

# SIGMARINE™ 28

## DESCRIPTION

One-component, quick-drying, high-build multipurpose zinc phosphate primer

## PRINCIPAL CHARACTERISTICS

- Onboard maintenance primer for above-water areas
- Easy application
- Quick-drying
- Recoatable with various one and two component products
- Surface tolerant
- Good anticorrosive properties

## COLOR AND GLOSS LEVEL

- Gray, redbrown, offwhite
- Flat

## BASIC DATA AT 20°C (68°F)

Data for 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. 266.0 g/kg max. 392.0 g/l (approx. 3.3 lb/US gal)
Recommended dry film thickness	75 µm (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	30 minutes
Overcoating Interval	Minimum: 4 hours Maximum: Unlimited
Shelf life	At least 24 months when stored cool and dry

Notes:

- See ADDITIONAL DATA - Overcoating intervals
- See ADDITIONAL DATA - Curing time

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO-Sa2½, blasting profile 40 – 70 µm (1.6 – 2.8 mils)
- Steel; power tool cleaned to min. ISO-St2



# SIGMARINE™ 28

## **Substrate temperature and application conditions**

- Substrate temperature during application should be above 5°C (41°F)
  - Substrate temperature during application should be at least 3°C (5°F) above dew point
- 

## **SYSTEM SPECIFICATION**

- SYSTEMS FOR BOOTTOP AND TOPSIDE – SYSTEM SHEET 3102
  - SYSTEMS FOR DECKS – SYSTEM SHEET 3103
  - SYSTEMS FOR SUPERSTRUCTURE AND DECK FITTINGS – SYSTEM SHEET 3104
  - SYSTEMS FOR INTERIOR(S) – SYSTEM SHEET 3105
- 

## **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)
- 

## **Air spray**

### **Recommended thinner**

THINNER 21-06

### **Volume of thinner**

5 - 10%, depending on required thickness and application conditions

### **Nozzle orifice**

1.7 – 2.0 mm (approx. 0.070 – 0.079 in)

### **Nozzle pressure**

0.2 - 0.3 MPa (approx. 2 - 3 bar; 29 - 44 p.s.i.)

---

# SIGMARINE™ 28

## 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.)

## Brush/roller

### Recommended thinner

THINNER 21-06

### Volume of thinner

0 - 3%

## Cleaning solvent

THINNER 21-06

## ADDITIONAL DATA

Overcoating interval for DFT up to 75 µm (3.0 mils)				
Overcoating with...	Interval	5°C (41°F)	20°C (68°F)	35°C (95°F)
SIGMARINE 28, SIGMARINE 48, PPG VIKOTE 56 and PPG VIKOTE 46	Minimum	8 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited
PPG VIKOTE 18	Minimum	12 hours	4 hours	3 hours
	Maximum	Unlimited	Unlimited	Unlimited
SIGMACOVER 456 and SIGMADUR 550	Minimum	16 hours	8 hours	4 hours
	Maximum	Unlimited	Unlimited	Unlimited

Note: Surface should be dry and free from chalking and contamination

# SIGMARINE™ 28

## Curing time for DFT up to 75 µm (3.0 mils)

Substrate temperature	Dry to touch
5°C (41°F)	2 hours
20°C (68°F)	30 minutes

## 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

• 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

## WARRANTY

PPG warrants (i) its title to the product, (ii) that the quality of the product conforms to PPG's specifications for such product in effect at the time of manufacture and (iii) that the product shall be delivered free of the rightful claim of any third person for infringement of any U.S. patent covering the product. THESE ARE THE ONLY WARRANTIES THAT PPG MAKES AND ALL OTHER EXPRESS OR IMPLIED WARRANTIES, UNDER STATUTE OR ARISING OTHERWISE IN LAW, FROM A COURSE OF DEALING OR USAGE OF TRADE, INCLUDING WITHOUT LIMITATION, ANY OTHER WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR USE, ARE DISCLAIMED BY PPG. Any claim under this warranty must be made by Buyer to PPG in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify PPG of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

## LIMITATIONS OF LIABILITY

IN NO EVENT WILL PPG BE LIABLE UNDER ANY THEORY OF RECOVERY (WHETHER BASED ON NEGLIGENCE OF ANY KIND, STRICT LIABILITY OR TORT) FOR ANY INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES IN ANY WAY RELATED TO, ARISING FROM, OR RESULTING FROM ANY USE MADE OF THE PRODUCT. The information in this sheet is intended for guidance only and is based upon laboratory tests that PPG believes to be reliable. PPG may modify the information contained herein at any time as a result of practical experience and continuous product development. All recommendations or suggestions relating to the use of the PPG product, whether in technical documentation, or in response to a specific inquiry, or otherwise, are based on data, which to the best of PPG's knowledge, is reliable. The product and related information is designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. PPG has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Therefore, PPG does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information (unless there are written agreements stating otherwise). Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. This sheet supersedes all previous versions and it is the Buyer's responsibility to ensure that this information is current prior to using the product. Current sheets for all PPG Protective & Marine Coatings Products are maintained at [www.ppgpmc.com](http://www.ppgpmc.com). The English text of this sheet shall prevail over any translation thereof.

The PPG logo, and all other PPG marks are property of the PPG group of companies. All other third-party marks are property of their respective owners.

