

SIGMARINE 24

3 pages

July 2009
Revision of May 2008

DESCRIPTION

modified zinc phosphate alkyd primer

PRINCIPAL CHARACTERISTICS

- economic general purpose maintenance and newbuilding primer
- suitable for use on superstructures and on steel surfaces not normally exposed to water immersion
- the adhesion of subsequent coats is not affected by long weathering periods of the primer
- should not be used over zinc primers, except when exposed to dry interior conditions
- to be recoated with conventional paint systems
- a thickness of 75 µm can be obtained by spray application in one operation by means of the crosscoat technique
- certificate for low flame spread: see sheet 1883

COLOURS AND GLOSS

yellow, brown (offwhite only on request) - flat

BASIC DATA AT 20°C

(1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)

| | |
|---------------------------------|--|
| Mass density | 1.4 g/cm ³ |
| Volume solids | 56 ± 2% |
| VOC (supplied) | max. 245 g/kg (Directive 1999/13/EC, SED) max. 343 g/l (approx. 2.9 lb/gal) |
| Recommended dry film thickness | 35 - 75 µm per coat |
| Theoretical spreading rate | 16 m ² /l for 35 µm; 7.5 m ² /l for 75 µm |
| Touch dry after | 3 hours at 5°C, 2 hours at 20°C |
| Overcoating interval | min. 48 hours at 5°C, 24 hours at 20°C max. unlimited |
| Shelf life (cool and dry place) | at least 12 months |

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm
- steel; power tool cleaned to min. ISO-St2
- shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2
- previous coat; dry and free from any contamination
- substrate temperature should be at least 3°C above dew point but not above 50°C

SYSTEM SPECIFICATION

marine system sheets: 3102, 3103, 3104, 3105, 3107

INSTRUCTIONS FOR USE

- stir well before use
- the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much solvent results in reduced sag resistance
- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)

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AIRLESS SPRAY

| | |
|---------------------|--|
| Recommended thinner | Thinner 20-05 |
| Volume of thinner | 0 - 3%, depending on required thickness and application conditions |
| Nozzle orifice | approx. 0.43 - 0.48 mm (= 0.017 - 0.019 in) |
| Nozzle pressure | 12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.) |

BRUSH/ROLLER

| | |
|---------------------|---------------|
| Recommended thinner | Thinner 20-05 |
| Volume of thinner | 0 - 2% |

CLEANING SOLVENT

Thinner 20-05

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

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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|--------|--------|------------|
| | PDS | 7135 |
| 136774 | brown | 2000002200 |
| 136775 | yellow | 3000002200 |