

SIGMARINE 28

3 pages

January 2013
Revision of July 2009

Description	one component quick drying high build multi purpose zinc phosphate primer
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> - on board maintenance primer for above water areas - easy application - quick drying - recoatable with various one and two component products - surface tolerant - good anticorrosive properties
COLOURS AND GLOSS	grey, redbrown, offwhite – flat
BASIC DATA AT 20°C	(1 g/cm ³ = 8.35 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal)
Mass density	1.5 g/cm ³
Volume solids	55 ± 2%
VOC (Supplied)	max. 266 g/kg (Directive 1999/13/EC, SED) max. 392 g/l (approx. 3.3 lb/gal)
Recommended dry film thickness	75 µm per coat
Theoretical spreading rate	7.3 m ² /l for 75 µm
Touch dry after	30 minutes at 20°C 2 hours at 5°C
Overcoating interval	min. 4 hours * max. unlimited
Shelf life (cool and dry place)	at least 12 months *See additional data
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> - steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm - steel; power tool cleaned to min. ISO-St2 - substrate temperature should be above 5°C and at least 3°C above dew point
SYSTEM SPECIFICATION	marine system sheets: 3102, 3103, 3104, 3105, 3107
INSTRUCTIONS FOR USE	<ul style="list-style-type: none"> - 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)
AIR SPRAY	
Recommended thinner	Thinner 21-06
Volume of thinner	5 - 10%, depending on required thickness and application conditions
Nozzle orifice	approx. 1.7 - 2.0 mm
Nozzle pressure	0.2 - 0.3 MPa (= approx. 2 - 3 bar; 29 - 44 p.s.i.)

SIGMARINE 28

January 2013

AIRLESS SPRAY

Recommended thinner Thinner 21-06
 Volume of thinner 0 - 5%, depending on required thickness and application conditions
 Nozzle orifice approx. 0.38 - 0.48 mm (= 0.015 - 0.019 in)
 Nozzle pressure 12 - 16 MPa (= approx. 120 - 160 bar; 1740 - 2321 p.s.i.)

BRUSH/ROLLER

Recommended thinner Thinner 21-06
 Volume of thinner 0 - 3%

CLEANING SOLVENT

Thinner 21-06

ADDITIONAL DATA

Overcoating table for Sigmarine 28 for dft up to 75 µm

Sigmarine 28, Sigmarine 48,
 Sigma Vikote 56 and
 Sigma Vikote 46

Sigma Vikote 18

SigmaCover 456 and
 SigmaDur 550

substrate temperature	5°C	20°C	35°C
minimum interval	8 hours	4 hours	3 hours
minimum interval	12 hours	4 hours	3 hours
minimum interval	16 hours	8 hours	4 hours
maximum interval	unlimited	unlimited	unlimited

– surface should be dry and free from any contamination

Worldwide availability

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, 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

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

SIGMARINE 28

January 2013

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	PDS	7117
195038	grey	5000002200
195037	offwhite	7001002200
210339	redbrown	2008002200