SIGMADUR™ 2800 HS

DESCRIPTION

Two-component, air drying, high solids fluorocarbon finish

PRINCIPAL CHARACTERISTICS

- Excellent resistance to atmospheric exposure conditions
- Excellent color and gloss retention
- Resistant to splash of mineral and vegetable oils, paraffins, aliphatic petroleum products and mild chemicals
- Unlimited recoatable
- Low surface energy, good decontamination and easy-clean properties
- 25% fluorine content
- Complies with JT/T 722-2008, HG/T 3792-2014, Q-CR 749.3-2020

COLOR AND GLOSS LEVEL

- White and various other colors (see also PPG shade card)
- Gloss

BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	1.4 kg/l (11.7 lb/US gal)
Volume solids	68 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 321.0 g/kg max. 320.0 g/l (approx. 2.7 lb/US gal)
Recommended dry film thickness	30 - 50 µm (1.2 - 2.0 mils) depending on system
Theoretical spreading rate	17.0 m^2/l for 40 µm (682 ft^2/US gal for 1.6 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 12 hours Maximum: Unlimited
Shelf life	Base: at least 36 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

Substrate conditions

- Previous coat must be dry and free from any contamination
- Old existing sound coating; sufficiently roughened, dry and cleaned

Substrate temperature and application conditions

- Substrate temperature during application and curing down to -5°C (23°F) is acceptable
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 85%
- Premature exposure to early condensation and rain my cause color and gloss change

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 87:13

- Do not thin more than is required by appropriate application property
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

Induction time

None

Pot life

5 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

Air spray

Recommended thinner

THINNER 91-88

Volume of thinner

10 - 25%, depending on required thickness and application conditions

Nozzle orifice

1.0 - 1.5 mm (approx. 0.040 - 0.060 in)

Nozzle pressure

0.3 - 0.4 MPa (approx. 3 - 4 bar; 44 - 58 p.s.i.)

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Airless spray

Recommended thinner
THINNER 91-88

Volume of thinner
5 - 20%, depending on required thickness and application conditions

Nozzle orifice
Approx. 0.28 – 0.38 mm (0.011 – 0.015 in)

Nozzle pressure
20.0 MPa (approx. 200 bar; 2901 p.s.i.)

Brush/roller

Recommended thinner
THINNER 91-88

Volume of thinner
5 – 15%

ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
30 µm (1.2 mils)	22.7 m^2/l (909 ft^2/US gal)
40 µm (1.6 mils)	17.0 m^2/l (682 ft^2/US gal)
50 µm (2.0 mils)	13.6 m^2/l (545 ft^2/US gal)

Overcoating interval for DFT up to 40 µm (1.6 mils)					
Overcoating with...	**Interval**	**5°C (41°F)**	**20°C (68°F)**	**30°C (86°F)**	**40°C (104°F)**
itself	Minimum Maximum	32 hours Unlimited	12 hours Unlimited	6 hours Unlimited	3 hours Unlimited

Note: Surface should be dry and free from any contamination

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Curing time for DFT up to 35 µm (1.4 mils)		
Substrate temperature	**Dry to touch**	**Dry to handle**
5°C (41°F)	24 hours	36 hours
20°C (68°F)	2 hours	20 hours
30°C (86°F)	1 hour	10 hours
40°C (104°F)	30 minutes	3 hours

Note: Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
5°C (41°F)	8 hours
20°C (68°F)	5 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

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
- Contains a toxic polyisocyanate curing agent
- Avoid at all times inhalation of aerosol spray mist

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
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
• SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
• DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434

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