

# SIGMARINE™ 28

## DESCRIPTION

One-component, quick-drying, high-build multipurpose zinc phosphate primer

## PRINCIPAL CHARACTERISTICS

- Onboard maintenance primer for above-water areas
- Easy application
- Quick-drying
- Recoatable with various one and two component products
- Surface tolerant
- Good anticorrosive properties

## COLOR AND GLOSS LEVEL

- Gray, redbrown, offwhite
- Flat

## BASIC DATA AT 20°C (68°F)

Data for product	
Number of components	One
Mass density	1.5 kg/l (12.5 lb/US gal)
Volume solids	55 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 266.0 g/kg max. 392.0 g/l (approx. 3.3 lb/US gal)
Recommended dry film thickness	75 µm (3.0 mils) per coat
Theoretical spreading rate	7.3 m <sup>2</sup> /l for 75 µm (294 ft <sup>2</sup> /US gal for 3.0 mils)
Dry to touch	30 minutes
Overcoating Interval	Minimum: 4 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

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

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; power tool cleaned to min. ISO-St2



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## **Substrate temperature and application conditions**

- Substrate temperature during application should be above 5°C (41°F)
  - Substrate temperature during application should be at least 3°C (5°F) above dew point
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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
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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**

1.7 - 2.0 mm (approx. 0.070 - 0.079 in)

#### **Nozzle pressure**

0.2 - 0.3 MPa (approx. 2 - 3 bar; 29 - 44 p.s.i.)

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### **Airless spray**

#### **Recommended thinner**

THINNER 21-06

#### **Volume of thinner**

0 - 5%, depending on required thickness and application conditions

#### **Nozzle orifice**

Approx. 0.38 - 0.48 mm (0.015 - 0.019 in)

#### **Nozzle pressure**

12.0 - 16.0 MPa (approx. 120 - 160 bar; 1741 - 2321 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 75 µm (3.0 mils)				
Overcoating with...	Interval	5°C (41°F)	20°C (68°F)	35°C (95°F)
SIGMARINE 28, SIGMARINE ONE 648, PPG VIKOTE 56 and PPG VIKOTE 46	Minimum	8 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited
PPG VIKOTE 18	Minimum	12 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited
SIGMACOVER 456 and SIGMADUR 550	Minimum	16 hours	8 hours	4 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note:

- Surface should be dry and free from chalking and contamination

Curing time for DFT up to 75 µm (3.0 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	2 hours
20°C (68°F)	30 minutes

**SAFETY PRECAUTIONS**

- See Safety Data Sheet and product label for complete safety and precaution requirements
- 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 & 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.

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## REFERENCES

- Information sheet | Explanation of product data sheets
- Guide | PPG SIGMACARE PLUS | Online guide to maintenance at sea

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## WARRANTY

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