

SIGMALINE 2000**(SIGMARITE EPH)**

4 pages

May 2006
Revision of February 2006**DESCRIPTION**

two component solvent free amine cured phenolic epoxy coating

PRINCIPAL CHARACTERISTICS

- one coat system direct to metal for pipe externals
- suitable for e.g. bell holing jobs
- resistant to well designed cathodic protection
- glossy and smooth appearance
- can be applied by heavy duty twin feed hot airless spray equipment
- can be applied at a substrate temperature of 90°C
- reduced explosion risk and fire hazard
- approved to Saudi Aramco APCS 113

COLOURS AND GLOSS

redbrown - gloss

BASIC DATA AT 20°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

100%

VOC (supplied)

max. 108 g/kg (Directive 1999/13/EC, SED)

max. 146 g/l (approx. 1.2 lb/gal)

see information sheet 1411

Recommended dry film
thickness

600 - 1500 µm depending on system

Theoretical spreading rate

1.7 m²/l for 600 µm *

Touch dry after

6 hours

Overcoating interval

min. 24 hours *

max. 2 months *

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**

- steel; blast cleaned to a minimum of ISO-Sa2½,
blasting profile (R_z) 50 - 100 µm
- substrate temperature should be above 5°C and at least 3°C above dew
point during application and curing



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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 with a minimum of 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
- 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/ROLLER

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

- 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 ² /l	1.7	1.0	0.7
dft in µm	600	1000	1500

max. dft when brushing: 150 µm

measuring wet film thickness

- a deviation 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
- 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 for some days (depending on ambient temperature) after application due to the penetration of the measuring device into the 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 with SigmaLine 2000 (spot repair and stripe coating)

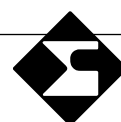
substrate temperature	5°C	10°C	20°C	30°C
minimum interval	80 hours	36 hours	24 hours	12 hours
maximum interval	3 months	3 months	2 months	1 month

- surface should be dry and free from any contamination

Curing table

substrate temperature	dry to handle	full cure
5°C	60 hours	15 days
10°C	30 hours	7 days
20°C	16 hours	5 days
30°C	10 hours	3 days

- although the paint is solvent free adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)



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Pot life (at application viscosity)

20°C	60 min.
30°C	45 min.
40°C	20 min. *

* it is recommended to use plural airless equipment due to the short potlife

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

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

LIMITATION OF LIABILITY

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

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