

# SIGMACOVER™ 805

## DESCRIPTION

Two-component, high solids polyamine adduct cured epoxy coating

## PRINCIPAL CHARACTERISTICS

- Can be used directly to metal
- Very good surface wetting
- Excellent corrosion resistance
- Outstanding (sea)water resistance
- Resistant to well designed/controlled cathodic protection
- Good resistance against chemically-polluted water
- Good abrasion resistance
- Tar free

## COLOR AND GLOSS LEVEL

- Limited color range available
- Gloss

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
<b>Number of components</b>	Two
<b>Mass density</b>	1.6 kg/l (13.4 lb/US gal)
<b>Volume solids</b>	82 ± 2%
<b>VOC (Supplied)</b>	Directive 1999/13/EC, SED: max. 158.0 g/kg max. 221.0 g/l (approx. 1.8 lb/US gal)
<b>Recommended dry film thickness</b>	150 - 250 µm (6.0 - 10.0 mils) depending on requirements
<b>Theoretical spreading rate</b>	5.5 m <sup>2</sup> /l for 150 µm (219 ft <sup>2</sup> /US gal for 6.0 mils)
<b>Dry to touch</b>	3 hours
<b>Overcoating Interval</b>	Minimum: 16 hours Maximum: 28 days
<b>Shelf life</b>	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

### Immersion exposure

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel with approved zinc silicate shop primer; pretreated according to SPSS-Ss

### Atmospheric exposure conditions

- Steel; pretreated preferably to ISO-Sa2½, , blasting profile 40 – 70 µm (1.6 – 2.8 mils) or according to ISO-St3
- Shop primed steel; pretreated to SPSS-Pt3

### Substrate conditions

- Previous coat (specific epoxy) must be dry and free from any contamination and within overcoating time

### 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

## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 75:25 (3:1)

- The temperature of the mixed base and hardener should be above 10°C (50°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

### Pot life

2 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

### Airless spray

#### **Recommended thinner**

THINNER 91-92

#### **Volume of thinner**

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

#### **Nozzle orifice**

Approx. 0.48 – 0.53 mm (0.019 – 0.021 in)

#### **Nozzle pressure**

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



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## Cleaning solvent

THINNER 90-53

## ADDITIONAL DATA

### Spreading rate and film thickness

DFT	Theoretical spreading rate
150 µm (6.0 mils)	5.5 m <sup>2</sup> /l (219 ft <sup>2</sup> /US gal)
250 µm (10.0 mils)	3.3 m <sup>2</sup> /l (132 ft <sup>2</sup> /US gal)

### Overcoating interval for DFT up to 150 µm (6.0 mils)

Overcoating with...	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)
itself	Minimum	36 hours	24 hours	16 hours	8 hours
	Maximum	28 days	28 days	28 days	14 days

#### Notes:

- Surface should be dry and free from any contamination
- For polyurethane paints like SIGMADUR 550 and SIGMADUR 520 the minimum overcoating time should be raised with 50%
- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)

### Curing time for DFT up to 150 µm (6.0 mils)

Substrate temperature	Service- water immersion
5°C (41°F)	10 days
10°C (50°F)	7 days
15°C (59°F)	5 days
20°C (68°F)	3 days
30°C (86°F)	60 hours
40°C (104°F)	36 hours

### Pot life (at application viscosity)

Mixed product temperature	Pot life
15°C (59°F)	3 hours
20°C (68°F)	2 hours
30°C (86°F)	1 hour
40°C (104°F)	30 minutes

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## 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
• SPECIFICATION FOR MINERAL ABRASIVES	INFORMATION SHEET	1491
• RELATIVE HUMIDITY – SUBSTRATE TEMPERATURE – AIR TEMPERATURE	INFORMATION SHEET	1650

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