

PRODUCT DATA SHEET

Sika Poxicolor® Primer HE NEW

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

DESCRIPTION

2-pack primer based on epoxy resin. Economically and high-performance corrosion protection also for manually de-rusted surfaces. 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) is feasible or economic.

CHARACTERISTICS / ADVANTAGES

- High-build application
- Fast initial drying and full hardening
- Very economically due to high coverage
- 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

APPROVALS / CERTIFICATES

- Approved according to German standard 'TL/TP-KOR-Stahlbauten', page 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 aluminium	~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.
Thermal Resistance	Dry heat up to + 100°C Damp heat up to + 40°C

SYSTEM INFORMATION

System	<u>Steel resp. touch up of spots on hot dip galvanized surfaces:</u> <u>Exposure to atmosphere:</u> 1 x Sika Poxicolor® Primer HE NEW 1 - 2 x SikaCor® EG-1 VHS 1 x SikaCor® EG-4 or SikaCor® EG-5 or SikaCor® EG-120
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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	150 µm	150 µm
Consumption	~0.194 kg/m ²	~0.206 kg/m ²
VOC	~38.8 g/m ²	~35.0 g/m ²
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:

Surface preparation according to ISO 12944-4. The required degree depends on future exposure. In case of atmospherically exposure St 2 or St 3 is sufficient. The substrate must be free from dirt, oil and grease.

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.

For contaminated surfaces e.g. galvanized or primed areas 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 (3/8 inch)
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

CLEANING OF TOOLS

SikaCor® Cleaner

BASIS OF PRODUCT DATA

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

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

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. Further notes and information data sheets on product safety and disposal can be found on the Internet at www.sika.de.

GISCODE: RE 3

This coding enables additional information and help with the creation of operating instructions (WINGIS online) to be obtained on the BG Bau service pages (www.gisbau.de).

Skin contact with epoxy resins can lead to allergies!
Avoid direct skin contact at all costs when handling epoxy resins!

For the selection of suitable protective equipment, we have made our information data sheets 7510 'General notes on occupational safety' and 7511 'General notes for wearing protective gloves' available at www.sika.de. In conjunction with this we also recommend the BG Bau service pages for information regarding the handling of epoxy resins (www.bgbau.de/gisbau/fachthemen/epoxi).

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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PRODUCT DATA SHEET
Sika Poxicolor® Primer HE NEW
March 2018, Version 03.01
020602000130000009

SikaPoxicolorPrimerHENEW-en-DE-(03-2018)-3-1.pdf