

SIGMAZINC™ 11

DESCRIPTION

One-component, inorganic zinc silicate coating

PRINCIPAL CHARACTERISTICS

- Heavy duty primer that protects with just a single coat
- Excellent corrosion protection properties
- Dry heat resistance up to 400°C (750°F)

COLOR AND GLOSS LEVEL

- Gray
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	One
Mass density	2.1 kg/l (17.5 lb/US gal)
Volume solids	58 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 263.0 g/kg UK PG 6/23(92) Appendix 3: max. 559.0 g/l (approx. 4.7 lb/US gal)
Recommended dry film thickness	65 µm (2.6 mils)
Theoretical spreading rate	8.9 m ² /l for 65 µm (358 ft ² /US gal for 2.6 mils)
Dry to touch	7 minutes
Overcoating Interval	Minimum: 16 hours See overcoating tables
Shelf life	At least 9 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Steel

- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile 35 – 65 µm (1.4 – 2.6 mils)
- Previous coat of approved coating must be dry and free from any contamination

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Substrate temperature and application conditions

- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
 - Relative humidity during application and curing should be between 50% and 95%
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INSTRUCTIONS FOR USE

- Stir well before use
 - The temperature of the paint should preferably be above 15°C (59°F), otherwise extra thinner may be required to obtain application viscosity
 - Adding too much thinner results in reduced sag resistance
 - Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
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Air spray**Recommended thinner**

THINNER 21-06

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

1.5 – 3.0 mm (approx. 0.060 – 0.110 in)

Nozzle pressure0.2 - 0.3 MPa (approx. 2 - 3 bar; 29 - 44 p.s.i.)

Airless spray**Recommended thinner**

THINNER 21-06

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.43 mm (0.017 in)

Nozzle pressure10.0 - 15.0 MPa (approx. 100 - 150 bar; 1451 - 2176 p.s.i.)

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Brush/roller**Recommended thinner**

THINNER 21-06

Volume of thinner

0 – 3%

Cleaning solvent

THINNER 21-06

ADDITIONAL DATA

Overcoating interval for DFT up to 65 µm (2.6 mils)			
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)
approved topcoats	Minimum	24 hours	16 hours
	Maximum	Extended	Extended

Notes:

- Zinc containing primers can form zinc salts on the surface; preferably they should not be weathered for long periods before overcoating
- An interval of several months can be allowed under clean interior exposure conditions
- In clean exterior conditions, a maximum interval of 14 days can be tolerated, but in industrial or marine conditions this interval should be reduced to the practical minimum
- Before overcoating visible surface contamination must be removed by high-pressure water cleaning, sweep blasting or mechanical cleaning

Curing time for DFT up to 65 µm (2.6 mils)		
Substrate temperature	Dry to touch	Dry to handle
10°C (50°F)	10 minutes	30 minutes
20°C (68°F)	7 minutes	20 minutes

Notes:

- Drying times are dependent on air and surface temperatures as well as film thickness, ventilation and relative humidity
- Times are proportionally shorter at higher temperature and longer at lower temperatures

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

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WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, 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	INFORMATION SHEET	1411
• SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
• DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434
• CLEANING OF STEEL AND REMOVAL OF RUST	INFORMATION SHEET	1490

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