

PRODUCT DATA SHEET

Sika® Icosit® KC 330 Primer

1-pack Polyurethane Primer for Icosit® KC 330 / 340 product range

DESCRIPTION

Sika® Icosit® KC 330 Primer is a 1-pack, polyurethane ready to use, solvented, reaction-curing primer.

USES

Sika® Icosit® KC 330 Primer may only be used by experienced professionals.

Adhesion promoter as pre-treatment of dry concrete, steel and asphalt substrates. For improving adhesion of the Icosit® KC 330 / 340 range of products.

FEATURES

- Highly abrasion resistant
- Good penetration and substrate stabilisation
- Moisture-curing
- Tough-hard

PRODUCT INFORMATION

Composition	1-pack polyurethane
Packaging	3 Litre container Refer to current price list for packaging variations.
Colour	Yellowish-brown / transparent
Shelf life	12 months from date of production
Storage conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +10 °C and +25 °C. Always refer to packaging.
Density	~1,0 kg/l (ISO 2811-1)

TECHNICAL INFORMATION

Chemical resistance	Long-term resistant against: <ul style="list-style-type: none">▪ Water▪ Many detergent solutions▪ Seawater Temporary resistant against: <ul style="list-style-type: none">▪ Mineral oil, Diesel fuel Short-term or no resistance against: <ul style="list-style-type: none">▪ Organic solvents (esters, ketones, aromates) and alcohol▪ Concentrated lyes and acids <p>Contact Sika Technical Services for specific information.</p>
Temperature resistance	Dry heat short-term up to ~+150 °C, liquids up to ~ +60 °C
Service temperature	-40 °C min. / +80 °C max. short term up to 150 °C

APPLICATION INFORMATION

Consumption	~ 0,1 kg/m ² - 0,2 kg/m ² Depends on the roughness and absorbency of the substrate.												
Material temperature	Condition product before application preferably at ~+15 °C												
Ambient air temperature	+5 °C min. / +35 °C max.												
Relative air humidity	30 % min. / 70 % max.												
Dew point	Beware of condensation. The substrate and uncured applied material must be at least +3 °C above dew point.												
Substrate temperature	+5 °C min. / +35 °C max												
Substrate moisture content	≤ 3 % parts by weight												
Pot Life	Contents of opened container should be used within the same day.												
Waiting time to overcoating	At 40 % - 60 % relative humidity												
	<table><thead><tr><th></th><th>+10 °C</th><th>+20 °C</th><th>+30 °C</th></tr></thead><tbody><tr><td>Minimum</td><td>3 hours</td><td>1 hour</td><td>1 hour</td></tr><tr><td>Maximum</td><td>3 days</td><td>3 days</td><td>3 days</td></tr></tbody></table>		+10 °C	+20 °C	+30 °C	Minimum	3 hours	1 hour	1 hour	Maximum	3 days	3 days	3 days
	+10 °C	+20 °C	+30 °C										
Minimum	3 hours	1 hour	1 hour										
Maximum	3 days	3 days	3 days										

SYSTEM INFORMATION

System structure

- SikaCor®-299 Airless (Steel deck / baseplate / rail coating)
- Sika® Icosit® KC 330 Primer
- Icosit® KC 330 / 340 products

BASIS OF PRODUCT DATA

Concrete tensile strength $\geq 1,5 \text{ N/mm}^2$.

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

IMPORTANT CONSIDERATIONS

- To achieve optimum application performance, condition the material to a temperature of +15 °C before application.
- During application and curing, air and substrate temperature should be ideally at least +5 °C. Lower temperatures will delay the curing process. If relative air humidity falls below 25 %, chemical reaction and curing will be delayed.
- Beware of solvent fumes vaporising from product during and after application.
- Poorly ventilated work areas need forced ventilation during application and drying.
- If a waiting time of 3 days is exceeded, Sika® Icosit® KC 330 Primer must be removed from substrate by blast cleaning, grinding or other suitable preparation technique and re-applied.
- Do not use on damp substrates.

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.

Regulation (EC) No 1907/2006 (REACH) - Mandatory training

As from 24 August 2023 adequate training is required before industrial or professional use of this product. For more information and a link to the training visit www.sika.com/pu-training.



APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

Substrate must be sound, free from oil, grease, loose and friable particles.

PRODUCT DATA SHEET

Sika® Icosit® KC 330 Primer
August 2025, Version 03.01
020202020020000010

SUBSTRATE PREPARATION

Cementitious substrates must be prepared mechanically using suitable abrasive blast cleaning or planing / scarifying equipment to remove cement laitance and achieve an open textured gripping surface.

Weak cementitious substrates must be removed and surface defects such as blow holes and voids must be fully exposed and filled / repaired with compatible Sika® products.

Steel substrates must be prepared mechanically using suitable abrasive blast cleaning to remove all corrosion products and achieve a bright metal finish.

All dust, loose and friable material must be completely removed from all surfaces before application of the product and associated system products, preferably by vacuum extraction equipment.

APPLICATION METHOD / TOOLS

Apply Sika® Icosit® KC 330 Primer onto the prepared substrate and apply by brush or short-piled nylon roller. Ensure a continuous coat covers the substrate.

CLEANING OF EQUIPMENT

Clean all tools and application equipment with Sika® Reinigungsmittel-5 immediately after use. Hardened material can only be removed mechanically.

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.

Sika Deutschland CH AG & Co KG

Kornwestheimer Straße 103 - 107

D - 70439 Stuttgart

Tel.: +49 711 8009-0

Fax: +49 711 8009-321

info@de.sika.com

www.sika.de

PRODUCT DATA SHEET

Sika® Icosit® KC 330 Primer

August 2025, Version 03.01

020202020020000010

SikalcositKC330Primer-en-DE-(08-2025)-3-1.pdf