

SIGMACOVER 515 LT

(SIGMA HULLRITE LT)

4 pages

December 2005
Revision of September 2005**DESCRIPTION**

two component polyamine cured epoxy anticorrosive tiecoat

PRINCIPAL CHARACTERISTICS

- final coat in epoxy underwater anticorrosive systems
- epoxy anticorrosive with excellent adhesion for antifoulings
- good low temperature curing
- excellent water resistance
- good abrasion and chemical resistance

COLOURS AND GLOSS

black, grey - flat

BASIC DATA AT 10°C(1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)
(data for mixed product)

Mass density

1.4 g/cm³

Volume solids

70 ± 2%

VOC (supplied)

max. 267 g/kg (Directive 1999/13/EC, SED)
max. 372 g/l (approx. 3.1 lb/gal)Recommended dry film
thickness

75 - 150 µm

Theoretical spreading rate

9.3 m²/l for 75 µm, 4.7 m²/l for 150 µm

Touch dry after

6 hours

Overcoating interval

min. see tables *
max. see tables *

Full cure after

7 days *

(data for components)

Shelf life (cool and dry place)

at least 12 months

Flash point

base 35°C, hardener 32°C

* see additional data

**RECOMMENDED
SUBSTRATE CONDITIONS
AND TEMPERATURES**

- previous coat; dry and free from any contamination
- substrate temperature should be between -10°C up to 15°C during application and curing and at least 3°C above dew point and free from ice and any contamination
- during application and curing a substrate temperature down to -10°C is possible, but curing to hardness takes longer and complete resistance will be reached when temperature increases
- maximum relative humidity during application and curing is 85%

SYSTEM SPECIFICATION

marine

system sheet 3101

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INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 86 : 14

- the temperature of the mixed base and hardener should preferably be above 5°C, otherwise extra solvent may be required to obtain application viscosity
- too much solvent results in reduced sag resistance and slower cure
- thinner should be added after mixing the components

Induction time

15 minutes for a substrate temperature of 5°C
25 minutes for a substrate temperature of -5°C

Pot life

6 hours at 10°C *

* see additional data

AIRLESS SPRAY

Recommended thinner

Sigma thinner 91-92

Volume of thinner

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

Nozzle orifice

approx. 0.53 - 0.58 mm (= 0.021 - 0.023 in)

Nozzle pressure

12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.)

AIR SPRAY

Recommended thinner

Sigma thinner 91-92

Volume of thinner

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

Nozzle orifice

1.5 - 2 mm

Nozzle pressure

0.3 - 0.4 MPa (= approx. 3 - 4 bar, 43 - 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner

Sigma thinner 91-92

Volume of thinner

0 - 5% if required

CLEANING SOLVENT

Sigma thinner 90-53

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

Film thickness and spreading rate

theoretical spreading rate m ² /l	9.3	7	4.7
dft in µm	75	100	150

max. dft when brushing:

75 µm

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Sigma AlphaGen 20 Series

Overcoating table for SigmaCover 515 LT at 150 µm with antifoulings

substrate temperature	-5°C	0°C	5°C	10°C
minimum interval	24 hours *	24 hours *	24 hours	12 hours
maximum interval	3 days	2 days	2 days	1 day

– surface should be dry and free from any contamination

* minimum interval for the antifouling at 100 µm dft

Note

for inquiries concerning other antifoulings, please contact your nearest Sigma Coatings sales office

Curing table for SigmaCover 515 LT at 150 µm

substrate temperature	minimum curing time before exposure to seawater	full cure
-5°C	60 hours	--
0°C	48 hours	15 days
5°C	36 hours	9 days
10°C	24 hours	7 days

– adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)

Pot life (at application viscosity)

5°C	10 hours
10°C	6 hours

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	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

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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	7481
223502 black	8000002200
223501 grey	5000002200