

1/3

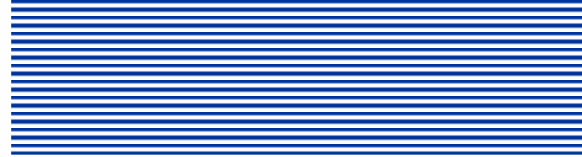
August 2002

I. Material description:

Type:	Primer and intermediate coat body color containing solvent, semi gloss.
Application:	Primer body color applied by dipping and flow coating for industrial processing of dimensional wooden elements.
Important features:	<ul style="list-style-type: none">- Used for Airless and Hot Airless spray application- Good hiding power- Uniform spreading- Suitable also for application with the use of a coating machine.- Quick drying- Possibility of obtaining a very thick coat- For further processing with water-thinnable and solvent-based painting coats
Color:	white, basis L / Z / B / Y (colored upon request)
Packaging unit:	10, 20, 60, 200 liters

II. Technical data:

Vehicle:	Alkyd resin
Density:	1.20 g/cm ³ (± 0.02) at 23°C
Solids content:	44 % (± 2.5) by volume
Dilution:	SIGMA 20-05 thinner or turpentine
Tool cleaning:	SIGMA 20-05 thinner or turpentine
Flash point (acc. to ISO 1523):	24°C.
Theoretical spread rate:	about 5 m ² /l with 200 µm (wet); 90 µm (dry) about 10 m ² /l with 100 µm (wet); 44 µm (dry) Max. coat thickness: 275 µm (wet); 120 µm (dry)
Storage:	In tightly closed original packaging, in a cool, dry and frost free room the minimum shelf life is 12 months.



Sigmalth A22

9372

2/3

August 2002

III. Application instructions:

Drying time (at 23°C and 50% relative air humidity):
 Dust dry: about 3 hours* (40 µm dry) /
 Non-tacky after: about 5 hours* (40 µm dry) /
 Dry to touch after: about 6 hours* (40 µm dry) /
 Dry for further treatment after: about 16 hours* (40 µm dry) /

* The drying time can be longer at lower temperatures or if the coats are thicker.

Dilution: 0 to 5 % SIGMA 20-05 thinner or turpentine

Application parameters: Airless / Airmix spray
 Dilution: : 0-5 % SIGMA 20-05 thinner or turpentine
 Nozzle size: 0.011 to 0.013 in (0.28 to 0.33 mm)
 Pressure: : about 120 bar (12 MPa)
 Temperature : over 5°C.

Hot Airless / Airmix spray
 Dilution: : 0-5 % SIGMA 20-05 thinner or turpentine
 Nozzle size: 0.011 to 0.013 in (0.28 to 0.33 mm)
 Pressure: : about 80 bar (8 MPa)
 Temperature : 40-60°C.

Quantity to be applied:	Wet µm	Dry µm	Consumption ml/m ² (no losses)
	about 100-200	about 44 - 90	about 100 -200

Application temperature: Do not apply at temperatures below 8°C (this refers to both substrate and ambient temperature). The drying time can be longer at lower temperatures. Max. air humidity 85%.

Substrate condition: The substrate must be dry and clean. Wood humidity should be between 11 and 17%.



3/3

August 2002

IV. Structure of coats:

Primer:	Sigmolith A22	Rustikal KP Extra	Sigmolith AK Dipprimer
Intermediate coat:	Sigmolith A22	Sigmolith A22	Sigmolith A22
Top coat:	Sigmolith AK Semigloss	Sigmolith AK Semigloss	Sigmolith AK Semigloss

Minimum coat thickness (total): 140 µm (dry)

When applying on coniferous wood or hardwood strength classes 3 to 5, a coat of Rustikal KP Extra should be applied as primer.

While coating wood with large pores, please remember to fill the pores thoroughly in order to prevent the outflow of wood mineral components.

Sigmolith A22: For further processing with water-thinnable and solvent-based painting coats:

Solvent-based: e.g. B. Sigma S2U gloss, Sigma S2U solid gloss

Water-thinnable: e.g. Sigmaluxe semigloss, Sigma S2U nova satin

V. Other information:

All data and guidelines concerning safety requirements and waste disposal should be obtained from current EU safety data sheets. Differences in the consumption of the material can result from substrate absorptivity differences and the material application method used.

Identification according to

Materials regulation: R 10 - flammable

Identification acc. to VbF: A II

Safety guidelines: S 51 - Use only in well ventilated rooms

S 23 - Do not breathe spray

S 38 - Use respirators, if ventilation is insufficient.

Please remember that pigment free and very light, transparent paints are not suitable for outdoor use due to higher UV transmittance.

The data contained herein reflect the state-of-the-art in technology. Due to the diversity of material application methods and areas of use no legal liability can be accepted. This publication cancels any data relating to this product contained in previous technical data sheets.

SIGMA COATINGS Farben- und Lackwerke GmbH

Klüsener Straße 54 • D-44805 Bochum • Telephone +49 (0) 234/869-461 • Fax +49 (0) 234/869-472