SIGMACOVER™ 280

DESCRIPTION

Universal epoxy anticorrosive primer, based upon pure epoxy technology

PRINCIPAL CHARACTERISTICS

- General-purpose epoxy primer in protective coating systems for steel and non-ferrous metals
- Excellent adhesion to steel, shop primer, galvanized steel and non-ferrous metals
- Suitable as sealer or tie-coat at DFT 25 - 40 µm (1 - 1.6 mils)
- Suitable for immersion service
- Cures at temperatures down to 5°C (41°F)
- Suitable for touching up of weld seams and damages of epoxy coatings during construction
- Suitable on wet blast cleaned substrates (damp or dry)
- Compatible with well-designed cathodic protection systems

COLOR AND GLOSS LEVEL

- Yellow/green (redbrown on request)
- Low sheen

Note: The addition of a UV stable topcoat should be considered when using epoxy coatings in cosmetic areas

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.3 kg/l (11.0 lb/US gal)
Volume solids	57 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 327.0 g/kg UK PG 6/23(92) Appendix 3: max. 432.0 g/l (approx. 3.6 lb/US gal) China GB 30981-2020 (tested) 336.0 g/l (approx. 2.8 lb/gal)
Recommended dry film thickness	50 - 100 µm (2.0 - 4.0 mils) depending on system
Theoretical spreading rate	11.4 m^2/l for 50 µm (457 ft^2/US gal for 2.0 mils) 5.7 m^2/l for 100 µm (229 ft^2/US gal for 4.0 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 2 hours
Full cure after	7 days
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:
- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Apply this product to the specified thickness as soon as possible after the surface is prepared

Atmospheric exposure conditions

- Steel blast cleaned to ISO-Sa2½, blasting profile 30 - 75 µm (1.2 – 3.0 mils) or according to ISO-St3
- Shop primed steel; pretreated to SPSS-Pt3

Galvanized steel

- The surface must be properly prepared, dry, clean and free of any contamination
- The surface should be sufficiently roughened by sweep blasting to achieve a uniform matt appearance
- Sweep blast in accordance with the SSPC SP-16 guidelines

Stainless steel

- The surface must be properly prepared, dry, clean and free of any contamination
- The surface should be sufficiently roughened by sweep blasting with inert non-metallic abrasives
- Sweep blast in accordance with the SSPC SP-16 guidelines

Thermal Sprayed Metallization (TSM)

- Surface must be dry and free from any contamination
- The mist coat / full coat technique is required. See mist coat thinning recommendation in the Instructions For Use part below

Concrete / Masonry

- Dried for at least 28 days in good ventilation conditions
- Moisture content should not exceed 4.5%
- Concrete must be sound, dry, free from laitance and any contamination
- Surface should be sufficiently roughened

Immersion exposure

- Steel or steel with not approved zinc silicate shop primer; blast cleaned (dry or wet) to ISO-Sa2½, blasting profile 30 - 75 µm (1.2 – 3.0 mils)
- Steel with approved zinc silicate shop primer; weld seams and areas of damaged shop primer or breakdown should be blast cleaned to ISO-Sa2½, blasting profile 30 - 75 µm (1.2 – 3.0 mils) or power tool cleaned to SPSS-Pt3
- Existing pipelines may have to be cleaned first by scraper pigs and solvents

Substrate temperature and application conditions

- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 85%

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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 80:20 (4:1)

- The temperature of the mixed base and hardener should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

Induction time

None

Pot life

8 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.5 – 2.0 mm (approx. 0.060 – 0.079 in)

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 - 10%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.46 mm (0.018 in)

Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

Note: Volume of thinner up to 30% for sealer or tie-coat application at DFT range 25 - 40 µm (1 - 1.6 mils)

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Brush/roller

Recommended thinner
No extra thinner is necessary

Volume of thinner
Up to 5% THINNER 91-92 can be added if desired

Cleaning solvent
THINNER 90-53

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
50 µm (2.0 mils)	11.4 m^2/l (457 ft^2/US gal)
75 µm (3.0 mils)	7.6 m^2/l (305 ft^2/US gal)
100 µm (4.0 mils)	5.7 m^2/l (229 ft^2/US gal)

Note: Maximum DFT when brushing: 50 µm (2.0 mils)

Overcoating interval for DFT up to 100 µm (4.0 mils)						
Overcoating with...	**Interval**	**5°C (41°F)**	**10°C (50°F)**	**20°C (68°F)**	**30°C (86°F)**	**40°C (104°F)**
itself and various two-pack epoxy coatings	Minimum	12 hours	6 hours	2 hours	1 hour	30 minutes
	Maximum	3 months	3 months	3 months	2 months	2 months
polyurethane topcoat	Minimum	36 hours	16 hours	6 hours	4 hours	3 hours
	Maximum	3 months	3 months	3 months	2 months	2 months

Notes:
- Surface should be dry and free from any contamination
- Glossy finishes require a corresponding undercoat

Curing time for DFT up to 100 µm (4.0 mils)			
Substrate temperature	**Dry to touch**	**Dry to handle**	**Full cure**
5°C (41°F)	8 hours	13 hours	21 days
10°C (50°F)	4 hours	6 hours	14 days
20°C (68°F)	2 hours	2.5 hours	7 days
30°C (86°F)	1 hour	1.5 hours	5 days
40°C (104°F)	45 minutes	1 hour	3 days

Note: Adequate ventilation must be maintained during application and curing

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Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
15°C (59°F)	10 hours
20°C (68°F)	8 hours
30°C (86°F)	5 hours
35°C (95°F)	4 hours

SAFETY PRECAUTIONS

- See Safety Data Sheet and product label for complete safety and precaution requirements
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

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 — INFORMATION SHEET — 1411

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