



# SIGMAFAST 302

4 pages

January 2011  
Revision of April 2009

## DESCRIPTION

two component silicate zinc epoxy primer

## PRINCIPAL CHARACTERISTICS

- good anticorrosive properties
- fast curing
- fast handling
- topcoats must be unsaponifiable
- cures at temperatures down to -5°C
- reduced risk of mudcracking
- ACQPA approval 21251

## COLOURS AND GLOSS

bluegreen, grey - flat

## BASIC DATA AT 20°C

(1 g/cm<sup>3</sup> = 8.25 lb/US gal; 1 m<sup>2</sup>/l = 40.7 ft<sup>2</sup>/US gal)  
(data for mixed product)

Mass density

2.1 g/cm<sup>3</sup>

Volume solids

63 ± 2%

VOC (supplied)

max. 204 g/kg (Directive 1999/13/EC, SED)

max. 419 g/l (approx. 3.5 lb/gal)

Recommended dry film thickness

50 - 80 µm depending on system

Theoretical spreading rate

12.6 m<sup>2</sup>/l for 50 µm \*

Touch dry after

10 min. at 20°C

Overcoating interval

min. 40 min. \*

max. 1 year \*

(data for components)

Shelf life (cool and dry place)

at least 12 months

\* see additional data

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm
- substrate temperature must be at least 3°C above dew point
- during application and curing a substrate temperature down to -5°C is acceptable provided the substrate is dry and free from ice

## INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 80 : 20

- the temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity
- too much solvent results in reduced sag resistance and slower cure
- thinner should be added after mixing the components

Induction time

10 minutes

Pot life

4 hours at 20°C

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## AIRLESS SPRAY

Recommended thinner Thinner 21-06  
 Volume of thinner 5 - 15%, depending on required thickness and application conditions  
 Nozzle orifice approx. 0.38 - 0.53 mm (= 0.015 - 0.021 in)  
 Nozzle pressure 15 MPa (= approx. 150 bar; 2130 p.s.i.)

## AIR SPRAY

Recommended thinner Thinner 21-06  
 Volume of thinner 15 - 20%, depending on required thickness and application conditions  
 Nozzle orifice 1.6 mm  
 Nozzle pressure 0.3 - 0.6 MPa (= approx. 3 - 6 bar; 43 - 85 p.s.i.)

## BRUSH/ROLLER

Recommended thinner Thinner 21-06  
 Volume of thinner 0 - 5%

## CLEANING SOLVENT

Thinner 90-53

## SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

this is a solvent borne paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

## ADDITIONAL DATA

### Film thickness and spreading rate

theoretical spreading rate m <sup>2</sup> /l	12.6	7.9
dft in µm	50	80

### Overcoating table for SigmaFast 302 for dft up to 50 µm

with SigmaFast 213, SigmaCover 456, SigmaCover 435, SigmaCover 410

substrate temperature	0°C	10°C	20°C	30°C
minimum interval	45 min.	30 min.	25 min.	20 min.
maximum interval	12 months	12 months	12 months	12 months

– surface should be dry and free from any contamination

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## Overcoating table for SigmaFast 302 for dft up to 80 µm

substrate temperature	0°C	10°C	20°C	30°C
minimum interval	60 min.	50 min.	40 min.	35 min.
maximum interval	12 months	12 months	12 months	12 months

- surface should be dry and free from any contamination
- zinc rich primers can form zinc salts on the surface; preferably they should not be weathered for long periods before overcoating
- an interval of several months can be allowed under clean interior exposure conditions
- before overcoating any visible surface contamination must be removed by high pressure water cleaning, sandwashing, sweep blasting or mechanical cleaning

### Worldwide availability

Whilst it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

### REFERENCES

Explanation to product data sheets	see information sheet 1411
Safety indications	see information sheet 1430
Safety in confined spaces and health safety	
Explosion hazard - toxic hazard	see information sheet 1431
Safe working in confined spaces	see information sheet 1433
Directives for ventilation practice	see information sheet 1434
Cleaning of steel and removal of rust	see information sheet 1490

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## LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the Sigma Coatings products made by PPG Protective & Marine Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

PPG Protective & Marine Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. PPG Protective & Marine Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development.

This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

The English text of this document shall prevail over any translation thereof.

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216759	bluegreen	1000002200
218818	bluegreen	1000002100
267560	grey	5000002200