

# SIGMAFAST™ 20

## DESCRIPTION

High-build zinc phosphate primer, based on modified alkyd resin

## PRINCIPAL CHARACTERISTICS

- Good anticorrosive properties under atmospheric conditions
- Fast-drying
- Fast-handling
- Recoatable with most one- and two-component coatings
- Suitable for atmospheric exposure conditions
- Lead- and chromate free
- Can be specified as a single coat, direct-to-metal system for ISO 12944 C1 and C2 environments

## COLOR AND GLOSS LEVEL

- Redbrown, gray (other (RAL) colors available on request)
- Flat

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	One
Mass density	1.5 kg/l (12.5 lb/US gal)
Volume solids	55 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 258.0 g/kg UK PG 6/23(92) Appendix 3: max. 382.0 g/l (approx. 3.2 lb/US gal)
Recommended dry film thickness	50 - 75 µm (2.0 - 3.0 mils) per coat
Theoretical spreading rate	7.3 m <sup>2</sup> /l for 75 µm (294 ft <sup>2</sup> /US gal for 3.0 mils)
Dry to touch	15 minutes
Overcoating Interval	Minimum: 45 minutes
Shelf life	At least 24 months when stored cool and dry

Note: See ADDITIONAL DATA – Overcoating intervals

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½
- Steel; power tool cleaned to min. ISO-St2
- Shop primed steel; sweep blasted or power tool cleaned to SPSS-Ss or SPSS-Pt2



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## **Substrate temperature**

- 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**

- 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 (please refer to INFORMATION SHEETS 1433 and 1434)
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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**

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

### **Nozzle pressure**

0.4 MPa (approx. 4 Bar; 51 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.)

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## **Brush/roller**

### **Recommended thinner**

THINNER 20-05

### **Volume of thinner**

0 – 2%

## **Cleaning solvent**

THINNER 21-06

## **ADDITIONAL DATA**

<b>Overcoating interval for DFT up to 75 µm (3.0 mils)</b>				
<b>Overcoating with...</b>	<b>Interval</b>	<b>10°C (50°F)</b>	<b>15°C (59°F)</b>	<b>20°C (68°F)</b>
two-component products: SIGMACOVER 456, SIGMACOVER 435 or SIGMADUR 520	Minimum	12 hours	10 hours	8 hours
	Maximum	Unlimited	Unlimited	Unlimited
alkyd-based products (e.g. SIGMAFAST 20 and SIGMAFAST 40)	Minimum	1.5 hours	1 hour	45 minutes
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from any contamination

## **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

## **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.

# SIGMAFAST™ 20

## REFERENCES

• CONVERSION TABLES	INFORMATION SHEET	1410
• 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
• CLEANING OF STEEL AND REMOVAL OF RUST	INFORMATION SHEET	1490
• SPECIFICATION FOR MINERAL ABRASIVES	INFORMATION SHEET	1491
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

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