

SIGMASHIELD 1200 LT**(SIGMA NOVASHIELD LT)**

4 pages

September 2005

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| DESCRIPTION | two component abrasion resistant solvent free amine cured phenolic epoxy coating |
| PRINCIPAL CHARACTERISTICS | <ul style="list-style-type: none"> – one or two coat system for structures requiring abrasion resistance – suitable for underwater hull of ice going vessels – excellent abrasion and impact resistance – resistant to well designed cathodic protection – excellent water resistance – glossy and smooth appearance – easy to clean – can be applied by heavy duty twin feed hot airless spray equipment – eliminates explosion risk and fire hazard |
| COLOURS AND GLOSS | black - gloss |
| BASIC DATA AT 10°C | (1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) (data for mixed product) |
| Mass density | 1.5 g/cm ³ |
| Volume solids | 100% |
| VOC (supplied) | max. 92 g/kg (Directive 1999/13/EC, SED) max. 136 g/l (approx. 1.1 lb/gal) see information sheet 1411 |
| Recommended dry film thickness | 400 - 500 µm |
| Theoretical spreading rate | 2.5 m ² /l for 400 µm, 2 m ² /l for 500 µm * |
| Touch dry after | 8 hours |
| Overcoating interval | min. 24 hours * max. 22 days * |
| Full cure after | 5 days * |
| | (data for components) |
| Shelf life (cool and dry place) | at least 12 months |
| Flash point | base and hardener above 65°C * see additional data |
| RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES | <ul style="list-style-type: none"> – steel; blast cleaned to a minimum of ISO-Sa2½, blasting profile (R_z) 50 - 100 µm – substrate temperature should be above 5°C and at least 3°C above dew point during application and curing – dry and free from any contamination |

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INSTRUCTIONS FOR USE

mixing ratio by volume: base to hardener 80 : 20

- when mixing the temperature of the base and hardener should be at least 20°C
- at lower temperature the viscosity will be too high for spray application
- no thinner should be added

Induction time

none

Pot life

30 min. at 20°C *
* see additional data

AIRLESS SPRAY

- twin feed hot airless spray
- heavy duty single feed airless spray equipment with a minimum of 60:1 pump ratio and suitable high pressure hoses
- in-line heating or insulated hoses may be necessary to avoid cooling down of paint in hoses at low air temperature
- length of hoses should be as short as possible

Recommended thinner

no thinner should be added

Nozzle orifice

approx. 0.53 mm (= 0.021 in)

Nozzle pressure

at 20°C (paint temperature) min. 28 MPa (= approx. 280 bar; 4000 p.s.i.)
at 30°C (paint temperature) min. 22 MPa (= approx. 220 bar; 3000 p.s.i.)

BRUSH/ROLLER

for stripe coating and spot repair only

Recommended thinner

no thinner should be added

CLEANING SOLVENT

Sigma thinner 90-83 (preferred) or Sigma thinner 90-53

- all application equipment must be cleaned immediately after use
- paint inside the spraying equipment must be removed before the pot life time has been expired

SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

although this is a solvent free paint, care should be taken to avoid inhalation of spray mist as well as contact between the wet paint and exposed skin or eyes

- ventilation should be provided in confined spaces to maintain good visibility

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ADDITIONAL DATA

Film thickness and spreading rate

| | | |
|----------------------------------------------|-----|-----|
| theoretical spreading rate m ² /l | 2.5 | 2 |
| dft in µm | 400 | 500 |

max. dft when brushing: 150 µm

measuring wet film thickness

- a deviation is often obtained between the measured apparent wft and the real applied wft
- this is due to the thixotropy and the surface tension of the paint which retards the release of air trapped in the paint film for some time
- recommendation is to apply a wft which is equal to the specified dft plus 60 µm

measuring dry film thickness

- because of low initial hardness the dft cannot be measured for some days (depending on ambient temperature) after application due to the penetration of the measuring device into the paint film
- the dft should be measured using a calibration foil of known thickness placed in between the coating and the measuring device

overcoating table with itself, SigmaCover 515 and SigmaCover 456

| substrate temperature | 5°C | 10°C | 20°C | 30°C |
|-----------------------|----------|----------|----------|---------|
| minimum interval | 36 hours | 24 hours | 12 hours | 6 hours |
| maximum interval | 22 days | 22 days | 14 days | 10 days |

- surface should be dry and free from any contamination

Curing table

| substrate temperature | dry to handle | full cure |
|-----------------------|---------------|-----------|
| 5°C | 48 hours | 12 days |
| 10°C | 24 hours | 5 days |
| 20°C | 12 hours | 3 days |
| 30°C | 6 hours | 2 days |

- although the paint is solvent free adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)

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Pot life (at application viscosity)

| | |
|------|---------|
| 20°C | 30 min. |
| 30°C | 20 min. |

- due to exothermic reaction, temperature during and after mixing may increase

Worldwide availability

Whilst it is always the aim of Sigma 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 |
| Cleaning of steel and removal of rust | see information sheet 1490 |

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

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