SIGMA DUR 568

4 January 2011

DESCRIPTION

4 pages

PRINCIPAL CHARACTERISTICS

Two component high solid high building polyurethane finish

- excellent resistance to atmospheric exposure conditions
- excellent colour and gloss retention
- non-chalking, non-yellowing
- cures at temperatures down to -5°C
- resistant to splash of mineral and vegetable oils, paraffins, aliphatic pertroleum products and mild chemicals
- can be recoated even after long atmospheric exposure
- good application properties
- can be high build up to 150um for one coat
- Directly to metal

COLOUR AND GLOSS

White and various other colours (see also Marine shade card) -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	1.5 g/cm^3
Volume Solids	68%±2
VOC (supplied)	Max. 220g/kg (Directive 1999/13/EC, SED) Max. 330 g/liter (approx.2.7 lb/gal)
Recommended dry film thickness	75-150µm depending on system
Theoretical spreading rate	6.8m^2/l for 100µm*
Touch dry after	3hours
Overcoating interval	Min. 8hours* Max. unlimited

(Data for components)

Shelf life (cool and dry place)	At least 24 months *see additional data

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Previous coat; (epoxy or polyurethane) dry and free from any contamination and sufficiently roughened if necessary
- application and curing a substrate temperature down to -5°C is acceptable provided the substrate is dry and free from ice
- substrate temperature should be at least 3°C above dew point
- maximum relative humidity during application and curing is 85%
- premature exposure to early condensation and rain may cause colour and gloss change

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INSTRUCTION FOR USE

Mixing ratio by volume: base to hardener 87: 13
- do not thin more than is required by appropriate application property
- too much solvent results in reduced sag resistance and slower cure
- thinner should be added after mixing the components

Induction time: None

Pot life: 2.5 hour at 20°C *
*see additional data

AIRLESS SPRAY

Recommended thinner	Thinner 21-06
Volume of thinner	0-5 %, depending on required thickness and application conditions
Nozzle orifice	approx. 0.44 – 0.49 mm (= 0.017 – 0.019 in)
Nozzle pressure	20MPa (= approx. 200 bar; 2800 p.s.i.)

AIR SPRAY

Recommended thinner	Thinner 21-06
Volume of thinner	10-15 %, depending on required thickness and application conditions
Nozzle orifice	1-1.5 mm
Nozzle pressure	0.3 – 0.4 MPa (= approx. 3 – 4 bar; 43 – 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner	Thinner 21-06
Volume of thinner	0 – 5 %

CLEANING SOLVENT

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 borne 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
- contains a toxic polyisocyanate curing agent
- avoid at all times inhalation of aerosol spray mist

ADDITIONAL DATA

Film thickness and spreading rate

Theoretical spreading rate m^2/l	9.0	6.8	4.5
dft in µm	75	100	150

Over coating table for SigmaDur products

substrate temperature	-5°C	0°C	5°C	20°C	30°C	40°C
minimum interval	36hours	24hours	16hours	8hours	6hours	4hours
maximum interval	unlimited					

- surface should be dry and free from any contamination

Curing table for dft up to100 µm

substrate temperature	touch dry	dry to handle
-5°C	24hours	40hours
0°C	15 hours	30 hours
10°C	5 hours	20 hours
20°C	3 hours	12 hours
30°C	2 hours	6 hours
40°C	1 hours	3 hours

- adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)

Pot life (at application viscosity)

10°C	4 hours
20°C	2.5hours
30°C	1.5hours
40°C	1 hours

Worldwide availability

Whilst it is always the aim of Sigma 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.

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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 products made by Sigma 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.

Sigma 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. Sigma 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.

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Yellow	1018262200
Black	8000002200