SIGMA PRIMAPOXY TOP

A two sheet issue

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*

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
SIGMA PRIMAPOXY TOP

January 2016

RECOMMENDED SUBSTRATE CONDITIONS
- 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

INSTRUCTIONS FOR USE
- 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