PPG SIGMAGUARD™ 730

DESCRIPTION

Two-component, high solids polyamine cured phenolic epoxy coating

PRINCIPAL CHARACTERISTICS

- Tank coating with good chemical resistance against a wide range of chemicals
- Meets the requirements of EI 1541 2.2 (coating systems for aviation fuel storage tanks and pipes)
- Short curing periods
- Good low-temperature curing
- Easy to clean

COLOR AND GLOSS LEVEL

- Offwhite, cream
- 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	78 ± 2%
VOC (Supplied)	Directive 2010/75/EU, SED: max. 169.0 g/kg max. 242.0 g/l (approx. 2.0 lb/US gal)
Recommended dry film thickness	150 µm (6.0 mils)
Theoretical spreading rate	5.2 m^2/l for 150 µm (209 ft^2/US gal for 6.0 mils)
Dry to touch	3 hours
Overcoating Interval	Minimum: 8 hours Maximum: 28 days
Shelf life	Base: at least 12 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

- Steel; blast cleaned to a minimum of ISO Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Previous coat of approved coating must be dry and free from any contamination

Substrate temperature and application conditions

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

INSTRUCTIONS FOR USE

Mixing ratio by volume: base to hardener 3:1

- 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

Table of Induction time

Mixed product induction time	
Mixed product temperature	**Induction time**
15°C (59°F)	15 minutes
20°C (68°F)	10 minutes
25°C (77°F)	5 minutes

Pot life

2.25 hours at 20°C (68°F)

Note:

- See ADDITIONAL DATA – Pot life

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Air spray

Recommended thinner

THINNER 91-92

Volume of thinner

5 - 15% for a one coat application of 150 µm (6.0 mils) DFT

Nozzle orifice

1.8 – 2.0 mm (approx. 0.070 – 0.079 in)

Nozzle pressure

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

Airless spray

Recommended thinner

THINNER 91-92

Volume of thinner

0 - 10% for a one coat application of 150 µm (6.0 mils) DFT

Nozzle orifice

Approx. 0.53 – 0.69 mm (0.021 – 0.027 in)

Nozzle pressure

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

Brush/roller

- For stripe coating and spot repair only

Cleaning solvent

- THINNER 90-53

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ADDITIONAL DATA

Spreading rate and film thickness	
DFT	**Theoretical spreading rate**
125 µm (5.0 mils)	6.2 m^2/l (250 ft^2/US gal)
150 µm (6.0 mils)	5.2 m^2/l (209 ft^2/US gal)

Note:

- Maximum DFT when brushing: 100 µm (4.0 mils)

Overcoating interval for DFT up to 150 µm (6.0 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	Minimum	32 hours	24 hours	8 hours	4 hours	3 hours
	Maximum	28 days	28 days	28 days	14 days	7 days

Note:

- Surface should be dry and free from any contamination

Curing time for DFT up to 150 µm (6.0 mils)		
Substrate temperature	**Minimum curing time before transport of aliphatic petroleum products and ballast water and tanktest with seawater**	**Minimum curing time before transport of cargoes without note 4, 7 or 11**
5°C (41°F)	10 days	17 days
10°C (50°F)	7 days	14 days
20°C (68°F)	3 days	5 days
30°C (86°F)	60 hours	4 days
40°C (104°F)	36 hours	3 days

Notes:

- Minimum curing time before transport of cargoes with note 4,7 or 11: 3 months
- For detailed information on resistance and resistance notes, please refer to the latest issue of the cargo resistance list
- Adequate ventilation must be maintained during application and curing

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Pot life (at application viscosity)	
Mixed product temperature	**Pot life**
15°C (59°F)	3 hours
20°C (68°F)	2.25 hours
25°C (77°F)	1.75 hour
30°C (86°F)	1 hour

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.

REFERENCES

- Information sheet | Explanation of product data sheets

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