

# SIGMADUR 520

(SIGMADUR HB FINISH)



4 pages

March 2010  
Revision of September 2005

**DESCRIPTION** two component high build semigloss aliphatic acrylic polyurethane finish

**PRINCIPAL CHARACTERISTICS**

- easy application by roller and airless spray
- unlimited recoatable
- excellent resistance to atmospheric exposure conditions
- good colour and gloss retention (aluminium version becomes grey)
- non-chalking, non-yellowing
- cures at temperatures down to -5°C
- tough and abrasion resistant
- resistant to splash of mineral and vegetable oils, paraffins, aliphatic petroleum products and mild chemicals
- can be recoated even after long atmospheric exposure

**COLOURS AND GLOSS** full colour range and aluminium as RAL 9006 available - semigloss

**BASIC DATA AT 20°C** (1 g/cm<sup>3</sup> = 8.25 lb/US gal; 1 m<sup>2</sup>/l = 40.7 ft<sup>2</sup>/US gal)  
(data for mixed product)

Mass density 1.4 g/cm<sup>3</sup> (white)  
1.1 g/cm<sup>3</sup> (aluminium)

Volume solids 58 ± 2% (white), 48 ± 2% (aluminium)

VOC (supplied) max. 287 g/kg (Directive 1999/13/EC, SED) (white)  
max. 377 g/kg (Directive 1999/13/EC, SED) (RAL 9006)  
max. 383 g/l (approx. 3.2 lb/gal) (white)  
max. 405 g/l (approx. 3.4 lb/gal) (aluminium)

Recommended dry film thickness 50 - 75 µm depending on system

Theoretical spreading rate 11.6 m<sup>2</sup>/l for 50 µm, 7.7 m<sup>2</sup>/l for 75 µm \*

Touch dry after 1 hour

Overcoating interval min. 6 hours \*  
max. unlimited

Full cure after 4 days \*

(data for components)

Shelf life (cool and dry place) at least 24 months

Flash point base 26°C, hardener 42°C

\* see additional data

**RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES**

- previous coat; (epoxy or polyurethane) dry and free from any contamination and sufficiently roughened if necessary
- during application and curing a substrate temperature down to -5°C is acceptable provided the substrate is dry and free from ice
- substrate temperature should be at least 3°C above dew point
- maximum relative humidity during application and curing is 85%
- premature exposure to early condensation and rain may cause colour and gloss change

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**INSTRUCTIONS FOR USE**

mixing ratio by volume: base to hardener 88 : 12

- the temperature of the mixed base and hardener should preferably be above 10°C, otherwise extra solvent may be required to obtain application viscosity
- too much solvent results in reduced sag resistance
- thinner should be added after mixing the components

Induction time

none

Pot life

5 hours at 20°C \*  
\* see additional data

**AIRLESS SPRAY**

Recommended thinner

Thinner 21-06

Volume of thinner

0 - 5%, depending on required thickness and application conditions

Nozzle orifice

approx. 0.46 mm (= 0.018 in)

Nozzle pressure

15 MPa (= approx. 150 bar; 2130 p.s.i.)

**AIR SPRAY**

Recommended thinner

Thinner 21-06

Volume of thinner

5 - 10%, depending on required thickness and application conditions

Nozzle orifice

1 - 1.5 mm

Nozzle pressure

0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)

**BRUSH/ROLLER**

Recommended thinner

Thinner 21-06

Volume of thinner

0 - 5%

**CLEANING SOLVENT**

Thinner 90-53

**SAFETY PRECAUTIONS**

for paint and recommended thinners see safety 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 vapour 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 spraymist

**ADDITIONAL DATA**

**Film thickness and spreading rate**

theoretical spreading rate m <sup>2</sup> /l		
colours	11.6	7.7
aluminium	9.6	6.4
dft in µm	50	75

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**Overcoating table for SigmaDur products**

substrate temperature	-5°C	0°C	10°C	20°C	30°C	40°C
minimum interval	24 hours	16 hours	8 hours	6 hours	5 hours	3 hours
maximum interval	unlimited when cleaned from any contamination					

- surface should be dry and free from any contamination

**Curing table**

substrate temperature	dry to handle	full cure
-5°C	24 hours	15 days
0°C	16 hours	11 days
10°C	8 hours	6 days
20°C	6 hours	4 days
30°C	5 hours	3 days
40°C	3 hours	2 days

- adequate ventilation must be maintained during application and curing (please refer to sheets 1433 and 1434)
- premature exposure to early condensation and rain may cause colour and gloss change

**Pot life (at application viscosity)**

10°C	7 hours
20°C	5 hours
30°C	3 hours
40°C	2 hours

**Worldwide availability**

Whilst it is always the aim of PPG Protective & Marine Coatings to supply the same product on a worldwide basis, 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	see information sheet 1411
Safety indications	see information sheet 1430
Safety in confined spaces and health safety	
Explosion hazard - toxic hazard	see information sheet 1431
Safe working in confined spaces	see information sheet 1433
Directives for ventilation practice	see information sheet 1434

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## LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the Sigma Coatings products made by PPG Protective & Marine Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

PPG Protective & Marine Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. PPG Protective & Marine Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development.

This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

The English text of this document shall prevail over any translation thereof.

	PDS	7524
119852	white	7000002200
183212	aluminium	9006262200