

SIGMACOVER ONE

DESCRIPTION

One component epoxy primer for on board maintenance

PRINCIPAL CHARACTERISTICS

- Easy to apply by brush and roller on topsides, decks and superstructures
- Recoatable with a wide range of one and two components conventional products
- Surface tolerant primer
- Fast drying
- Good anticorrosive properties

COLOR AND GLOSS LEVEL

- Gray
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	One
Mass density	1.3 kg/l (10.8 lb/US gal)
Volume solids	50 ± 2%
VOC (Supplied)	max. 441.0 g/l (approx. 3.7 lb/US gal)
Recommended dry film thickness	50 µm (2.0 mils) per coat
Theoretical spreading rate	10.0 m ² /l for 50 µm (401 ft ² /US gal for 2.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 4 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Atmospheric exposure conditions

- Steel; power tool cleaned to min. ISO-St2

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Substrate temperature

- Substrate temperature during application should not exceed 50°C (122°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point

SYSTEM SPECIFICATION

- SYSTEMS FOR SUPERSTRUCTURE AND DECK FITTINGS – SYSTEM SHEET 3104
- SYSTEMS FOR DECKS – SYSTEM SHEET 3103

INSTRUCTIONS FOR USE

- Stir well before use
- The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Brush/roller

- A roller suitable for epoxy application must be used

Recommended thinner

THINNER 21-06

Volume of thinner

0 – 3%

Cleaning solvent

THINNER 21-06

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
35 µm (1.4 mils)	14.3 m ² /l (573 ft ² /US gal)
50 µm (2.0 mils)	10.0 m ² /l (401 ft ² /US gal)
75 µm (3.0 mils)	6.7 m ² /l (267 ft ² /US gal)

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Overcoating interval for DFT up to 50 µm (2.0 mils)				
Overcoating with...	Interval	5°C (41°F)	20°C (68°F)	35°C (95°F)
itself, SIGMADUR ONE, SIGMARINE 48	Minimum	8 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited
SIGMACOVER 456, SIGMACOVER 350, SIGMADUR 550	Minimum	12 hours	6 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

Curing time for DFT up to 50 µm (2.0 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	5 hours
20°C (68°F)	2 hours

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	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
• SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
• DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434

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