

# SIGMADUR 568

(SIGMADUR 550 H)



4 pages

March 2014  
Revision of June 2012

**Description**

two component high solids high build polyurethane finish

**PRINCIPAL CHARACTERISTICS**

- excellent resistance to atmospheric exposure conditions
- good colour and gloss retention
- cures at temperatures down to -5°C
- resistant to splash of mineral and vegetable oils, paraffins, aliphatic petroleum products and mild chemicals
- can be recoated even after long atmospheric exposure
- good application properties by airless, brush and roller
- high film build-up to 150 µm for one coat
- can be applied direct to metal

**COLOURS AND GLOSS**

White and various other colours (see also Marine shade card) – gloss

**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)

Mass density

1.5 g/cm<sup>3</sup>

Volume solids

70 ± 2%

VOC (Supplied)

max. 220 g/kg (Directive 1999/13/EC, SED)

max. 330 g/l (approx. 2.8 lb/gal)

Recommended dry film thickness

50 - 150 µm depending on system

Overcoating interval

min. 8 hours \*

max. unlimited

Shelf life (cool and dry place)

at least 24 months

\* see additional data

**RECOMMENDED  
SUBSTRATE CONDITIONS  
AND TEMPERATURES**

- steel; blast cleaned to ISO-Sa2½
- previous coat; (alkyd, epoxy or polyurethane) dry and free from any contamination and sufficiently roughened if necessary
- during application and curing a substrate temperature down to -5°C is acceptable provided the substrate is dry and free from any contamination
- substrate temperature should be at least 3°C above dew point
- maximum relative humidity during application and curing is 85%
- premature exposure to early condensation and rain may cause colour and gloss change

**INSTRUCTIONS FOR USE**

mixing ratio by volume: base to hardener 87 : 13

- do not thin more than is required by appropriate application property
- too much solvent results in reduced sag resistance
- thinner should be added after mixing the components

Induction time

none

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### AIR SPRAY

Recommended thinner Thinner 21-06  
 Volume of thinner 10 - 15%, depending on required thickness and application conditions  
 Nozzle orifice 1.0 - 1.5 mm  
 Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 44 - 58 p.s.i.)

### AIRLESS SPRAY

Recommended thinner Thinner 21-06  
 Volume of thinner 0 - 10%, depending on required thickness and application conditions  
 Nozzle orifice approx. 0.44 - 0.49 mm (= 0.017 - 0.019 in)  
 Nozzle pressure 20 MPa (= approx. 200 bar; 2901 p.s.i.)

### BRUSH/ROLLER

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

### Film thickness and spreading rate

theoretical spreading rate m <sup>2</sup> /l	14	9.3	7.0	4.7
dft in µm	50	75	100	150

### Overcoating table for SigmaDur products

substrate temperature	-5°C	0°C	10°C	20°C	30°C	40°C
minimum interval	36 hours	24 hours	16 hours	8 hours	4 hours	3 hours
maximum interval	unlimited					

- surface should be dry and free from any contamination

### Curing

#### Curing table for dft up to 100 µm

substrate temperature	touch dry	dry to handle
-5°C	24 hours	40 hours
0°C	15 hours	30 hours
10°C	5 hours	20 hours
20°C	3 hours	12 hours
30°C	2 hours	6 hours
40°C	1 hour	3 hours

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

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**Pot life (at application viscosity)**

10°C	4 hours
20°C	2.5 hours
30°C	1.5 hour
40°C	1 hour

**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

**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
  - avoid at all times inhalation of aerosol spraymist

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