

SIGMALINE 855 REPAIR

(SIGMALINING 7655 REPAIR)

2 pages

November 2005
Revision of December 2004

DESCRIPTION	two component solvent free brushable polyurethane repair coating
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – repair coating for SigmaLine 855 – fast curing – easy field weld repair – excellent corrosion resistance – good abrasion and impact resistance – good water resistance
COLOURS AND GLOSS	blue, grey, redbrown - gloss
BASIC DATA AT 20°C	(1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) (data for mixed product)
Mass density	1.7 g/cm ³
Volume solids	93 ±2%
VOC (supplied)	max. 1 g/kg (Directive 1999/13/EC, SED) max. 2 g/l (approx. 0.0 lb/gal) see information sheet 1411
Recommended dry film thickness	500 µm in one coat
Theoretical spreading rate	1.9 m ² /l for 500 µm
Touch dry after	2 - 3 hours
Full cure after	5 days
	(data for components)
Shelf life (cool and dry place)	at least 6 months
Flash point	base and hardener above 65°C
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> – steel; blast cleaned to ISO-Sa2½ – SigmaLine 855; after 16 hours curing proper pretreatment is required – substrate temperature should be above 15°C and at least 3°C above dew point, lower temperatures will reduce flow properties
INSTRUCTIONS FOR USE	<p>mixing ratio by volume: base to hardener 73 : 27</p> <ul style="list-style-type: none"> – application by brush – no thinner should be added
Induction time	none
Pot life	50 min. at 20°C, 30 min. at 40°C
CLEANING SOLVENT	Sigma thinner 91-88

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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
- protective clothing and spray masks should be provided to avoid any dermatitic or toxic hazard
- if any symptoms arise immediately seek medical advice

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
Cleaning of steel and removal of rust	see information sheet 1490

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	7655RP
175148 blue	100000 set 2 ltr
235697 redbrown	200800 set 2 ltr
235701 grey	500000 set 2 ltr