



Friazinc® R

Two Component Epoxy Zinc Rich Primer

Technical Data Sheet

DESCRIPTION

A two component low VOC epoxy based zinc rich primer of low solvent content containing 92.5% pure zinc granules. Also available in **Rapid** grade.


USES

- * Hydraulic structures
- * Pressure pipes
- * Chemical and petrochemical plants
- * Power stations
- * Highway structures
- * Heavily polluted industrial areas

ADVANTAGES

- * Fast drying
- * Inhibits under-rusting
- * Weldable (20 microns)
- * Suitable for immersion
- * Overpaintable
- * Resistant to barnacle attack
- * Low solvents
- * Excellent cohesion
- * Low temperature application (-10°C) available

Technical Data

Colour:	Grey Red tint available		
Finish:	Matt		
Density (SG):	2.8 kg/litre		
Volume solids:	67%		
Typical film thickness per coat:	20 - 80 microns dry 30 - 120 microns wet		
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point		
Coverage:	11 m ² /litre @ 60 microns dft		
Service temperature:	Max dry heat +180°C Max damp heat +50°C		
Method of Application:	Airless spray		
Drying times:	10°C	20°C	
Hard dry:	60 mins	30 mins	
Overcoating:			
Min (hours)	-	24 (4 hrs - Rapid grade)	
Max (weeks)	-	Unlimited	
Mix ratio: (A:B)	94:6 by wt		
No of coats:	Without finishing coats 2 x Friazinc R . Primer 1 x Friazinc R . Welding primer. 1 x Friazinc R @ 20 microns dft.		
Pot life: (hours)	10°C	20°C	30°C
	8	5	2
VOC:	251 g/litre		
Flashpoint:	Pt A 26°C Pt B 87°C		

All above values are approximate.

SURFACE PREPARATION

The surface to be coated should be dry and free from contaminants. Prior to painting all surfaces should be assessed in accordance with ISO 8504:1992.

Oil and grease to be removed according to SSPC-SP1 solvent cleaning.

Abrasive blast cleaning:

Prepare to SA2½ (ISO 12944 Pt 4).

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 90 - 150 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.66 mm (15 - 26 thou)
Spray angle 40°-80°
Output fluid pressure at tip
Min (170 kg/cm²) (2560 psi)

Brush: Not recommended except for small areas of repair or touch up.

Roller: Not recommended.

THINNING

For weldable shop coating add approx 15% by wt of **Sika® Thinner K**. Max 3% by wt of general thinning.

IMPORTANT CONSIDERATIONS

- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Sika Thinner K**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 11 m²/litre @ 60 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 12 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).



Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Please consult our Technical Sales Department for further information

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Icosit® Aktiv Primer

Zinc Phosphate Primer

Technical Data Sheet

DESCRIPTION

Icosit Aktiv Primer is a one component, high solid, fast drying, zinc phosphate primer based on mild solvent.


USES

- * Most industrial plant.
- * Water and sewage industry.
- * Chemical industry.
- * Bridges.
- * Maintenance primer.
- * Petrochemical plants.

ADVANTAGES

- * Fast drying with high film thicknesses.
- * Suitable for hand de-rusted surfaces.
- * Suitable for overcoating with one or two component top coats.
- * Compatible with most existing coatings.
- * Excellent wetting properties onto poorly prepared substrates.
- * Pigmented with zinc phosphate, anti corrosive pigments to comply with BS 5493:1977.

Technical Data

Colour:	Oxide red, sand yellow	
Finish:	Matt	
Density (SG):	1.5 kg/litre	
Volume solids:	54%	
Typical film thickness per coat:	60 - 100 microns dry	110 - 185 microns wet
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point	
Coverage:	9 m ² /litre @ 60 microns dft	
Service temperature:	Max dry heat +80°C Max damp heat +50°C	
Method of Application:	Airless spray, brush or roller	
Drying times:	10°C	20°C 
Touch dry (mins):	60	30
Hard dry (hours):	6	4
Overcoating:		
Min (hours)	-	24
Max (weeks)	-	Indefinite
Overcoating (2 pack):		
Min (hours)	-	72
No of coats:	1 - 2	
In accordance with ISO 12 944 Pt 5		
VOC:	356 g/litre	
Flashpoint:	35°C	

All above values are approximate.

SURFACE PREPARATION

The surface to be coated should be dry and free from contaminants. Prior to painting all surfaces should be assessed in accordance with ISO 8504:1992.

Oil and grease to be removed according to SSPC-SP1 solvent cleaning.

Hand tool preparation:

Prepare to a minimum standard of St 2 (ISO 12944 Pt 4) or SSPC-SP2. All scale must be removed.

Abrasive blast cleaning:

Prepare to SA1 (ISO 12944 Pt 4) or SSPC-SP7.

MIXING

Stir thoroughly before use. DO NOT THIN.

APPLICATION

Airless spray: Typically 100 - 185 microns per coat wft on vertical surfaces

Tip range 0.45 - 0.58 mm (18 - 23 thou)
Output fluid pressure at tip
Min (170 kg/cm²) (2000 psi)

Brush: Typically 75 - 150 microns per coat wft on vertical surfaces

Roller: Typically 75 - 150 microns per coat wft on vertical surfaces

THINNING

Use **Sika® Thinner B** up to 5% by wt in cold weather.

IMPORTANT CONSIDERATIONS

- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Sika Thinner B**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 9 m²/litre @ 60 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).





Icosit® Poxicolor Primer

Epoxy Primer

Technical Data Sheet

DESCRIPTION

Icosit Poxicolor Primer is a low VOC, high solid, two component epoxy combination primer for steel and galvanized structures.

USES

- * Bridges.
- * Pipelines.
- * Marine structures.
- * Industrial plant.
- * Water and sewage treatment plant.
- * Duplex coating for new/weathered galvanized structures.

ADVANTAGES

- * Low VOC.
- * High solids.
- * Economical high build priming system.
- * High chemical resistance.
- * Low solvent content.
- * Highly flexible primer.
- * Does not require 'T' wash or etch primer when applied to new/weathered galvanized substrates.

Technical Data

Colour:	Red brown	
Finish:	Matt	
Density (SG):	1.6 kg/litre	
Volume solids:	70%	
Typical film thickness per coat:	100 - 125 microns dry	140 - 180 microns wet
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point	
Coverage:	7 m ² /litre @ 100 microns dft	
Service temperature:	Max dry heat +150°C Max damp heat +80°C	
Method of Application:	Airless spray, brush or roller	
Drying times:	Overcoatable at 20°C after an overnight wait.	
Mix ratio: (A:B)	88:12 by wt	
No of coats:	1 coat @ 100 microns dft	
In accordance with ISO 12 944 Pt 5		
Pot life: (hours)	20°C 8	30°C 5
VOC:	196 g/litre	
Flashpoint:	Pt A 23°C Pt B 25°C	

All above values are approximate.

SURFACE PREPARATION

The surface to be coated should be dry and free from contaminants. Prior to painting all surfaces should be assessed in accordance with ISO 8504:1992.

Oil and grease to be removed according to SSPC-SP1 solvent cleaning.

Hand tool preparation:

Prepare to a minimum standard of St 2 (ISO 12944 Pt 4) or SSPC-SP2. All scale must be removed.

Abrasive blast cleaning:

Prepare to SA2 (ISO 12944 Pt 4) or SSPC-SP7.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 140 - 180 microns per coat wft on vertical surfaces

Tip range 0.48 - 0.58 mm (19 - 23 thou)
Output fluid pressure at tip
Min (211 kg/cm²) (3000 psi)

Brush: Typically 100 - 150 microns per coat wft on vertical surfaces

Roller: Typically 100 - 150 microns per coat wft on vertical surfaces

THINNING

If necessary, during application by pressure pot spraying, thin to a maximum of 5% with **Sika**® Thinner EG.

IMPORTANT CONSIDERATIONS

- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Sika Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 7 m²/litre @ 100 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).



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Icosit[®] Poxicolor Primer HE

Surface Tolerant Primer

Technical Data Sheet

DESCRIPTION

Icosit Poxicolor Primer HE is a low VOC, two component, surface tolerant, aluminium epoxy primer.

USES

- * As a plant maintenance coating where abrasive blast cleaning is not possible.
- * Bridges.
- * Chemical engineering plant.
- * Coastal structures.
- * Paper mills.

ADVANTAGES

- * Low VOC.
- * Low solvent content.
- * High volume solids.
- * Excellent wetting and barrier properties onto hand de-rusted steel.
- * Ideal for use in conjunction with wet abrasive blasting.
- * Highly economical barrier coating.

Technical Data

Colour:	Aluminium grey	
Finish:	Matt	
Density (SG):	1.2 kg/litre	
Volume solids:	71%	
Typical film thickness per coat:	75 - 125 microns dry	105 - 176 microns wet
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point	
Coverage:	9.5 m ² /litre @ 75 microns dft	
Method of Application:	Airless spray, brush or roller	
Overcoating times:	Allow an overnight cure between primer and finish coats.	
Mix ratio: (A:B)	89:11 by wt	
No of coats:	1 - 2	
	In accordance with ISO 12 944 Pt 5	
Pot life: (hours)	20°C 8	30°C 5
VOC:	230 g/litre	
Flashpoint:	Pt A 39°C Pt B 35°C	

All above values are approximate.

SURFACE PREPARATION

The surface to be coated should be dry and free from contaminants. Prior to painting all surfaces should be assessed in accordance with ISO 8504:1992.

Oil and grease to be removed according to SSPC-SP1 solvent cleaning.

Hand tool preparation:

Prepare to a minimum standard of St 2 (ISO 12944 Pt 4) or SSPC-SP2. All scale must be removed.

Abrasive blast cleaning:

Prepare to SA2½ (ISO 12944 Pt 4) or SSPC-SP6.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 105 - 175 microns per coat wft on vertical surfaces

Tip range 0.48 - 0.58 mm (19 - 23 thou)
Output fluid pressure at tip
Min (210 kg/cm²) (3000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

Not usually required. If necessary in cold weather or when spraying with pressure pot use **Sika® Thinner EG** up to 5% by wt.

IMPORTANT CONSIDERATIONS

- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Sika Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 9.5 m²/litre @ 75 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit[®] EG Phosphate

Epoxy Zinc Phosphate Primer

Technical Data Sheet

DESCRIPTION

Icosit EG Phosphate is a low VOC two component, fast drying, low temperature curing, epoxy zinc phosphate primer. Also available in **Rapid** grade.

USES

- * Bridges.
- * Chemical plants.
- * Oil refineries.
- * Coastal structures.
- * Rapid turnaround maintenance painting.
- * High production fabrication shops.

ADVANTAGES

- * Low VOC.
- * Application down to -10°C substrate.
- * Rapid overcoating properties.
- * Low solvent content.
- * High temperature resistance (150°C).
- * Excellent barrier protection.
- * Three applications in one day.

Technical Data

Colour:	Sand yellow/red brown		
Finish:	Matt		
Density (SG):	1.6 kg/litre		
Volume solids:	62%		
Typical film thickness per coat:	75 - 125 microns dry 120 - 200 microns wet		
Application temperatures & humidity conditions:	-10°C minimum (substrate) +3°C (5°F) above the dew point		
Coverage:	8.2 m ² /litre @ 75 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +80°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	0°C	10°C	20°C
EG Phosphate			
Touch dry	-	1 hour	15 mins
Hard dry	-	10 hours	3 hours
EG Phosphate Rapid			
Touch dry	2 hours	30 mins	10 mins
Hard dry	10 hours	4 hours	1hr 30 mins
Mix ratio: (A:B)	90:10 by wt		
No of coats:	1		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	10°C	20°C	30°C
	8	5	2
VOC:	283 g/litre		
Flashpoint:	Pt A 23°C Pt B 32°C		

All above values are approximate.

SURFACE PREPARATION

The surface to be coated should be dry and free from contaminants. Prior to painting all surfaces should be assessed in accordance with ISO 8504:1992.

Oil and grease to be removed according to SSPC-SP1 solvent cleaning.

Hand tool preparation:

Prepare to a minimum standard of St 2 (ISO 12944 Pt 4) or SSPC-SP2. All scale must be removed.

Abrasive blast cleaning:

Prepare to SA2½ (ISO 12944 Pt 4) or SSPC-SP6.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 120 - 300 microns per coat wft on vertical surfaces

Tip range 0.45 - 0.58 mm (18 - 23 thou)
Output fluid pressure at tip
Min (170 kg/cm²) (2500 psi)

Brush: Typically 80 - 100 microns per coat wft on vertical surfaces

Roller: Typically 80 - 100 microns per coat wft on vertical surfaces

THINNING

Not usually required. If necessary in cold weather or high pressure spray, use **Sika® Thinner EG** at up to 5% by wt.

IMPORTANT CONSIDERATIONS

- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas
- * Surface temperature must always be +3° above dew point.

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8.2 m²/litre @ 75 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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Icosit® 5530/5530 EG

PVC-Acryl Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit 5530/5530 EG is a one component, thixotropic, PVC-acryl finish coat for steel and galvanized surfaces.

USES

- * Maintenance coating for bridges, pipelines, masts, gates etc.
- * Duplex coating for new/weathered galvanized structures.
- * Maintenance coating for PVC cladding.

ADVANTAGES

- * High film thickness.
- * Excellent barrier protection.
- * Excellent adhesion direct to aluminium structures.
- * Does not require 'T' wash or etch primer primer when applied to new/weathered galvanized substrates.
- * Direct application to aluminium and PVC substrates.

Technical Data

Colour:	Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Refer to Sika standard colour shade chart.		
Finish:	Eggshell		
Density (SG):			
Icosit 5530	1.3 kg/litre		
Icosit 5530 EG	1.4 kg/litre		
Volume solids:	50%		
Typical film thickness per coat:	75 - 85 microns dry 150 - 170 microns wet		
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point		
Coverage:	6.6 m ² /litre @ 75 microns dft		
Method of Application:	Airless spray, brush or roller		
Drying times:	10°C	20°C	30°C
Touch dry (hours):	2	1	0.5
Overcoating:			
Min (hours)	-	5	3
Max (weeks)	-----	Indefinite	-----
No of coats:	2		
In accordance with ISO 12 944 Pt 5			
VOC:	434 g/litre		
Flashpoint:	23°C		
All above values are approximate.			

SURFACE PREPARATION

Coated surfaces:

Icosit 5530/5530 EG is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Stir thoroughly before use. DO NOT THIN.

APPLICATION

Airless spray: Typically 100 - 300 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.45 mm (15 - 18 thou)
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 75 - 150 microns per coat wft on vertical surfaces

Roller: Typically 75 - 150 microns per coat wft on vertical surfaces

THINNING

DO NOT THIN. The material is designed to be thixotropic and is not intended to be brushed out as an alkyd or conventional decorative coating.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas
- * Apply a small test area for compatibility onto unknown existing coatings.

CLEANING OF EQUIPMENT

Use **Thinner C**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 6.6 m²/litre @ 75 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).



Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® 6630

Polyurethane Alkyd Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit 6630 is a low VOC, one component, high build polyurethane alkyd coating for steel and galvanized structures.

USES

- * Duplex coating of galvanized masts, towers, gates etc.
- * Maintenance coating for bridges, towers, masts etc.
- * High build corrosion protection for pipelines etc.
- * Maintenance/new coating for street furniture.

ADVANTAGES

- * Low VOC.
- * Very mild solvent, suitable for maintenance painting over unknown single component paints.
- * Direct site application to new hot dip galvanized structures.
- * Excellent colour retention.
- * Excellent weathering properties and corrosion protection.
- * Excellent weathering properties.
- * Does not require 'T' wash or etch primer primer when applied to new/weathered galvanized substrates.

Technical Data

Colour:	Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Refer to Sika standard colour shade chart.	
Finish:	Eggshell	
Density (SG):	1.4 kg/litre	
Volume solids:	63%	
Typical film thickness per coat:	80 - 100 microns dry 127 - 160 microns wet	
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point	
Coverage:	8 m ² /litre @ 80 microns dft	
Service temperature:	Max dry heat +80°C Max damp heat +50°C	
Method of Application:	Airless spray, brush or roller	
Drying times:	20°C	30°C
Touch dry (mins):	60	30
Hard dry (hours):	24	18
Overcoating:		
Min (hours)	24	24
Max (weeks)		unlimited
No of coats:	2	
In accordance with ISO 12 944 Pt 5		
VOC:	299 g/litre	
Flashpoint:	34°C	
All above values are approximate.		

SURFACE PREPARATION

Coated surfaces:

Icosit 6630 is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Stir thoroughly before use. DO NOT THIN.

APPLICATION

Airless spray: Typically 100 - 300 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.66 mm (15 - 25 thou)
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

DO NOT THIN. **Icosit 6630** is a high build, thixotropic coating and when applying by either airless spray, brush or roller, thinning is not necessary.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner B**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8 m²/litre @ 80 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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Icosit® EG1

MIO Epoxy Intermediate/Primer

Technical Data Sheet

DESCRIPTION

Icosit EG1 is a two component epoxy resin system containing micaeous iron oxide providing a high build chemically and abrasion resistant coating direct to new or weathered galvanized and an intermediate coating for steel.

USES

- * Bridges.
- * Submerged/non submerged structures.
- * Harbour and port facilities.
- * Water and sewage treatment.
- * General fabrication.
- * Street furniture.

ADVANTAGES

- * Direct application to new or weathered galvanized structures.
- * Fast drying.
- * High build intermediate coating .
- * Highly abrasion/chemical resistant travel coats.
- * Three coat system application possible within one working day.
- * Does not require 'T' wash or etch primer when applied direct to new or weathered galvanized substrates.

Technical Data

Colour:	Several shades of grey/white		
Finish:	Matt		
Density (SG):	1.6 kg/litre		
Volume solids:	65%		
Typical film thickness per coat:	80 - 100 microns dry 123 - 153 microns wet		
Application temperatures & humidity conditions:	+5°C minimum (substrate) +3°C (5°F) above the dew point		
Coverage:	8 m ² /litre @ 80 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +50°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	10°C	20°C	30°C
Touch dry:	1.5 hours	45 mins	20 mins
Hard dry:	8 hours	6 hours	3 hours
Overcoating:			
Max	3 months	3 months	3 months
Mix ratio: (A:B)	94.7:5.3 by wt		
No of coats:	1 - 2		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	10°C	20°C	30°C
	12	8	5
VOC:	347 g/litre		
Flashpoint:	Pt A 23°C Pt B 32°C		

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit EG1 is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 140 - 200 microns per coat wft on vertical surfaces

Tip range 0.33 - 0.43 mm (13 - 17 thou)
Spray angle 20° - 30°C
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 100 - 150 microns per coat wft on vertical surfaces

Roller: Typically 100 - 150 microns per coat wft on vertical surfaces

THINNING

Not recommended unless ambient temperature is below 15°C when up to 5% by volume of **Thinner EG** may be added. Full atomisation should be obtainable using the correct proprietary airless spray equipment without thinning.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8 m²/litre @ 80 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 12 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® EG1 Rapid

MIO Epoxy Intermediate/Primer

Technical Data Sheet

DESCRIPTION

Icosit EG1 Rapid is a fast curing, two component epoxy resin system containing micaeous iron oxide for low temperatures, providing a high build chemically and abrasion resistant coating direct to new or weathered galvanized and an intermediate coating for steel.

USES

- * Bridges.
- * Submerged/non submerged structures.
- * Harbour and port facilities.
- * Water and sewage treatment.
- * General fabrication.
- * Street furniture.

ADVANTAGES

- * Direct application to new or weathered galvanized structures.
- * Low temperature/fast track application for production.
- * Application down to 0°C (-10°C substrate).
- * Extremely fast drying.
- * High build intermediate coating .
- * Highly abrasion/chemical resistant travel coats.
- * Three coat system application possible within one working day.
- * Does not require 'T' wash or etch primer when applied to new/weathered galvanized substrates.

Technical Data

Colour:	Several shades of grey/white		
Finish:	Matt		
Density (SG):	1.6 kg/litre		
Volume solids:	60%		
Typical film thickness per coat:	80 - 100 microns dry 135 - 165 microns wet		
Application temperatures & humidity conditions:	-10°C minimum (substrate) +3°C (5°F) above the dew point		
Coverage:	8 m ² /litre @ 80 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +50°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	0°C	10°C	20°C
Touch dry:	3 hours	45 mins	20 mins
Hard dry:	12 hours	5 hours	3 hours
Overcoating:			
Max	3 months	3 months	3 months
Mix ratio: (A:B)	94.7:5.3 by wt		
No of coats:	1 - 2		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	0°C	10°C	20°C
	9	7	5
VOC:	347 g/litre		
Flashpoint:	Pt A 23°C Pt B 32°C		

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit EG1 Rapid is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 140 - 200 microns per coat wft on vertical surfaces

Tip range 0.33 - 0.43 mm (13 - 17 thou)
Spray angle 20° - 30°C
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 100 - 150 microns per coat wft on vertical surfaces

Roller: Typically 100 - 150 microns per coat wft on vertical surfaces

THINNING

Not recommended unless ambient temperature is below 15°C when up to 5% by volume of **Thinner EG** may be added. Full atomisation should be obtainable using the correct proprietary airless spray equipment without thinning.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8 m²/litre @ 80 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 12 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® EG4

Polyurethane MIO Finishing Coat

Technical Data Sheet

DESCRIPTION

A MIO pigmented two component polyurethane finish for steel and galvanized substrates.

USES

- * Duplex system for galvanizing.
- * Bridges.
- * Pipelines.
- * Street furniture.
- * Coastal structures.
- * Chemical, petrochemical and paper industries.

ADVANTAGES

- * Fast curing grade available*
- * Application down to -10°C (substrate).
- * Excellent UV light resistance.
- * Excellent chemical, impact and abrasion resistance.
- * Component part for Duplex coating system for galvanizing.
- * Temperature resistant to 150°C.

Technical Data

Colour:	Available in a selection of MIO colour shades. Refer to Sika standard colour shade chart.			
Finish:	Matt			
Density (SG):	1.4 kg/litre			
Volume solids:	55%			
Typical film thickness per coat:	75 - 90 microns dry 135 - 165 microns wet			
Application temperatures & humidity conditions:	-10°C substrate minimum (accelerated grade) +3°C (5°F) above the dew point			
Coverage:	7.3 m ² /litre @ 75 microns dft			
Service temperature:	Max dry heat +150°C Max damp heat +80°C			
Method of Application:	Airless spray, brush or roller			
Drying times:	0°C	10°C	20°C	30°C
Hard dry: (hours)	-	18	12	3
(accelerated hours)	48	12	4	2
Overcoating: Max (years)	4	4	4	4
Mix ratio: (A:B)	92:8 by wt			
No of coats:	1 finish coat for galvanized substrates In accordance with ISO 12 944 Pt 5			
Pot life:	0°C	10°C	20°C	30°C
(hours)	-	7	5	4
(accelerated hours)	8	5	3	2
VOC:	391 g/litre			
Flashpoint:	Pt A 24°C Pt B 35°C			

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit EG4 is an finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 135 - 165 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.53 mm (13 - 17 thou)
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

If necessary add up to 5% **Thinner EG**.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 7.3 m²/litre @ 75 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Fast curing grade

- * Add 1% by weight (of the complete two component unit) of **Icosit Pur Accelerator** to component B before completely mixing component B into component A.

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® EG5

Polyurethane Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit EG5 is a high gloss, two component, fast drying polyurethane finish for steel and galvanized substrates.

USES

- * Duplex system for galvanizing.
- * Bridges.
- * Pipelines.
- * Street furniture.
- * Coastal structures.
- * Chemical, petrochemical and paper industry.
- * Fast curing finish coat for fast track production shops.

ADVANTAGES

- * Application down to -10°C substrate (accelerated grade).
- * Excellent UV resistance.
- * Fast curing grade available*
- * Excellent impact and chemical resistance.
- * Component part for Duplex coating system for galvanizing.
- * Temperature resistant to +150°C.
- * High solids economical finish coating.

Technical Data

Colour:	Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Refer to Sika standard colour shade chart.			
Finish:	High Gloss			
Density (SG):	1.3 kg/litre			
Volume solids:	57%			
Typical film thickness per coat:	60 - 80 microns dry 105 - 140 microns wet			
Application temperatures & humidity conditions:	-10°C substrate minimum (accelerated grade) +3°C (5°F) above the dew point			
Coverage:	8.1 m ² /litre @ 70 microns dft			
Service temperature:	Max dry heat +150°C Max damp heat +100°C			
Method of Application:	Airless spray, brush or roller			
Drying times:	0°C	10°C	20°C	30°C
Hard dry: (hours)	-	20	12	3
(accelerated hours)	48	13	5	2
Overcoating: Max (Years)	4	4	4	4
Mix ratio: (A:B)	90:10 by wt			
No of coats:	1 finish coat for galvanized substrates In accordance with ISO 12 944 Pt 5			
Pot life:	0°C	10°C	20°C	30°C
(hours)	-	12	8	5
(accelerated hours)	10	8	5	2
VOC:	337 g/litre			
Flashpoint:	Pt A 23°C Pt B 38°C			

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit EG5 is a finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 105 - 140 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.53 mm (13 - 17 thou)
Min (141 kg/cm²) (2000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

If necessary to atomise add up to 5% **Sika**® Thinner EG.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8.1 m²/litre @ 70 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Fast curing grade

- * Add 1% by weight (of the complete two component unit) of **Icosit PUR Accelerator** to component B before completely mixing component B into component A.

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® EG120

One Coat Polyurethane Finishing

Technical Data Sheet

DESCRIPTION

Icosit EG120 is a low VOC, low solvent, high gloss two component polyurethane for direct application to galvanized or steel structures.

USES

- * One coat Duplex system for new hot dip galvanized structures.
- * One coat application to structural steel.
- * Marine and offshore corrosion protection.
- * Corrosion protection of bridges, pipelines etc.

ADVANTAGES

- * 120 microns dft in one application.
- * Low VOC.
- * Low solvent.
- * Exceptional UV resistance.
- * Solid and mio coloured finishes.
- * Does not require 'T' wash or etch primer when applied to new/weathered galvanized substrates.

Technical Data

Colour: Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Also DB MIO colours. Refer to Sika standard colour shade chart.

Finish: High Gloss/Matt MIO grades

Density (SG): 1.4 kg/litre - solid colours
1.7 kg/litre - MIO colours

Volume solids: 67%

Typical film thickness per coat: 110 - 130 microns dry
165 - 195 microns wet

Application temperatures & humidity conditions: +5°C minimum (substrate and ambient)
+3°C (5°F) above the dew point

Coverage: 5.6 m²/litre @ 120 microns dft

Service temperature: Max dry heat +150°C

Method of Application: Airless spray, brush or roller

Drying times:	10°C	20°C	30°C
Hard dry (hours):	14	11	3
Overcoating: Min (hours)	-----12-----		

Mix ratio: (A:B) 85:15 by wt solid colours
90:10 by wt MIO colours

No of coats: 1 - 2
In accordance with ISO 12 944 Pt 5

Pot life: (hours)	10°C	20°C	30°C
	3	2	1

VOC: 208 g/litre

Flashpoint: Pt A 32°C
Pt B 38°C

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit EG120 is a finishing coat which may be applied directly onto steel, blastcleaned to SA 2.5 according to ISO 129 44 Pt 4.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 110 - 130 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.53 mm (15 - 23 thou)
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 90 - 100 microns per coat wft on vertical surfaces (best optical results will be achieved by airless spray).

Roller: Typically 90 - 100 microns per coat wft on vertical surfaces (best optical results will be achieved by airless spray).

THINNING

Thinner with **Sika Thinner EG** up to 5% may be necessary to improve atomisation.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 5.6 m²/litre @ 120 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Icosit® Poxicolor

Epoxy Combination Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit Poxicolor is a low VOC, two component, high solids, epoxy combination finishing coat for steel and galvanized structures.

USES

- * Bridges.
- * Coastal structures.
- * Sewage treatment plants.
- * Highway structures.
- * Pipelines.

ADVANTAGES

- * Low VOC.
- * Low solvent.
- * High solids - economical coating.
- * Duplex system for galvanized structures.
- * Fast curing.
- * Excellent corrosion protection.
- * Does not require 'T' wash or etch primer when applied to new/weathered galvanized substrates.

Technical Data

Colour:	Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Refer to Sika standard colour shade chart.		
Finish:	Eggshell		
Density (SG):	1.6 kg/litre		
Volume solids:	76%		
Typical film thickness per coat:	100 - 120 microns dry 130 - 155 microns wet		
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point		
Coverage:	7.6 m ² /litre @ 100 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +80°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	10°C	20°C	30°C
Hard dry (hours):	6	4	1
Overcoating:			
Min (hours)	24	24	24
Max (weeks)	----- unlimited -----		
Mix ratio: (A:B)	88:12 by wt		
No of coats:	1 - 2		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	20°C	30°C	
	8	5	
VOC:	200 g/litre		
Flashpoint:	Pt A 25°C Pt B 35°C		

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit Poxicolor is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 130 - 150 microns per coat wft on vertical surfaces

Tip range 0.42 - 0.53 mm (15 - 23 thou)
Output fluid pressure at tip
Min (212 kg/cm²) (2000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

Depending on ambient temperature addition of up to 5% of **Sika Thinner EG** may be required to improve atomisation.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 7.6 m²/litre @ 100 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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Icosit[®] Poxicolor Rapid

Fast Cure Epoxy Intermediate Coat

Technical Data Sheet

DESCRIPTION

Icosit Poxicolor Rapid is a two component, epoxy resin, fast curing system providing a high build chemically and abrasion resistant coating. It can be applied direct to new or weathered hot dip galvanized or steel structures without conventional etch-priming systems.

USES

- * Duplex coating for fabrication and paint shop fast production.
- * Low temperature site application.
- * Coastal corrosion protection.
- * Chemical, petrochemical works.
- * Water and sewage plant maintenance painting.

ADVANTAGES

- * Low temperature curing.
- * Application at 0°C (-10°C substrate).
- * Duplex coating direct to galvanized surfaces.
- * Does not require 'T' wash or etch primer.
- * Low VOC.
- * Low solvent.
- * Three applications in one day.
- * Economical due to high solids content.

Technical Data

Colour:	Light grey Light green		
Finish:	Matt		
Density (SG):	1.62 kg/litre		
Volume solids:	66%		
Typical film thickness per coat:	75 - 100 microns dry 113 - 150 microns wet		
Application temperatures & humidity conditions:	-10°C minimum (substrate) +3°C (5°F) above the dew point		
Coverage:	8.25 m ² /litre @ 80 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +80°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	0°C	10°C	20°C
Hard dry (hours):	6	5	3
Overcoating:			
Min (hours)	6	4	2
Max (weeks)	4	4	4
Mix ratio: (A:B)	89:11 by wt		
No of coats:	1 coat direct to galvanized followed by 1 or 2 finishing coats.		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	10°C	20°C	
	8	6	
VOC:	263 g/litre		
Flashpoint:	Pt A 35°C Pt B 25°C		

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit Poxicolor Rapid is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika**® Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 75 - 100 microns per coat wft on vertical surfaces

Tip range 0.48 - 0.66 mm (15 - 19 thou)
Output fluid pressure at tip
Min (212 kg/cm²) (2000 psi)

Brush: Typically 60 - 75 microns per coat wft on vertical surfaces

Roller: Typically 60 - 75 microns per coat wft on vertical surfaces

THINNING

Not recommended unless ambient temperature is below 15°C when up to 5% by volume of **Thinner EG** may be added. Full atomisation should be obtainable using the correct proprietary airless spray equipment without thinning.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8.25 m²/litre @ 80 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Inertol® Poxitar® F

Epoxy Tar Oil Finishing Coat

Technical Data Sheet

DESCRIPTION

Inertol Poxitar F is a two component, low VOC, very high solids epoxy tar oil coating for steel and concrete.

USES

- * Heavy duty corrosion protection of most marine steel and concrete structures.
- * Sewage treatment corrosion protection.
- * Bridges.
- * Tunnels.
- * Hydro electric structures.
- * Chemical industry.

ADVANTAGES

- * Low VOC.
- * Suitable for application to damp concrete or steel structures.
- * High chemical resistance.
- * Good abrasion and impact resistance.
- * Resistant to permanent submersion in sea water.

Technical Data

Colour:	Black/red brown		
Finish:	Eggshell		
Density (SG):	1.8 kg/litre		
Volume solids:	87%		
Typical film thickness per coat:	140 - 170 microns dry	172 - 195 microns wet	
Application temperatures:	+5°C minimum (substrate and ambient)		
Coverage:	6 m ² /litre @ 150 microns dft		
Service temperature:	Max dry heat +100°C Max damp heat +80°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	10°C	20°C	30°C
Overcoating:			
Min (hours)	30	12	6
Max (hours)	72	48	24
Mix ratio: (A:B)	85:15 by wt		
No of coats:	2 - 3		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	1.5 hours @ 20°C		
VOC:	307 g/litre		
Flashpoint:	Pt A 66°C Pt B 23°C		

All above values are approximate.

SURFACE PREPARATION

Concrete:

Remove cement laitance by sweep blasting or equivalent to improve adhesion. Cavities must be filled/levelled before use with **SikaDur® 31**.

Steel:

Blastclean to SA 2.5 according to ISO 129 44 Pt 4.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika®** Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 170 - 195 microns per coat wft on vertical surfaces

Tip range 0.58 - 0.66 mm (19 - 25 thou)
Output fluid pressure at tip
Min (170 kg/cm²) (2500 psi)

Brush: Typically 100 - 150 microns per coat wft on vertical surfaces

Roller: Typically 100 - 150 microns per coat wft on vertical surfaces

THINNING

Depending on ambient temperature, up to 5% of **Sika Thinner C** may be necessary for atomisation. This reduces immediate exposure to water. If immediate exposure to water is required, it is recommended that atomisation is achieved by pressure and tip size adjustments.

IMPORTANT CONSIDERATIONS

- * Apply in ventilated areas
- * Do not exceed the maximum overcoating times. Should this be unavoidable consider using **Inertol Poxitar G**.

CLEANING OF EQUIPMENT

Use **Thinner C**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 6 m²/litre @ 150 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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