

SIGMATHERM 175**(SIGMARINE ALUMINIUM HR)**

3 pages

September 2005
Revision of January 2003**DESCRIPTION**

modified alkyd aluminium finish

PRINCIPAL CHARACTERISTICS

- a high quality aluminium paint with an extensive range of applications for exposure in atmospheric conditions
- high brilliancy
- spray application improves the appearance
- a minimum drying time of 3 days should be allowed before exposure to heat
- heat resistant up to 175°C

COLOURS AND GLOSS

aluminium - gloss

BASIC DATA AT 20°C(1 g/cm³ = 8.25 lb/US gal; 1 m²/l = 40.7 ft²/US gal)

Mass density

1.0 g/cm³

Volume solids

47 ± 2%

VOC (supplied)

max. 411 g/kg (Directive 1999/13/EC, SED)

max. 417 g/l (approx. 3.5 lb/gal)

Recommended dry film thickness

25 µm per coat

Theoretical spreading rate

18.8 m²/l for 25 µm

Touch dry after

3 hours at 5 - 10°C, 1 hour at 20°C

Overcoating interval

min. 36 hours at 5 - 10°C, 16 hours at 20°C

max. unlimited

Shelf life (cool and dry place)

at least 12 months,
longer storage period may affect the brilliancy

Flash point

38°C

RECOMMENDED**SUBSTRATE CONDITIONS AND TEMPERATURES**

- previous coat; dry and free from any contamination
- substrate temperature should be at least 3°C above dew point

SYSTEM SPECIFICATION

for heat resistant systems - see system sheet 3140

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 no thinner should be added
 Nozzle orifice approx. 0.33 - 0.38 mm (= 0.013 - 0.015 in)
 Nozzle pressure 12 - 15 MPa (= approx. 120 - 150 bar; 1700 - 2130 p.s.i.)

AIR SPRAY

Recommended thinner Sigma thinner 20-05
 Volume of thinner 0 - 3%, depending on required thickness and application conditions
 Nozzle orifice 1.8 - 2 mm
 Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar, 43 - 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner no thinner should be added

CLEANING SOLVENT

Sigma thinner 20-05

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

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.

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