SIGMARINE 28

(SIGMARINE MULTIPRIMER)

3 pages

September 2005 Revision of October 2004

DESCRIPTION

one component quick drying high build multi purpose primer

PRINCIPAL CHARACTERISTICS — on board maintenance primer for above water areas

 easy application quick drying

recoatable with various one and two component products

surface tolerant

good anticorrosive properties

COLOURS AND GLOSS

grey, redbrown, offwhite - flat

BASIC DATA AT 20°C

 $(1 \text{ g/cm}^3 = 8.25 \text{ lb/US gal}; 1 \text{ m}^2/\text{I} = 40.7 \text{ ft}^2/\text{US gal})$

1.5 g/cm³ Mass density Volume solids $55 \pm 2\%$

VOC (supplied) max. 266 g/kg (Directive 1999/13/EC, SED)

max. 392 g/l (approx. 3.3 lb/gal)

Recommended dry film

thickness

75 µm per coat

Theoretical spreading rate $7.3 \text{ m}^2/\text{I} \text{ for } 75 \text{ }\mu\text{m}$

Touch dry after 30 min. at 20°C, 2 hours at 5°C

Overcoating interval min. 4 hours *

max, unlimited

Shelf life (cool and dry place)

Flash point

at least 12 months

28°C

RECOMMENDED SUBSTRATE CONDITIONS **AND TEMPERATURES**

 steel; blast cleaned to ISO-Sa2½ or power tool cleaned to min. ISO-St2 overlap of the primer onto excisting aged coatings (alkyd, acrylics or chlorinated rubber) by 2-3 cm

substrate temperature should be above 5°C and at least 3°C above dew

point

SYSTEM SPECIFICATION

marine

system sheets 3102, 3103, 3104, 3105, 3107

INSTRUCTIONS FOR USE

stir well before use

- the temperature of the paint should preferably be above 15°C, otherwise extra thinner may be required to obtain application viscosity

- too much solvent results in reduced sag resistance

adequate ventilation must be maintained during application and curing

(please refer to sheet 1433 and 1434)



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AIRLESS SPRAY

Recommended thinner

Volume of thinner 0 - 5%, depending on required thickness and application conditions

Nozzle orifice approx. 0.38 - 0.48 mm (= 0.015 - 0.019 in)

Nozzle pressure 12 - 16 MPa (= approx. 120 - 160 bar; 1700 - 2270 p.s.i.)

Sigma thinner 21-06

AIR SPRAY

Recommended thinner Sigma thinner 21-06

Volume of thinner 5 - 10%, depending on required thickness and application conditions

Nozzle orifice approx. 1.7 - 2.0 mm

Nozzle pressure 0.2 - 0.3 MPa (= approx. 2 - 3 bar; 28 - 43 p.s.i.)

BRUSH/ROLLER

Recommended thinner Sigma thinner 21-06

Volume of thinner 0 - 3%

CLEANING SOLVENT Sigma thinner 21-06

SAFETY PRECAUTIONS for paint and recommended thinners see safety sheets 1430, 1431 and

relevant material safety data sheets

this is a solvent based 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

ADDITIONAL DATA

Overcoating table

paint type:

Sigmarine 28

Sigmarine 48

Sigma Vikote 56 and Sigma Vikote 46 Sigma Vikote 18

SigmaCover 456

SigmaDur 550

Uvercoating to	adie		
substrate temperature	5°C	20°C	35°C
minimum interval	8 hours	4 hours	3 hours
minimum interval	8 hours	4 hours	3 hours
minimum interval	8 hours	4 hours	3 hours
minimum interval	12 hours	4 hours	3 hours
minimum interval	16 hours	8 hours	4 hours
minimum interval	16 hours	8 hours	4 hours
maximum interval	unlimited, provided that the surface is dry and cleaned from any contamination		



DATA

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see information sheet 1430

Worldwide availability Whilst it is always the aim of Sigma Coatings to supply the same product on

a worldwide basis, 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

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

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the products made by Sigma Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

Sigma Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Sigma Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

The English text of this document shall prevail over any translation thereof.

DS 7117

 195038 grey
 5000002200

 195037 offwhite
 7001002200

 210339 redbrown
 2008002200

