

PPG SIGMACOVER™ 47

DESCRIPTION

Two-component, surface tolerant high-build epoxy primer/coating

PRINCIPAL CHARACTERISTICS

- Can be applied as a single coat, direct-to-metal for moderately corrosive environments (ISO 12944 C1-C3)
- Surface tolerant coating for lower grade of surface preparation for atmospheric exposure
- Easy application by different application methods such as airless spray, brush etc.
- Good drying and curing property at low temperatures down to -5°C (23°F)

COLOR AND GLOSS LEVEL

- Dark Gray, Light Gray and Redbrown
- Flat

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.5 kg/l (12.9 lb/US gal)
Volume solids	80 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 133.0 g/kg max. 205.0 g/l (approx. 1.7 lb/US gal)
Recommended dry film thickness	75 - 200 µm (3.0 - 8.0 mils) depending on system
Theoretical spreading rate	6.4 m²/l for 125 µm (257 ft²/US gal for 5.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 5 hours Maximum: Extended
Full cure after	4 days
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA – Spreading rate and film thickness
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Curing time

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RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Atmospheric exposure conditions

- Steel; blast cleaned to ISO-Sa2½ for excellent corrosion protection
 - Steel; blast cleaned to ISO-Sa2 or power tool cleaned to ISO-St2 for good corrosion protection
 - Shop primed steel; pretreated to SPSS-Pt2
 - Galvanized steel; sweep blasted to roughen the surface and to remove any zinc salts which might be present
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Substrate temperature and application conditions

- Substrate temperature during application and curing should be at least 3°C (37°F) above dew point
 - Relative humidity during application should not exceed 85%
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INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 4:1

- The temperature of the mixed base and hardener should be above 10°C (50°F), otherwise extra thinner may be required to obtain application viscosity
 - Adding too much thinner results in reduced sag resistance and slower cure
 - Thinner should be added after mixing the components
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Pot life

3 hours

Note:

- See ADDITIONAL DATA – Pot life
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Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 15%, depending on required thickness and application conditions

Nozzle orifice

Approx. 0.43 – 0.53 mm (0.017 – 0.021 in)

Nozzle pressure

20.0 - 25.0 MPa (approx. 200 - 250 bar; 2901 - 3626 p.s.i.)

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Brush/roller

Recommended thinner

THINNER 91-92

Volume of thinner

0 – 5%

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
75 µm (3.0 mils)	10.7 m ² /l (428 ft ² /US gal)
100 µm (4.0 mils)	8.0 m ² /l (321 ft ² /US gal)
125 µm (5.0 mils)	6.4 m ² /l (257 ft ² /US gal)
150 µm (6.0 mils)	5.3 m ² /l (214 ft ² /US gal)
200 µm (8.0 mils)	4.0 m ² /l (160 ft ² /US gal)

Overcoating interval for DFT up to 125 µm (5.0 mils): Atmospheric exposure								
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself	Minimum	60 hours	36 hours	20 hours	12 hours	5 hours	2.5 hours	1.5 hours
	Maximum	Extended	Extended	Extended	Extended	Extended	Extended	Extended

Curing time for DFT up to 125 µm (5.0 mils)			
Substrate temperature	Full cure	Dry to touch	Dry to handle
-5°C (23°F)	20 days	24 hours	48 hours
0°C (32°F)	14 days	12 hours	24 hours
5°C (41°F)	7 days	8 hours	16 hours
10°C (50°F)	5 days	6 hours	12 hours
20°C (68°F)	4 days	3 hours	5 hours
30°C (86°F)	3 days	1.5 hours	2.5 hours
40°C (104°F)	48 hours	1 hour	1.5 hours

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Pot life (at application viscosity)	
Mixed product temperature	Pot life
10°C (50°F)	5 hours
20°C (68°F)	3 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

SAFETY PRECAUTIONS

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

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.

REFERENCES

- Information sheet | Explanation of product data sheets

WARRANTY

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