

SIGMASHIELD 620

3 pages

November 2006
Revision of February 2006

DESCRIPTION	two component high solids amine cured epoxy coating
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – specialised coating for use under SigmaGlide fouling release system – excellent impact resistance – excellent water resistance
COLOURS AND GLOSS	grey, redbrown, blue (other colours on request) - gloss
BASIC DATA AT 20°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	1.6 g/cm ³
Volume solids	85 ± 2%
VOC (supplied)	max. 150 g/kg (Directive 1999/13/EC, SED) max. 235 g/l (approx. 2.0 lb/gal)
Recommended dry film thickness	150 µm
Theoretical spreading rate	5.7 m ² /l for 150 µm
Touch dry after	3 hours
Overcoating interval	min. 12 hours * max. 5 days *
Curing time	5 days *
	(data for components)
Shelf life (cool and dry place)	at least 12 months * see additional data
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> – previous coat; dry and free from any contamination – substrate temperature should be at least 20°C and at least 3°C above dew point during application and curing
INSTRUCTIONS FOR USE	<p>mixing ratio by volume: base to hardener 75 : 25</p> <ul style="list-style-type: none"> – the temperature of the mixed base and hardener should preferably be above 20°C, otherwise extra solvent may be required to obtain application viscosity – too much solvent results in reduced sag resistance and slower cure – thinner should be added after mixing the components
Induction time	none
Pot life	1.5 hours at 20°C * * see additional data

SIGMASHIELD 620

November 2006

AIRLESS SPRAY

Recommended thinner no thinner should be added
 Nozzle orifice approx. 0.53 - 0.68 mm (= 0.021 - 0.027 in)
 Nozzle pressure 15 MPa (= approx. 150 bar; 2130 p.s.i.)

BRUSH/ROLLER

Recommended thinner no thinner should be added

CLEANING SOLVENT

Sigma thinner 90-53

SAFETY PRECAUTIONS

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

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

ADDITIONAL DATA

Overcoating table for SigmaShield 620 for dft up to 150 µm

with SigmaGlide 790

substrate temperature	20°C	30°C	40°C
minimum interval	12 hours	4 hours	4 hours
maximum interval	5 days	3 days	2 days

- surface should be dry and free from any contamination

Curing table for SigmaShield 620 for dft up to 150 µm

substrate temperature	dry to handle	full cure for immersion in seawater	full cure
20°C	3.5 hours	5 days	7 days
30°C	2 hours	4 days	5 days
40°C	1.5 hour	3 days	3 days

- adequate ventilation to remove solvent must be maintained during application and curing (please refer to sheet 1433 and 1434)
- for advice please contact your nearest SigmaKalon Marine & Protective Coatings sales office

SIGMASHIELD 620

November 2006

Pot life (at application viscosity)

10°C	3 hours
20°C	1.5 hour
30°C	45 min.

Worldwide availability

Whilst it is always the aim of SigmaKalon Marine & Protective 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

LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the Sigma Coatings products made by SigmaKalon Marine & Protective Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

SigmaKalon Marine & Protective Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. SigmaKalon Marine & Protective Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

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

PDS	7948
252060 grey	5177052200
252062 redbrown	6179052200
256894 blue	1000002200