DESCRIPTION
Glass flake polyester coating

PRINCIPAL CHARACTERISTICS
- Meets the requirements of Norsok M-501 rev. 6, system 7A
- Excellent resistance to seawater immersion
- Resists many aggressive atmospheric environments
- Suitable for application on concrete on top of Sigmashield 4700
- Cures through a wide temperature range

COLOR AND GLOSS LEVEL
- Offwhite, light gray
- Flat

BASIC DATA AT 20°C (68°F)

<table>
<thead>
<tr>
<th>Data for mixed product</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Number of components</td>
<td>Two</td>
</tr>
<tr>
<td>Mass density</td>
<td>1.2 kg/l (10.0 lb/US gal)</td>
</tr>
<tr>
<td>Volume solids</td>
<td>100%</td>
</tr>
<tr>
<td>Recommended dry film thickness</td>
<td>300 - 850 µm (12.0 - 34.0 mils)</td>
</tr>
<tr>
<td>Theoretical spreading rate</td>
<td>2.7 m²/l for 300 µm (107 ft²/US gal for 12.0 mils)</td>
</tr>
<tr>
<td></td>
<td>0.9 m²/l for 850 µm (38 ft²/US gal for 34.0 mils)</td>
</tr>
<tr>
<td>Dry to touch</td>
<td>5 hours</td>
</tr>
<tr>
<td>Full cure after</td>
<td>7 days</td>
</tr>
<tr>
<td>Shelf life</td>
<td>Base: at least 12 months when stored cool and dry</td>
</tr>
<tr>
<td></td>
<td>Catalyst: at least 6 months when stored cool and dry</td>
</tr>
</tbody>
</table>

Notes:
- A film shrinkage up to 20% can be expected, due to the specific reaction mechanism and depending on conditions
- Frequent temperature cycles may shorten the shelf life
- See ADDITIONAL DATA – Overcoating intervals
- See ADDITIONAL DATA – Spreading rate and film thickness

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

Steel
- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile 50 – 75 µm (2.0 – 3.0 mils)
Coated concrete
- Suitable primer must be dry and free from any contamination

Substrate temperature and application conditions
- Substrate temperature during application and curing should be above 10°C (50°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 catalyst 98.5:1.5
- The reaction between the base component and catalyst is highly exothermic, deviation from the recommended mixing ratio should not be undertaken.
- Pre-mix base component with a pneumatic air mixer at moderate speeds to homogenize the container
- Add the catalyst while stirring the base
- Mix thoroughly before application

Pot life
1 hour at 20°C (68°F)
Note: The pot life will vary substantially with temperature

Application
- Never add any solvent
- Never add the catalyst without continuous stirring
- Never add more than the recommended amount of catalyst

Airless spray
- AIRLESS PUMP 45:1 or greater, fit leather or FPTE seals and remove fluid filters, 10 mm diameter (0.375 in) nylon-lined hoses, large-bore gun with 0.6 to 1.5 mm (0.024 to 0.059 in) reverse clean tip
- Typical tip size is 0.75 – 0.85 mm (0.030 – 0.033 in) with reverse clean and 45° fan
- The size of tip and fan pattern will vary with the nature of the work
- Pressure to suit hose lengths and working conditions (circa 200 bar)

Cleaning solvent
THINNER 50-02
SIGMASHIELD™ 4800

ADDITIONAL DATA

### Spreading rate and film thickness

<table>
<thead>
<tr>
<th>DFT</th>
<th>Theoretical spreading rate</th>
</tr>
</thead>
<tbody>
<tr>
<td>300 µm (12.0 mils)</td>
<td>2.7 m²/l (107 ft²/US gal)</td>
</tr>
<tr>
<td>600 µm (24.0 mils)</td>
<td>1.3 m²/l (53 ft²/US gal)</td>
</tr>
<tr>
<td>850 µm (34.0 mils)</td>
<td>0.9 m²/l (38 ft²/US gal)</td>
</tr>
</tbody>
</table>

### Overcoating interval for DFT up to 850 µm (34.0 mils)

<table>
<thead>
<tr>
<th>Overcoating with...</th>
<th>Interval</th>
<th>20°C (68°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>itself</td>
<td>Minimum</td>
<td>5 hours</td>
</tr>
<tr>
<td></td>
<td>Maximum</td>
<td>3 days</td>
</tr>
</tbody>
</table>

Notes:
- The maximum recoating time will reduce significantly at high temperature or in strong sunlight
- Please contact your PPG representative for more details

SAFETY PRECAUTIONS

- Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods
- Although this is a solvent-free paint, care should be taken to avoid inhalation of spray mist, as well as contact between the wet paint and exposed skin or eyes
- The catalyst of this product is supplied in small polythene bottles separately from the pigmented base component
- The catalyst of this product is an organic peroxide which is a highly reactive, combustible and thermally unstable substance that can undergo self-accelerating decomposition
- It is also a powerful oxidizing agent and will react violently with other organic chemicals
- It is thus recommended to keep in original containers, to hold within the predetermined temperature limits, to prevent contact/contamination with other materials, and to minimize the quantity at the workplace – only have enough present for the job in hand
- The waste of this product should be treated with special care; please contact your PPG representative for more details

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.
SIGMASHIELD™ 4800

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