SIGMACOVER 480

A two sheet issue

January 2014

DESCRIPTION

two component chemical resistant multipurpose coating based on polyamide cured epoxy resins for a wide range of non immersed substrate types

PRINCIPAL CHARACTERISTICS

- general multi purpose coating
- can be used as primer and buildcoat and finish as part of a concrete flooring system; see sheet 1561
- good flow properties
- easy to apply by spray, roller and brush
- good water resistance
- resistant to splash and spillage of mild chemicals and solvents
- good abrasion and impact resistance
- can be given non skid properties by the addition of quartz sand added to the second coat whilst still wet
- easy to clean

COLOUR AND GLOSS

see Sigma P.C. colour card – gloss

BASIC DATA AT 20 °C

(for mixed product)

Mass density approx. 1.4g/cm³

Solids content approx. 53% by volume

Recommended dry film thickness 50 - 100 µm

Theoretical spreading rate 6.6 m²/ltr for a dft of 80 µm*

depending on the nature and condition of the substrate and the application method employed

Touch dry after approx. 3 hours

Overcoating interval min. 10 hours*

max. 3 months*

Full cure after 7 days

Shelf life (cool,dry place) 12 months

Flashpoint base 27 °C - hardener 28 °C

Available pack size 5 ltr, 20 ltr

*see additional data please turn
The information in this data sheet is to the best of our knowledge correct at the date of printing. The company reserves the right to modify data without notice. Any change in data will normally be followed by issue of a new data sheet. The user should check the date of printing and if more than 12 months have elapsed, then the data should only be used after checking with our nearest sales office to establish that they are still valid. Since conditions of application and service may be beyond our control, no liability can be accepted on the basis of this data.

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RECOMMENDED

INSTRUCTIONS FOR USE

- previous coat of epoxy primer or buildcoat within overcoating interval and free from any contamination
- if previous coat is exposed longer it should be roughened prior to application of next coat
- substrate temperature should be above 5 °C and at least 3 °C above the dew point

- mixing ratio: by volume; base to hardener 76 : 24
- the temperature of the mixed base and hardener should be above 15 °C, otherwise extra solvent may be required to obtain the correct application viscosity
- too much solvent will result in lower sag resistance and slower cure
- thinner should only be added after proper mixing of the base and hardener

Induction time at 20 °C 10 minutes
Potlife at 20 °C 8 hours*

METHOD OF APPLICATION

AIRLESS SPRAY
Recommended thinner 91-92 (flashpoint 20 °C)
Volume of thinner 5 - 10%
Nozzle orifice approx. 0.48 mm (0.019 inch)
Nozzle pressure 150 bar (approx. 2100 p.s.i.)

AIR SPRAY
Recommended thinner 91-92 (flashpoint 20 °C)
Volume of thinner 5 - 10%
Nozzle orifice 1.5 - 3.0 mm
Nozzle pressure 3 - 4 bar (approx. 43 - 57 p.s.i.)

BRUSH AND ROLLER
Recommended thinner 91-92 (flashpoint 20 °C)
Volume of thinner 0 - 5%

CLEANING SOLVENT
90-53 (flashpoint 30 °C)

see sheet two
SAFETY PRECAUTIONS

see safety sheet 1570 for information on LEL and TLV values

ADDITIONAL DATA

Film thickness and spreading rate

<table>
<thead>
<tr>
<th>Dry film thickness in microns (µm)</th>
<th>50</th>
<th>80</th>
<th>100</th>
</tr>
</thead>
<tbody>
<tr>
<td>Theoretical spreading rate (m²/l)</td>
<td>10.6</td>
<td>6.6</td>
<td>5.3</td>
</tr>
</tbody>
</table>

Maximum dft without sagging with airless spray: 160 µm
Minimum dft for closed film with airless spray: 60 µm
Maximum dft for brush application: 70 µm

Note: maximum dft is for overlap areas only

Overcoating table with epoxy paint

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>20 °C</th>
<th>30 °C</th>
<th>40 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum interval</td>
<td>8 hours</td>
<td>6 hours</td>
<td>5 hours</td>
</tr>
<tr>
<td>Maximum interval</td>
<td>3 months</td>
<td>2 months</td>
<td>1 month</td>
</tr>
</tbody>
</table>

substrate should be free from chalking and contamination

Curing table

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>Dry to handle</th>
<th>Full cure</th>
</tr>
</thead>
<tbody>
<tr>
<td>20 °C</td>
<td>18 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>30 °C</td>
<td>12 hours</td>
<td>5 days</td>
</tr>
<tr>
<td>40 °C</td>
<td>8 hours</td>
<td>3 days</td>
</tr>
</tbody>
</table>

Potlife at application viscosity; these figures are valid for approx. 5 ltr

<table>
<thead>
<tr>
<th>Paint temperature</th>
<th>Pot life</th>
</tr>
</thead>
<tbody>
<tr>
<td>20 °C</td>
<td>8 hours</td>
</tr>
<tr>
<td>30 °C</td>
<td>6 hours</td>
</tr>
<tr>
<td>40 °C</td>
<td>4 hours</td>
</tr>
</tbody>
</table>

REFERENCES

explanation to product data sheets on information sheet 1551