

October 1992

DESCRIPTION

A two component exterior epoxy acrylic topcoat with excellent weathering properties.

PRINCIPAL CHARACTERISTICS

- Color and gloss retention superior to standard epoxy coatings.
- Good solvent resistance.
- Easy to apply by conventional spray.
- Fast curing properties.
- Good adhesion and flexibility.

COLOR AND GLOSS

Available in white and colors.
High Gloss Finish.

BASIC DATA AT 68°F (20°C)

Data may vary slightly with color.

Mass Density
Solids content by volume
VOC (before thinning)
Theoretical spreading rate @ 1 mil
Recommended dry film
Touch dry after
Hard dry after
Min. interval before overcoating
Temperature resistance (dry)
Shelf life
Flashpoint (T.C.C.)

Approx. 9.0 lbs/gal (1.08 kg/ltr)
Approx. 44%
3.9 lbs/gal (468 grm/ltr)
706 ft²/gal (17.3 m²/liter)
2.0 mils (50 microns)
2 Hours
6 Hours
2-3 Hours
250°F
Subject to reinspection after 12 months
Base: 80°F
Hardener: 80°F

Ordering Information

Order "Sigma Epoxy Acrylic 5441-color". Available in 5 gal. kits consisting of 4 gals. of base in a 5 gal. pail and 1 gal. of hardener in a one gal. can. Available in 1 gal. kits consisting of 0.80 gal. of base in a one gal. can and 0.20 gal. of hardener in a quart can.

(1/3)

INSTRUCTIONS FOR USE

- Contact your Sigma Coatings representative for recommendations concerning specific requirements.
- Power agitate Base component to uniform consistency before combining, then again after combining. **DO NOT** vary proportions.

Mixing Instructions

Ratio: base to hardener 81 : 19 by weight
base to hardener 4 : 1 by weight

The temperature of the mixture of base and hardener during the mixing and application should be above 59°F (15°C), otherwise more solvents must be used to obtain application viscosity. This results in lower sag resistance and slower cure. Thinner should be added only after mixing components.

Induction Time

15 minutes

Potlife

Over 8 Hours at 68°F (20°C)

Conventional Spray**Manufacturer:****Gun Model:****Tip - Aircap Combination:****DeVilbiss**

MBC or JGA

704E

Binks

#18 or #62

66PE

Fluid hose should be 3/8" I.D. with a maximum length of 50 feet. Pot should always have dual regulation and be kept at same elevation as spray gun.

Airless:**Manufacturer:****Gun Model:****Pump:****Graco**

205-591

Bulldog

Binks

Model 500

Mercury 5C

DeVilbiss

JGN-501

QFA-519

Hose should be 3/8" I.D. minimum, but a 1/4" I.D. whip end section may be used for ease of application. A maximum length of 100 feet is suggested. Best results will be obtained using a .016" - .019" tip at 1900 - 2400 p.s.i.

NOTE: Nylon or Teflon type packings are available from pump manufacturer and are highly recommended. Reversible tips are suggested.

THINNING REQUIREMENTS

Recommended thinner #91-88, Flash Point 80°F (27°C).

Airless Spray : 0-5% by volume

Conventional Spray : 0-10% by volume



Substrate Temperature

The substrate temperature must be above 41°F (5°C), the relative humidity should not be more than 70% during application and curing. The temperature must reach a minimum of 55°F (13°C) within 6 hours of application to allow the coating to cure.

SAFETY PRECAUTIONS

This product is offered for sale and use only to **PROFESSIONALLY TRAINED INDUSTRIAL PERSONNEL**. It is **NOT FOR RESIDENTIAL USE**. This product contains flammable solvents and/or other hazardous chemical ingredients and must be used with caution. Observe all health and safety precautions as listed on the Material Safety Data Sheet during storage, handling, application, drying and disposal. **DO NOT ATTEMPT TO USE THIS PRODUCT WITHOUT CONSULTING THE CURRENT "MATERIAL SAFETY DATA SHEET"**. Material Safety Data Sheets are available from the Customer Service Department at Sigma Coatings (504-347-4321).

ADDITIONAL DATA**Overcoating-**

At substrate Temperature of	59°F (15°C)	68°F (20°C)	77°F (25°C)	86°F (30°C)
Minimum Interval	18 Hours	12 Hours	10 Hours	8 Hours
Max. Interval on Surfaces Free from Chalking & Contamination	Interval unlimited. Surface abrading is necessary when repair work is done.			

(10/92)

(3/3)

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