

PPG SIGMAFAST ONE 628 (SIGMARINE 28)

DESCRIPTION

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

PRINCIPAL CHARACTERISTICS

- Onboard maintenance primer for above-water areas
- Easy application
- Fast-drying and handling
- Recoatable with various one and two component products
- Surface tolerant
- Good anticorrosive properties
- Suitable for atmospheric industrial and marine applications

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	50 - 75 µm (2.0 - 3.0 mils) per coat
Theoretical spreading rate	7.3 m ² /l for 75 µm (294 ft ² /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

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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.)

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)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
itself, SIGMARINE ONE 648 and PPG VIKOTE 56	Minimum	8 hours	6 hour	4 hours	3 hours	2 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited	Unlimited
SIGMACOVER 456 and SIGMADUR 550	Minimum	16 hours	12 hours	8 hours	6 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited	Unlimited	Unlimited

Note:

- Surface should be dry and free from chalking and contamination

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Curing time for DFT up to 75 µm (3.0 mils)	
Substrate temperature	Dry to touch
5°C (41°F)	2 hours
10°C (50°F)	1 hour
20°C (68°F)	30 minutes
30°C (86°F)	15 minute

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

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.

WARRANTY

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