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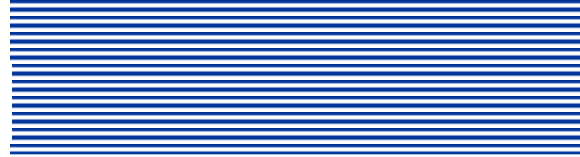
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I. Material description:

Type:	Water-thinnable primer applied by dipping and flow coating for body colors.
Application:	Wood body color primer containing water-soluble components.
Important features:	<ul style="list-style-type: none">- Insulating- Good spreading properties- Hydrophobic
Color:	white
Packaging unit:	20 liters 120 liters

II. Technical data:

Vehicle:	Modified alkyd resin
Density:	1.25 g/cm ³ (± 0.02) at 23°C
Solids content:	36 % (± 2.5) by volume
Dilution:	Tap water
Tool cleaning:	Tap water (if the material gets dry use thinner SIGMA 91-11)
pH value:	7.8 (± 0.5) at 23°C
Flash point (acc. to ISO 1523):	N.A.
Theoretical spread rate: (+ about 15 to 20 % water)	Dipping: about 12.5 m ² /l with 80 µm (wet); 6.4 µm (dry) 24 µm (dry) about 10 m ² /l with 100 µm (wet); 6.4 µm (dry) 30 µm (dry)
Theoretical spread rate: (undiluted)	Spraying: about 8.0 m ² /l with 125 µm (wet); 6.4 µm (dry) 45 µm (dry) about 6.7 m ² /l with 150 µm (wet); 55 µm (dry)
Storage:	In tightly closed original packaging, in a cool, dry and frost free room the minimum shelf life is 12 months.



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III. Application instructions:

Drying time (at 23°C and 50% relative air humidity)

Dust dry: about 2 hours
 Non-tacky after: about 4 hours
 Dry to recoat after: next day

Forced drying (at 35°C and 40% relative air humidity):

Dry for further treatment after: about 2.5 to 3 hours in a blow drier

Viscosity (20°C):

Flow coating/dipping: about 13 to 14 sec., 4 mm Ford viscosity cup
 (+ 15 to 20 % water) about 22 to 24 sec., 3 mm Ford viscosity cup

Spraying: undiluted

Quantity to be applied:

Method	Consumption ml/m ² (no losses)	Spreading rate m ² /l
Dipping/ Flow coating	about 80 to 100	about 10 to 12.5
Spraying	about 125 to 150	about 6.7 to 8

Spraying method:

Spraying	Pressure: bar	Nozzle size	
		mm	in
Airless / Airmix	90 - 120 (depending on spraying equipment)	0.23	0.009

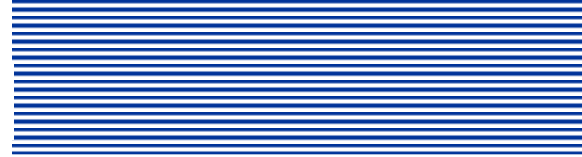
Application temperature:

Do not apply at temperatures below 15°C (this refers to both substrate and ambient temperature). The drying time can be longer at lower temperatures.
 Max. air humidity 75%.

Substrate condition:

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





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IV. Structure of coats:

Primer	Rustikal Concept Grund // Rustikal Concept Grund Konz.	Sigmalth Systema Primer	Rustikal WS Sealer
Intermediate coat:	Sigmalth Systema Primer	Sigmalth Systema Primer	Sigmalth Systema Primer
Top coat:	Sigmalth Systema Top // PA	Sigmalth Systema Top // PA	Sigmalth Systema Top // PA
Impregnation	Rustikal Concept Conditioner	-	Rustikal Concept Conditioner
Primer:	Rustikal Concept Grund // Rustikal Concept Grund Konz.	Sigmalth Systema Primer	-
Intermediate coat:	Sigmalth Systema Primer	-	Sigmalth Systema Primer
Top coat:	Sigmalth Systema Top // PA	Sigmalth Systema Top // PA	Sigmalth Systema Top // PA

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

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.

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.

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