

**SIGMATHERM 175****(SIGMARINE ALUMINIUM HR)**

3 pages

September 2005  
Revision of January 2003

<b>DESCRIPTION</b>	modified alkyd aluminum finish
<b>PRINCIPAL CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>– a high quality aluminum paint with an extensive range of applications for exposure in atmospheric conditions</li> <li>– high brilliancy</li> <li>– spray application improves the appearance</li> <li>– a minimum drying time of 3 days should be allowed before exposure to heat</li> <li>– heat resistant up to 347°F (175°C)</li> </ul>
<b>COLORS AND GLOSS</b>	aluminum - gloss
<b>BASIC DATA AT 68°F</b>	(8.25 lb/US gal = 1 g/cm <sup>3</sup> ; 40.7 ft <sup>2</sup> /US gal = 1 m <sup>2</sup> /l)
Mass density	8.34 lbs/gal (1.0 g/cm <sup>3</sup> )
Solids content	47 ± 2%
VOC (supplied - EPA 24)	max. 411 g/kg (Directive 1999/13/EC, SED) max. 3.5 lb/gal (approx. 417 g/l)
Recommended dry film thickness	1 mil (25 µm) per coat
Theoretical spreading rate	764 ft <sup>2</sup> /gal (18.8 m <sup>2</sup> /l) for 1 mil (25 µm)
Touch dry after	3 hours at 41 - 50°F (5 - 10°C), 1 hour at 68°F (20°C)
Overcoating interval	min. 36 hours at 5 - 10°C, 16 hours at 20°C max. unlimited
Shelf life (cool and dry place)	at least 12 months, longer storage period may affect the brilliancy
Flash point	100°F (38°C)
<b>RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES</b>	<ul style="list-style-type: none"> <li>– previous coat; dry and free from any contamination</li> <li>– substrate temperature should be at least 5°F (3°C) above dew point</li> </ul>
<b>SYSTEM SPECIFICATION</b>	for heat resistant systems - see system sheet 3140
<b>INSTRUCTIONS FOR USE</b>	<ul style="list-style-type: none"> <li>– stir well before use</li> <li>– the temperature of the paint should preferably be above 59°F (15°C), otherwise extra thinner may be required to obtain application viscosity</li> <li>– too much solvent results in reduced sag resistance</li> <li>– adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)</li> </ul>

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## AIRLESS SPRAY

Recommended thinner no thinner should be added  
 Nozzle orifice approx. 0.013" - 0.015" inch (= 0.33 - 0.38 mm)  
 Nozzle pressure 1700 - 2130 p.s.i. (= approx. 12 - 15 MPa; 120 - 150 bar)

## CONVENTIONAL SPRAY

Recommended thinner Sigma thinner 20-05  
 Volume of thinner 0 - 3%, depending on required thickness and application conditions  
 Nozzle orifice 0.070" - 0.078" inch (1.8 - 2 mm)  
 Nozzle pressure 43 - 57 p.s.i. (= approx. 0.3 - 0.4 MPa or 3 - 4 bar)

## BRUSH/ROLLER

Recommended thinner no thinner should be added

## CLEANING SOLVENT

Sigma thinner 20-05

## 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 vapor as well as contact between the wet paint and exposed skin or eyes

## 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

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## 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 therefore does 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.

In the event of any disparity or dispute in the wording of this document, the original English text shall prevail.

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