BUILDING TRUST

PRODUCT DATA SHEET

Sika Poxicolor® Primer HE NEW

HIGH SOLID, SURFACE-TOLERANT EPOXY PRIMER COAT FOR STEEL AND GALVANIZED SURFACES

DESCRIPTION

2-pack primer coat based on epoxy resin.
Economically and high-performance corrosion protection also for manually de-rusted surfaces and surfaces prepared by high-pressure water jetting.
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

Sika Poxicolor® Primer HE NEW may only be used by experienced professionals.

Tough hard, versatile overcoatable primer for corrosion protection on steel exposed to atmosphere. Especially suitable for use on surfaces where only manually de-rusting (wirebrushing or power tool cleaning) or high-pressure water jetting is feasible or economic.

CHARACTERISTICS / ADVANTAGES

- Surface tolerant
- High layer thickness and diffusion resistance combined with very good surface wetting properties and adhesion result in a very high safety margin for good corrosion protection
- Fast initial drying and full hardening
- High-build application
- Very economically due to high coverage

APPROVALS / CERTIFICATES

- Approved according to German standard 'TL/TP-KOR-Stahlbauten, Blatt 94'.

PRODUCT INFORMATION

Packaging	Sika Poxicolor® Primer HE NEW	28 kg, 14 kg and 4 kg net.
	Sika® Thinner EG	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
Appearance / Colour	Aluminium, sand-yellow and red-brown (mat.-no.: 694.01/02/06)	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	Sika Poxicolor® Primer HE NEW aluminium	~1.3 kg/l
	Sika Poxicolor® Primer HE NEW red-brown, sand-yellow	~1.4 kg/l

Solid content	Sika Poxicolor® Primer HE NEW auminium	~67 % by volume ~80 % by weight
	Sika Poxicolor® Primer HE NEW red-brown, sand-yellow	~68 % by volume ~83 % by weight

TECHNICAL INFORMATION

Chemical Resistance	Weathering, de-icing salts, oils and grease and short term exposure to fuels and solvents.
Temperature Resistance	Dry heat up to 150°C; short-term up to + 200°C Damp heat up to + 40°C

SYSTEMS

Systems

Steel resp. touch up of spots on hot dip galvanized surfaces

1 - 2 x Sika Poxicolor® Primer HE NEW
Universally recoatable with 1- and 2-pack intermediate coats and top coats of Sika Deutschland GmbH.

e. g. "Blatt 94 acc. TL-KOR-Stahlbauten"
1 x Sika Poxicolor® Primer HE NEW
1 x SikaCor® EG-1 VHS
1 x SikaCor® EG-4 or SikaCor® EG-5

Old coatings
Sika Poxicolor® Primer HE NEW can be used on a variety of intact 1-pack and 2-pack coats for refubishment.

APPLICATION INFORMATION

Mixing Ratio

	Components A : B
By weight	88 : 12

Thinner

Sika® Thinner EG
If necessary max. 5% Sika® Thinner EG may be added to adapt the viscosity.

Consumption

Theoretical material-consumption/VOC without loss for medium dry film thickness:

	Sika Poxicolor® Primer HE NEW aluminium	Sika Poxicolor® Primer HE NEW red-brown, sand-yellow
Dry film thickness	100 µm	100 µm
Wet film thickness	149 µm	147 µm
Consumption	~0,194 kg/m²	~0,206 kg/m²
VOC	~39 g/m²	~35 g/m²

Product Temperature

Min. + 5°C

Relative Air Humidity

Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.

Surface Temperature

Min. + 5°C

Pot Life

At + 5°C	~6 h
At + 20°C	~4 h

Drying Stage 6		**Dry film thickness 100 µm**	(ISO 9117-5)
	+ 5°C after	12 h	
	+ 20°C after	6 h	
	+ 30°C after	3 h	

Waiting Time / Overcoating	Min.: until drying stage 6 is achieved Max.: 1 year
Drying time	**Final drying time** Depending on layer thickness and temperature final hardness is achieved within 1 - 2 weeks.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Steel:
The durability of corrosion protection by coatings generally depends on the surface preparation. Usually, blasting is the most effective and economical solution. For permanent immersion and permanent condensation, we recommend to prepare the surfaces in accordance with ISO 12944-4 Sa 2 ½. In case of atmospheric exposure hand- or power-tool cleaning in accordance with St 2 is sufficient. Even ultra high pressure water jetting according to ISO 8501-4 Wa 2 with a maximum flash rust grade M is also acceptable.
Note: Sika Poxicolor® Primer HE NEW is not recommended for continuous immersion. In addition, the surface must be dry, free of dirt, oil, grease and loose rust.

Hot dip galvanized surfaces:
Free from oil, grease and zinc salts.
In case of permanent condensation surfaces should be sweep blasted according to ISO 12944-4.

Old coatings:
In case of well adhering coating systems, careful cleaning(e.g. by water jetting) is sufficient. Loose particles must be removed, damaged areas should be minimum de-rusted in accordance with PSa 2, PMa or PSt 2 and primed with Sika Poxicolor® Primer HE NEW.
The required surface preparation/cleaning and compatibility of the system should be determined with trial areas.

Contaminated surfaces e.g. galvanized surfaces, primed areas or old coatings we recommend to clean with SikaCor® Wash.

MIXING

Stir component A very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush:
- Surface preparation St 2 or St 3
- With brush application best penetration and surface wetting is achieved

Conventional high pressure spraying:
- Nozzle size 1.7 - 2.5 mm
- Pressure 3 - 5 bar

Airless-spraying:
- Pressure of min. 180 bar
- Diameter of hoses min. 10 mm (⅜ inch)
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40°- 80°

CLEANING OF EQUIPMENT

SikaCor® Cleaner

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

DIRECTIVE 2004/42/CE LIMITATION OF EMISSIONS OF VOC

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / j type Sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sika Poxicolor® Primer HE NEW is < 500 g/l VOC for the ready to use product.

LEGAL NOTES

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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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