

# SIGMAZINC™ 102 HS

## DESCRIPTION

Two-component, high solids polyamide cured zinc rich epoxy primer

## PRINCIPAL CHARACTERISTICS

- High build anticorrosive zinc epoxy primer
- Designed as a system primer for various paint systems
- Quick-drying, can be overcoated after a short interval
- Complies with the compositional requirements of SSPC-Paint 20, Level 3

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	2.4 kg/l (20.0 lb/US gal)
Volume solids	66 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 120.0 g/kg max. 286.0 g/l (approx. 2.4 lb/US gal)
Recommended dry film thickness	60 - 150 µm (2.4 - 6.0 mils) depending on system
Theoretical spreading rate	11.0 m <sup>2</sup> /l for 60 µm (441 ft <sup>2</sup> /US gal for 2.4 mils)
Dry to touch	2 hours
Overcoating Interval	Minimum: 6 hours Maximum: 3 months
Full cure after	7 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

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Immersion exposure

- Steel; shot blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm (1.6 - 2.8 mils)
- Steel with approved zinc silicate shop primer; sweep blasted to SPSS-Ss

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## **Atmospheric exposure conditions**

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
  - Steel with approved zinc silicate shop primer; sweep blasted to SPSS-Ss or power tool cleaned to SPSS-Pt3
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## **Substrate temperature and application conditions**

- Substrate temperature during application and curing should be above 5°C (41°F)
  - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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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 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 and slower cure
  - Thinner should be added after mixing the components
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### **Induction time**

0 minute

Note:

- No induction time required
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### **Pot life**

8 hours at 20°C (68°F)

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### **Air spray**

#### **Recommended thinner**

THINNER 91-92

#### **Volume of thinner**

5 - 15%, depending on required thickness and application conditions

#### **Nozzle orifice**

1.8 – 2.2 mm (approx. 0.070 – 0.087 in)

#### **Nozzle pressure**

0.3 - 0.6 MPa (approx. 3 - 6 bar; 44 - 87 p.s.i.)

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## Airless spray

### Recommended thinner

THINNER 91-92

### Volume of thinner

0 - 10%, depending on required thickness and application conditions

### Nozzle orifice

Approx. 0.43 – 0.48 mm (0.017 – 0.019 in)

### Nozzle pressure

15.0 MPa (approx. 150 bar; 2176 p.s.i.)

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## Brush/roller

### Recommended thinner

THINNER 91-92

### Volume of thinner

0 – 10%

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## Cleaning solvent

- THINNER 90-53
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## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
60 µm (2.4 mils)	11.0 m <sup>2</sup> /l (441 ft <sup>2</sup> /US gal)
75 µm (3.0 mils)	8.8 m <sup>2</sup> /l (353 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	6.6 m <sup>2</sup> /l (265 ft <sup>2</sup> /US gal)
150 µm (6.0 mils)	4.4 m <sup>2</sup> /l (176 ft <sup>2</sup> /US gal)

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Overcoating interval for DFT up to 100 µm (4.0 mils)					
Overcoating with...	Interval	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
subsequent coating	Minimum	10 hours	6 hours	4 hours	3 hours
	Maximum	3 months	3 months	3 months	3 months

Notes:

- Zinc rich 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
- Before overcoating any visible surface contamination must be removed by high-pressure water cleaning, sand washing, sweep blasting or mechanical cleaning

Curing time for DFT up to 100 µm (4.0 mils)			
Substrate temperature	Full cure	Dry to touch	Dry to handle
10°C (50°F)	20 days	5 hours	6 hours
15°C (59°F)	10 days	3 hours	4 hours
20°C (68°F)	7 days	2 hours	3 hours
30°C (86°F)	5 days	1 hour	1.5 hours

Note:

- Adequate ventilation must be maintained during application and curing

## 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



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