

5 pages

June 2012  
Revision of April 2009

**PRINCIPAL CHARACTERISTICS**

- final coat in epoxy underwater anticorrosive systems
- epoxy tiecoat for use with Sigma antifoulings as specified
- excellent water resistance
- good abrasion and impact resistance

**BASIC DATA AT 20 °C** (1 g/cm<sup>3</sup> = 8.35 lb/US gal; 1 m<sup>2</sup>/l = 40.7 ft<sup>2</sup>/US gal)  
(data for mixed product)

Overcoating interval	min. 12 hours * max. 14 days *
Full cure after	14 days * at 20 °C (data for components)

**RECOMMENDED  
SUBSTRATE CONDITIONS  
AND TEMPERATURES**

- previous coat; dry and free from any contamination
- substrate temperature should be above -5°C during application and curing and at least 3°C above dew point and free from ice and any contamination
- during application and curing a substrate temperature down to -5°C is possible, but curing to hardness takes longer and complete resistance will be reached when temperature increases

**INSTRUCTIONS FOR USE** mixing ratio by volume: base to hardener 86 : 14



**SIGMA**  
COATINGS

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Pot life 18 hours at 20 °C \*  
\* see additional data

**AIR SPRAY**

Recommended thinner Thinner 91-92  
Volume of thinner 0 - 5%, depending on required thickness and application conditions  
Nozzle orifice 1.5 - 2 mm  
Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 44 - 58 p.s.i.)

**AIRLESS SPRAY**

Recommended thinner Thinner 91-92  
Volume of thinner 0 - 5%, depending on required thickness and application conditions  
Nozzle orifice approx. 0.53 - 0.58 mm (= 0.021 - 0.023 in)  
Nozzle pressure 12 - 15 MPa (= approx. 120 - 150 bar; 1740 - 2176 p.s.i.)

**BRUSH/ROLLER**

Recommended thinner Thinner 91-92  
Volume of thinner 0 - 5% if required

**CLEANING SOLVENT**

Thinner 90-53

**ADDITIONAL DATA****Film thickness and spreading rate**

theoretical spreading rate m <sup>2</sup> /l	8.2	6.0	4.9
dft in µm	75	100	125

Maximum dft when brushing: 75 µm

**Overcoating table for SigmaCover 525 for dft up to 125 µm**

substrate temperature	-5°C	5°C	10°C	20°C	30°C	40°C
minimum interval	20 hours	16 hours	14 hours	12 hours	10 hours	8 hours
maximum interval	18 days	18 days	18 days	14 days	7 days	3 days

with Sigma antifoulings

– surface should be dry and free from chalking and contamination

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**Curing****Curing table for dft up to 125 µm**

substrate temperature	full cure	Immersion
-5°C	--	120 hours
5°C	--	96 hours
10°C	21 days	48 hours
20°C	14 days	24 hours
30°C	7 days	18 hours

- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)

**Pot life (at application viscosity)**

15 °C	20 hours
20 °C	16 hours
30 °C	12 hours

**Worldwide availability**

Whilst it is always the aim of Sigma 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

**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

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

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	PDS	7902
231787	black	8000002200
238738	grey	5000002200
240750	grey	5000002150