



SIGMATHERM 540

3 pages

June 2012
Revision of April 2010

Description	one component heat resistant moisture curing silicone aluminium
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none"> – heat resistant up to 540°C on steel, grit blasted to ISO-Sa2½ – heat resistant up to 400°C on rusted steel, power tool cleaned to ISO-St3 – to be used for the internal and external protection of steel surfaces – no heat cure necessary between coats – excellent resistance against weathering – also suitable on top of zinc silicate primer – a minimum drying time of 3 days at 20°C should be allowed before exposure to heat
COLOURS AND GLOSS	aluminium – eggshell
BASIC DATA AT 20 °C	(1 g/cm ³ = 8.35 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal)
Mass density	1.1 g/cm ³
Volume solids	45% ± 2%
VOC (Directive 1999/13/EC, SED)	max. 427 g/kg (Directive 1999/13/EC, SED)
VOC (UK PG 6/23(92) appendix 3)	max. 478 g/l (approx. 4.0 lb/gal)
Recommended dry film thickness	25 µm
Theoretical spreading rate	18 m ² /l for 25 µm
Touch dry after	45 min. at 20 °C
Overcoating interval	min. 16 hours
Shelf life (cool and dry place)	at least 6 months
RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES	<ul style="list-style-type: none"> – steel; blast cleaned to ISO-Sa2½, blasting profile 40 - 70 µm – steel; pretreated according to ISO-St3 – suitable zinc silicate primer (e.g. SigmaZinc 158); dry and free from any contamination and zinc salts – substrate temperature should be at least 3°C above dew point
INSTRUCTIONS FOR USE	– power agitate to uniform consistency
AIR SPRAY	
Recommended thinner	no thinner should be added
Nozzle orifice	1.5 - 2 mm
Nozzle pressure	0.3 - 0.4 MPa (= approx. 3 - 4 bar; 44 - 58 p.s.i.)
BRUSH/ROLLER	For Roller application the best results will be obtained by using fine foam type rollers
CLEANING SOLVENT	Thinner 21-06

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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.

REFERENCES

Conversion labels	see information sheet 1410
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
Cleaning of steel and removal of rust	see information sheet 1490
Specification for mineral abrasives	see information sheet 1491
Relative humidity - substrate temperature - air temperature	see information sheet 1650

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

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