

# PRODUCT DATA SHEET

## SikaCor® Zinc R Plus

High solid epoxy zinc-rich primer for steel

Made in Germany

### DESCRIPTION

2-pack, highly pigmented zinc-rich primer of low solvent content, based on epoxy resin.  
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

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Designed as a mechanically resistant zinc-rich coating for steel surfaces exposed to atmospheric conditions. Mainly for bridges, pipe lines, containers, industrial and harbour installations or large machinery in industrial or marine environments.

Particularly suited for workshop application as heavy duty transportable coating.

In combination with 2-pack intermediate and top coats, SikaCor® Zinc R Plus is a mechanically, water and chemically resistant coating system for durable corrosion protection up to corrosivity category C5 very high according to ISO 12944-2.

### CHARACTERISTICS / ADVANTAGES

- Low consumption per square meter
- Excellent corrosion protection
- Mechanically extraordinary resistant
- Fast drying and curing characteristics

### APPROVALS / CERTIFICATES

- Approved according to German standard 'TL/TP-KOR-Stahlbauten, Blatt 87'.
- Certificates for C5 high and very high acc. ISO 12944 are available

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor® Zinc R Plus	22 kg, 15 kg und 6 kg net.
	Sika® Thinner K	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
<b>Appearance and colour</b>	Zinc grey, mat.-no. 687.03 Tinted red, mat.-no. 687.04	
<b>Shelf life</b>	1 year	
<b>Storage conditions</b>	In original sealed containers in a cool and dry environment.	

Density	~2.3 kg/l
Solid content	~71 % by volume ~89 % by weight

## TECHNICAL INFORMATION

Chemical resistance	The fully cured material is resistant to weathering, water and mechanical wear.
Temperature resistance	Dry heat up to approx. + 150°C, short term up to max. + 180°C Damp heat up to approx. + 50°C

## SYSTEM INFORMATION

System	<p><b>Steel</b></p> <p>Without top coat: 2 x SikaCor® Zinc R Plus</p> <p>For priming under intermediate coat / top coat: 1 x SikaCor® Zinc R Plus Versatile recoatable with 1- and 2-pack products of Sika Deutschland GmbH</p> <p>e. g. "Blatt 87" acc. TL-KOR-Stahlbauten 1 x SikaCor® Zinc R Plus 1-2 x SikaCor® EG-1 Plus 1 x SikaCor® EG-4 / SikaCor® EG-5</p>
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## APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	94 : 6
	By volume	6.1 : 1
Thinner	Sika® Thinner K If necessary max. 3 % Sika® Thinner K may be added to adapt the viscosity.	
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:	
	Dry film thickness	60 µm      80 µm*)
	Wet film thickness	85 µm      113 µm
	Consumption	~0.194 kg/m <sup>2</sup> ~0.259 kg/m <sup>2</sup>
	VOC	~21 g/m <sup>2</sup> ~29 g/m <sup>2</sup>
	*) for spray application Apart from small areas the dry film thickness of SikaCor® Zinc R Plus should not exceed 150 µm per layer.	
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	
Pot Life	At + 10°C	~12 h
	At + 20°C	~8 h
	At + 30°C	~5 h

+ 5°C after	3 h
+ 10°C after	2.5 h
+ 20°C after	2 h
+ 30°C after	0.75 h

**Waiting time to overcoating**

**Min.:** Until drying stage 6 is achieved.

Higher layer thicknesses, but also lower temperatures than specified, lead to longer drying times. The overcoating intervals can be delayed and may need to be determined on site.

**Max.:** 1 year

In case of longer waiting times please contact Sika.

When SikaCor® Zinc R Plus is to be overcoated after a waiting period or after exposure to weathering, all zinc corrosion products or other contaminations must be removed from the surface before the subsequent coating material is applied.

**Drying time****Final drying time**

Depending on film thickness and temperature full hardness is achieved after 1 - 2 days.

If used as primer for a coating system with top coats the final drying time depend on them and the full hardness is usually achieved after 1 - 2 weeks, depending on film thickness and ambient temperature. Tests of the completed system should only be carried out after final drying.

**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:

Blast-cleaning to Sa 2 ½ according to ISO 12944-4. Free from dirt, oil and grease.

For contaminated and weathered surfaces 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 oth-

er 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 brushConventional high pressure spraying:

- Nozzle size 1.7 - 2.5 mm
- Pressure 3 - 4 bar
- Oil and water trap is compulsory

Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 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

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February 2022, Version 01.02  
020602000040000092

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 GmbH

Industrial Coatings  
Rieter Tal  
D-71665 Vaihingen / Enz  
Phone: +49 (0)7042 109-0  
industrial-coatings@de.sika.com  
www.sika.de



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SikaCorZincRPlus-en-DE-(02-2022)-1-2.pdf

