

# SIGMACOVER 1000

(SIGMACOVER TCP COMPOUND)

4 pages

September 2007  
Revision of August 2007

## DESCRIPTION

two component solvent free amine cured epoxy coating

## PRINCIPAL CHARACTERISTICS

- one coat protection for steel structures with excellent corrosion resistance
- can be exposed to water immersion shortly after application
- can be applied at a dft up to 1000 µm by heavy duty single feed airless spray equipment (60:1)
- suitable for immersed and non immersed areas
- one coat heavy duty deck system
- reduced explosion risk and fire hazard
- good visibility due to light colour
- resistant to well designed cathodic protection

## COLOURS AND GLOSS

grey (other colours on request) - gloss

## BASIC DATA AT 20°C

(1 g/cm<sup>3</sup> = 8.25 lb/US gal; 1 m<sup>2</sup>/l = 40.7 ft<sup>2</sup>/US gal)  
(data for mixed product)

Mass density	1.4 g/cm <sup>3</sup>
Volume solids	100%
VOC (supplied)	max. 62 g/kg (Directive 1999/13/EC, SED) max. 86 g/l (approx. 0.7 lb/gal) see information sheet 1411
Recommended dry film thickness	min. 500 - 1000 µm depending on system
Theoretical spreading rate	2.0 m <sup>2</sup> /l for 500 µm
Touch dry after	12 hours *
Overcoating interval	min. 20 hours * max. 20 days *
Full cure after	5 days *

(data for components)

Shelf life (cool and dry place)

at least 12 months  
\* see additional data

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- **for immersion exposure:**
  - steel; blast cleaned to ISO-Sa2½
  - shop primed steel; blast cleaned to ISO-Sa2½, blasting profile; (R<sub>z</sub>) 50 - 100 µm
- **for atmospheric exposure conditions:**
  - steel; blast cleaned to ISO-Sa2½, blasting profile (R<sub>z</sub>) 50 - 100 µm
- substrate temperature should be above 5°C and at least 3°C above dew point

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## INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 80 : 20

- when mixing the temperature of the base and hardener should be at least 20°C
- at lower temperature the viscosity will be too high for spray application
- no thinner should be added

Induction time

none

Pot life

1 hour at 20°C \*

\* see additional data

## AIRLESS SPRAY

- heavy duty single feed airless spray equipment preferably 60:1 pump ratio and suitable high pressure hoses
- in-line heating or insulated hoses may be necessary to avoid cooling down of paint in hoses at low air temperature
- application with 45:1 airless spray equipment is possible provided in-line heated high pressure hoses are used
- in case of using 45:1 airless spray equipment the paint must be heated to approx. 30°C in order to obtain the right application viscosity
- length of hoses should be as short as possible

Recommended thinner

no thinner should be added

Nozzle orifice

approx. 0.53 mm (= 0.021 in)

Nozzle pressure

at 20°C (paint temperature) min. 28 MPa (= approx. 280 bar; 4000 p.s.i.)  
at 30°C (paint temperature) min. 22 MPa (= approx. 220 bar; 3000 p.s.i.)

## BRUSH

for stripe coating and spot repair only

Recommended thinner

no thinner should be added

## CLEANING SOLVENT

Sigma thinner 90-83 (preferred) or Sigma thinner 90-53

- all application equipment must be cleaned immediately after use
- paint inside the spraying equipment must be removed before the pot life time has been expired

## SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

although this is a solvent free paint, care should be taken to avoid inhalation of spray mist as well as contact between the wet paint and exposed skin or eyes

- no solvent present; however, spray mist is not harmless, a fresh air mask should be used during spraying
- ventilation should be provided in confined spaces to maintain good visibility

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## ADDITIONAL DATA

### *Film thickness and spreading rate*

theoretical spreading rate m <sup>2</sup> /l	2.0	1.0
dft in µm	500	1000

min. dft for closed film with airless spray: 400 µm  
 max. dft when brushing: 150 µm

### **measuring wet film thickness**

- a difference is often obtained between the measured apparent wft and the real applied wft
- this is due to the thixotropy and the surface tension of the paint which retards the release of air trapped in the paint film for some time
- a practical recommendation is to apply a wft which is equal to the specified dft plus 60 µm

### **measuring dry film thickness**

- because of low initial hardness the dft cannot be measured within some days due to the penetration of the measuring device into the soft paint film
- the dft should be measured using a calibration foil of known thickness placed in between the coating and the measuring device

### *Overcoating table (spot repair and stripe coating)*

substrate temperature	5°C	10°C	20°C	30°C	40°C
minimum interval	3 days	48 hours	20 hours	16 hours	12 hours
maximum interval	28 days	28 days	20 days	14 days	7 days

- surface should be dry and free from any contamination

### *Curing table*

substrate temperature	touch dry	dry to handle	full cure
5°C	48 hours	3 days	14 days
10°C	24 hours	2 days	10 days
20°C	12 hours	24 hours	5 days
30°C	8 hours	16 hours	3 days
40°C	6 hours	12 hours	2 days

- early exposure to sea water is permitted after the initial cure of 3 hours at 20°C

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**Pot life (at application viscosity)**

20°C	60 min.
30°C	45 min.

- due to exothermic reaction, temperature during and after mixing may increase

**Worldwide availability**

Whilst it is always the aim of SigmaKalon Marine & Protective 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	see information sheet 1430
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 Sigma Coatings products made by SigmaKalon Marine & Protective 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.

SigmaKalon Marine & Protective 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. SigmaKalon Marine & Protective 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.

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