

# SIGMAFAST™ 302

## DESCRIPTION

Two-component, silicate zinc epoxy primer

## PRINCIPAL CHARACTERISTICS

- Good anticorrosive properties
- Fast-curing
- Fast-handling
- Cures at temperatures down to -5°C (23°F)
- Reduced risk of mud cracking
- Topcoats must be unsaponifiable

## COLOR AND GLOSS LEVEL

- Bluegreen, gray
- Flat

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
Number of components	Two
Mass density	2.1 kg/l (17.5 lb/US gal)
Volume solids	63 ± 2%
VOC (Supplied)	Directive 1999/13/EC, SED: max. 204.0 g/kg max. 419.0 g/l (approx. 3.5 lb/US gal)
Recommended dry film thickness	50 - 80 µm (2.0 - 3.1 mils) depending on system
Theoretical spreading rate	12.6 m <sup>2</sup> /l for 50 µm (505 ft <sup>2</sup> /US gal for 2.0 mils)
Dry to touch	10 minutes
Overcoating Interval	Minimum: 25 minutes Maximum: 12 months
Shelf life	Base: at least 24 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 ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
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### Substrate temperature and application conditions

- Substrate temperature during application at -5°C (23°F) is acceptable; provided the substrate is free from ice and dry
  - Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
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## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 80:20 (4:1)

- 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
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### Pot life

4 hours at 20°C (68°F)

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### Air spray

#### **Recommended thinner**

THINNER 21-06

#### **Volume of thinner**

15 - 20%, depending on required thickness and application conditions

#### **Nozzle orifice**

1.6 mm (approx. 0.063 in)

#### **Nozzle pressure**

0.3 - 0.6 MPa (approx. 3 - 6 bar; 44 - 87 p.s.i.)

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**Airless spray**

**Recommended thinner**

THINNER 21-06

**Volume of thinner**

5 - 15%, depending on required thickness and application conditions

**Nozzle orifice**

Approx. 0.38 – 0.53 mm (0.015 – 0.021 in)

**Nozzle pressure**

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

**Brush/roller**

**Recommended thinner**

THINNER 21-06

**Volume of thinner**

0 – 5%

**Cleaning solvent**

THINNER 90-53

**ADDITIONAL DATA**

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2.0 mils)	12.6 m <sup>2</sup> /l (505 ft <sup>2</sup> /US gal)
80 µm (3.1 mils)	7.9 m <sup>2</sup> /l (326 ft <sup>2</sup> /US gal)

Overcoating interval for DFT up to 50 µm (2.0 mils)						
Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
various two-component epoxy coatings	Minimum	1 hour	45 minutes	30 minutes	25 minutes	20 minutes
	Maximum	12 months	12 months	12 months	12 months	12 months

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## Overcoating interval for DFT up to 80 µm (3.1 mils)

Overcoating with...	Interval	-5°C (23°F)	0°C (32°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
various two-pack epoxy coatings	Minimum	1.5 hours	1 hour	50 minutes	40 minutes	35 minutes
	Maximum	12 months	12 months	12 months	12 months	12 months

## Notes:

- Surface should be dry and free from any contamination
- An interval of several months can be allowed under clean interior exposure conditions
- Before overcoating any visible surface contamination must be removed by sandwashing, sweep blasting or mechanical cleaning

## Curing time for DFT up to 80 µm (3.1 mils)

Substrate temperature	Dry to touch	Dry to handle
-5°C (23°F)	1 hour	1.5 hours
0°C (32°F)	40 minutes	1 hour
10°C (50°F)	25 minutes	50 minutes
20°C (68°F)	10 minutes	40 minutes
30°C (86°F)	less than 10 minutes	35 minutes

Note: Adequate ventilation must be maintained during application and curing

## 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.

## 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



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