SikaCor®-1360

Solvent based, 1-pack coating for temporary corrosion protection of steel

DESCRIPTION

SikaCor®-1360 is a fast-curing, 1-pack coating material based on a special synthetic resin for the temporary corrosion protection of high-temperature equipment in power station constructions and plant engineering.

USES

SikaCor®-1360 may only be used by experienced professionals.

SikaCor®-1360 is used as temporary corrosion protection for the transportation and storage of high-temperature equipment e.g. raw gas, clean gas and hot ventilation flues, pressurised boiler components, pipelines, pipework, boilers, chimneys, heating air shafts.

CHARACTERISTICS / ADVANTAGES

- Rapid initial and through drying
- Excellent temporary corrosion protection
- Easy single-layered application, usable between 60 - 100 μ
- The coating film decomposes slowly at high temperature with moderate release of gases and without leaving an inert residue

PRODUCT INFORMATION

<table>
<thead>
<tr>
<th>Packaging</th>
<th>SikaCor®-1360</th>
<th>250 kg and 30 kg net.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Sika® Thinner S</td>
<td>25 l, 10 l and 3 l</td>
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<tr>
<td></td>
<td>SikaCor® Cleaner</td>
<td>160 l and 25 l</td>
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</tbody>
</table>

Appearance and colour  Redbrown, mat

Shelf life               2 years

Storage conditions       In originally sealed containers in a cool and dry environment.

Density                  ~1.6 kg/l

Solid content            ~57 % by volume
                          ~77 % by weight

SYSTEM INFORMATION

System                   Steel:
                          1 x SikaCor®-1360
APPLICATION INFORMATION

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

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

<table>
<thead>
<tr>
<th>Dry film thickness</th>
<th>60 μm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet film thickness</td>
<td>105 μm</td>
</tr>
<tr>
<td>Consumption</td>
<td>~0.168 kg/m²</td>
</tr>
<tr>
<td>VOC</td>
<td>~39.0 g/m²</td>
</tr>
</tbody>
</table>

**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**

<table>
<thead>
<tr>
<th>Drying Stage 1</th>
<th>Dry film thickness 60 μm (ISO 9117-5)</th>
</tr>
</thead>
<tbody>
<tr>
<td>+ 23°C after</td>
<td>15 min</td>
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<table>
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<tr>
<th>Drying Stage 6</th>
<th>Dry film thickness 60 μm (ISO 9117-5)</th>
</tr>
</thead>
<tbody>
<tr>
<td>+ 23°C after</td>
<td>30 min</td>
</tr>
</tbody>
</table>

**Waiting time to overcoating**
SikaCor®-1360 is applied in one single coat.
If necessary, a second coat can be applied after 30 min at + 23°C.

**Drying time**
The final hardness is achieved within 7 - 14 days depending on layer thickness and temperature.

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

**Steel:**
Free from dirt, grease and oil.
In case of aggressive industrial atmosphere or highly polluted surfaces (e.g. chlorides, sulphates or nitrates):
Blast cleaning to Sa 2 ½ according to ISO 12944-4.
In case of lower exposure as e.g. in rural atmosphere or indoors, manual or mechanical surface preparation (power tool cleaning) to St 2 may be sufficient.

MIXING
SikaCor®-1360 is supplied ready for use.

Stir thoroughly with electrical stirrer 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.
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 shades 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 or roller**

**High pressure spraying:**
- Nozzle size 1.5 - 2.0 mm
- Pressure 2 - 5 bar

**Airless spraying:**
- Efficient airless equipment necessary
- Pressure min. 180 bar
- Hose diameter ¼ inch or 10 mm
- Nozzle size 0.33 - 0.53 mm (0.013 - 0.021 inch)
- Spraying angle 40° - 80°
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.