

## PRODUCT DATA SHEET

# SikaCor® Aktivprimer Rapid

Primer with active anti-corrosion pigment for manually de-rusted surfaces, maintenance coating, sweep-blasted galvanizing, on steel, stainless steel and aluminium

Made in Germany

### DESCRIPTION

Quick-drying, 1-pack corrosion protection primer, containing zinc phosphate based on synthetic resin combination.

Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

SikaCor® Aktivprimer Rapid may only be used by experienced professionals.

For surfaces and objects, where only manually de-rusting is possible and economical.

Suitable as high performance primer for surfaces blast-cleaned to Sa 2 ½, for stainless steel, aluminium and sweep-blasted galvanized surfaces.

Suitable for atmospherical corrosion protection and occasional condensation.

As intermediate coat / tie coat on well adhering old coating systems.

### CHARACTERISTICS / ADVANTAGES

- Low solvent content, ecologically harmless
- VOC content < 350 g/l
- Versatilely overcoatable with 1-pack coatings and SikaCor® ZP Primer
- Economical
- High-build
- Fast-drying

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor® Aktivprimer Rapid	15 kg net., 3 l and 0.75 l
	Sika® Thinner S	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
<b>Appearance and colour</b>	Oxide red, beige yellow	
<b>Shelf life</b>	2 years	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.	
<b>Density</b>	~1.6 kg/l	
<b>Solid content</b>	~60 % by volume	
	~78 % by weight	

## TECHNICAL INFORMATION

Temperature resistance Dry heat up to max. + 80°C

## SYSTEM INFORMATION

**System**

Manually de-rusted steel:  
1 x SikaCor® Aktivprimer Rapid  
1 - 2 x top coat  
Total dry film thickness: Min. 200 µm

Stainless steel, sweep-blasted galvanizing and aluminium:  
1 x SikaCor® Aktivprimer Rapid  
1 - 2 x top coat

Steel blast-cleaned to Sa 2 ½:  
1 x SikaCor® Aktivprimer Rapid  
1 - 2 x top coat

For atmospheric conditions SikaCor®-6630 High Solid is recommended as top coat.  
**Please note: If galvanized surfaces can't be sweep-blasted, SikaCor®-6630 Primer must be used!**

## APPLICATION INFORMATION

**Thinner** If necessary max. 2 % Sika® Thinner S may be added to adapt the viscosity.

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

Dry film thickness	80 µm
Wet film thickness	130 µm
Consumption	~0.215 kg/m <sup>2</sup>
VOC	~46.9 g/m <sup>2</sup>

**Material 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

**Drying stage 6**

	<b>Dry film thickness 80 µm</b>	(ISO 9117-5)
+ 5°C after	4 h	
+ 20°C after	3 h	

**Waiting time to overcoating**

Between priming coats:  
After drying stage 6 is achieved (see above).

Between SikaCor® Aktivprimer Rapid and 1-pack top coats:  
Min. 1 day at + 20°C

Between SikaCor® Aktivprimer Rapid and SikaCor® ZP Primer:  
Min. 3 days at + 20°C

**Drying time**

**Final drying time**  
Depending on film thickness, temperature and ventilation full hardness is achieved within several days.  
Depending on local conditions full curing with top coat is achieved within 1 - 2 weeks.

## 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.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION

#### Manually de-rusted surfaces:

Prepare surface by wire brush, trowel, power tool to surface preparation grade St 2 resp. St 3 according to ISO 12944-4.

#### Steel:

Blast-cleaning to Sa 2 ½ according to ISO 12944-4.

#### Galvanized surfaces:

Sweep-blasting to a uniform rough, grey surface is achieved.

#### Stainless steel and aluminium:

The substrate must be free from dirt, oil, grease and corrosion products.

#### Maintenance coatings:

In case of well adhering old coating systems, careful cleaning is sufficient. Loose particles must be removed, defective areas must be de-rusted to PSa 2 ½, PMA or PSt 2 and patch-primed with SikaCor® Aktivprimer Rapid.

For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.

### MIXING

SikaCor® Aktivprimer Rapid is supplied ready for use. Stir thoroughly prior to application.

### 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.

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#### **PRODUCT DATA SHEET**

SikaCor® Aktivprimer Rapid  
February 2022, Version 03.02  
020601000120000007

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 and roller:

- As a good wetting and penetration into the substrate is essential for the efficiency of the priming coat, the best result is achieved by using a distemper brush or similar
- Dry film thickness per application 40 - 60 µm by brush application

#### Conventional high pressure spraying:

- Nozzle size 1.5 - 2.0 mm
- Pressure 4 - 6 bar

#### Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 65° - 80°
- Dry film thickness per application 60 - 80 µm by spray application

### CLEANING OF EQUIPMENT

SikaCor® Cleaner

## 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.

## 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.

SikaCorAktivprimerRapid-en-DE-(02-2022)-3-2.pdf