two component polyamide cured epoxy primer for use over a wide range of substrate types

- good adhesion to steel and galvanized steel
- good adhesion to non ferrous metals
- good adhesion to various plastics and wood
- good adhesion to cement based building materials
- good wetting properties
- excellent water resistance
- good chemical resistance
- can be overcoated with alkyd, epoxy and polyurethane
- good abrasion and impact resistance

white, red-brown – eggshell

Mass density approx. 1.4g/cm³
Solids content approx. 53% by volume
Recommended dry film thickness 35 µm
Theoretical spreading rate 15.1 m²/ltr for 35 µm*
depending on the nature and condition of the substrate and the application method employed
Touch dry after approx. 30 minutes
Overcoating interval min. 16 hours*
max. 10 days*
Full cure after 7 days*
Shelf life (cool,dry place) 12 months
Flashpoint base 17 °C - hardener 26 °C
Available pack size 5 ltr, 20 ltr
*see additional data
RECOMMENDED SUBSTRATE CONDITIONS
- substrate must be dry and free from any contamination
- steel: blast cleaned (dry or wet), to ISO-Sa2½
- shop primed steel: pretreated according to SPSS Pt3
- concrete: remove all laitance and loose material
- must not be applied at temperatures below 5 °C
- substrate temperature should be at least 3 °C above the dew point

INSTRUCTIONS FOR USE
- mixing ratio: by volume; base to hardener 75 : 25
- 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 none
Potlife at 20 °C 10 hours*

METHOD OF APPLICATION
AIRLESS SPRAY
Recommended thinner 91-92 (flashpoint 20 °C)
Volume of thinner 10 - 20%
Nozzle orifice approx. 0.33 mm (0.013 inch)
Nozzle pressure 150 bar (approx. 2100 p.s.i.)

AIR SPRAY
Recommended thinner 91-92 (flashpoint 20 °C)
Volume of thinner 10 - 20%
Nozzle orifice 1.5 - 2.0 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 5 - 10%

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>20</th>
<th>35</th>
</tr>
</thead>
<tbody>
<tr>
<td>Theoretical spreading rate (m²/l)</td>
<td>26.5</td>
<td>15.1</td>
</tr>
</tbody>
</table>

Maximum dft without sagging with airless spray: 50 µm
Minimum dft for closed film with airless spray: 20 µm
Maximum dft for brush application: 35 µm

Note: maximum dft is for overlap areas only

Overcoating table with epoxy paints

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>10 °C</th>
<th>15 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>minimum interval</td>
<td>48 hours</td>
<td>24 hours</td>
<td>16 hours</td>
<td>8 hours</td>
</tr>
<tr>
<td>maximum interval</td>
<td>21 days</td>
<td>14 days</td>
<td>10 days</td>
<td>7 days</td>
</tr>
</tbody>
</table>

Substrate should be free from chalking and contamination

Curing table

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>Touch dry</th>
<th>Full cure</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 °C</td>
<td>120 minutes</td>
<td>21 days</td>
</tr>
<tr>
<td>10 °C</td>
<td>60 minutes</td>
<td>14 days</td>
</tr>
<tr>
<td>15 °C</td>
<td>45 minutes</td>
<td>10 days</td>
</tr>
<tr>
<td>20 °C</td>
<td>30 minutes</td>
<td>7 days</td>
</tr>
<tr>
<td>30 °C</td>
<td>20 minutes</td>
<td>5 days</td>
</tr>
</tbody>
</table>

Ensure adequate ventilation during application and curing

please turn
SIGMACOVER 211

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>15 °C</td>
<td>12 hours</td>
</tr>
<tr>
<td>20 °C</td>
<td>9 hours</td>
</tr>
<tr>
<td>25 °C</td>
<td>7 hours</td>
</tr>
<tr>
<td>30 °C</td>
<td>5 hours</td>
</tr>
<tr>
<td>35 °C</td>
<td>3 hours</td>
</tr>
</tbody>
</table>

REFERENCES

explanation to product data sheets on information sheet 1551