

PRODUCT DATA SHEET

Sika Poxicolor® Primer HE NEW

High solid, surface-tolerant epoxy primer coat for steel and galvanized surfaces

Made in Germany

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.

FEATURES

- 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

PRODUCT INFORMATION

Packaging	Sika Poxicolor® Primer HE NEW	14 kg and 4 kg net.
	Sika® Thinner EG	5 l
	SikaCor® Cleaner	25 l
Appearance and colour	Aluminium	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.3 kg/l	
Solid content	~67 % by volume	
	~80 % 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

APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	88 : 12
Consumption	Theoretical material-consumption without loss for medium dry film thickness:	
	Dry film thickness	100 µm
	Wet film thickness	149 µm
	Consumption	~0.194 kg/m ²
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.	
Pot Life	At + 5°C	~6 h
	At + 20°C	~4 h
Waiting time to overcoating	Min.: until drying stage 6 is achieved Max.: 1 year	
Thinner	Sika® Thinner EG If necessary max. 5% Sika® Thinner EG may be added to adapt the viscosity.	
Drying time	Final drying time Depending on layer thickness and temperature final hardness is achieved within 1 - 2 weeks.	
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
Surface temperature	Min. + 5°C	

SYSTEM INFORMATION

System	Steel resp. touch up of spots on hot dip galvanized surfaces 2 x Sika Poxicolor® Primer HE NEW Universally recoatable with 1- and 2-pack Sika intermediate coats and top coats e. g.: 1 x Sika Poxicolor® Primer HE NEW 1 x SikaCor® EG-1 Plus 1 x SikaCor® EG-4 / SikaCor® EG-5 / SikaCor® PUR Color Plus Old coatings Sika Poxicolor® Primer HE NEW can be used on a variety of intact 1-pack and 2-pack coats for refurbishment.
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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

SUBSTRATE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion. For contaminated and weathered surfaces e.g. primed areas we recommend to clean with SikaCor® Wash.

Steel surfaces shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4) in case of permanent condensation.

Hot-dip galvanized surfaces shall be prepared by degreasing or, in case of permanent condensation, sweep blasting according to ISO 12944-4 with a non-ferrous blasting abrasive.

Manually prepared surfaces shall be prepared by wire brush or power tool to surface preparation grade St 2 according to ISO 8501-1 (ISO 12944-4), in case of atmospheric exposure. Even ultra-high pressure water jetting according to ISO 8501-4 Wa 2 with a maximum flash rust grade M is also acceptable.

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 prepared 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.

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 1.5 - 2.5 mm
- Pressure 3 - 5 bar

Airless-spraying:

- Pressure of min. 180 bar
- Diameter of hoses min. 10 mm (¾ inch)
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

CLEANING OF EQUIPMENT

SikaCor® Cleaner

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December 2025, Version 13.01

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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.

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