

PRODUCT DATA SHEET

Sika Poxicolor® Rapid

Low solvent containing, fast-curing epoxy resin coating for steel

Made in Germany

DESCRIPTION

Sika Poxicolor® Rapid is a chemically and mechanically resistant high solid 2-pack epoxy primer and intermediate coat containing zinc phosphate as an active pigment.
Low solvent content acc. to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

Sika Poxicolor® Rapid may only be used by experienced professionals.

Durable corrosion protection for steel constructions exposed to water, salt water or domestic waste water, up to corrosivity category C5 high acc. to ISO 12944-2.

Sika Poxicolor® Rapid can also be used as sealer for thermal-sprayed metallic coatings to close pores and also as a subsequent intermediate coat.

CHARACTERISTICS / ADVANTAGES

- Short overcoating times, up to 3 coats per day
- Fast curing at low temperatures
- Suitable as sealer for thermal-sprayed metallic coatings
- Very economical due to low solvent contents

APPROVALS / CERTIFICATES

- Approved according to ENERCON specification for corrosivity categories C3 high to C5 high according to ISO 12944-2.

PRODUCT INFORMATION

Packaging	Sika Poxicolor® Rapid	30 kg net.
	Sika® Thinner EG	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
Appearance and colour	Light grey	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.6 kg/l	
Solid content	~68 % by volume	
	~83 % by weight	

TECHNICAL INFORMATION

Chemical resistance	Industrial and marine atmosphere, water, domestic waste water, sea water, de-icing salts, grease and oil. Short term resistance against fuels and solvents!	
Temperature resistance	Dry heat: Short term resistance <u>up to max. + 150°C</u> Permanent exposure <u>up to max. + 80°C</u>	

SYSTEM INFORMATION

System	Steel 1 - 2 x Sika Poxicolor® Rapid Used as intermediate coat on top of primers e.g.: ▪ SikaCor® Zinc R Suitable top coats: Versatile overcoatable with 1- or 2-pack SikaCor® and Sika® Permacor® products. Thermal-sprayed metallic coatings 1 x Sika Poxicolor® Rapid as sealer 1-2 x Sika Poxicolor® Rapid
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APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	<u>89 : 11</u>
	By volume	<u>4 : 1</u>

Thinner	Sika® Thinner EG Adapt the viscosity: If necessary add max. 5% Sika® Thinner EG. If used as a sealer: Thinn with 20 % Sika® Thinner EG. Use the heavily diluted material immediately and under continuous stirring.
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Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:		
	Dry film thickness	<u>100 µm</u>	<u>160 µm</u>
	Wet film thickness	<u>150 µm</u>	<u>235 µm</u>
	Consumption	<u>~0.235 kg/m²</u>	<u>~0.376 kg/m²</u>
	VOC	<u>~40.0 g/m²</u>	<u>~64.0 g/m²</u>

Material temperature	Min. + 5°C
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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. The surface must be dry and free from ice.
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Surface temperature	Min. - 10°C
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Pot Life	At + 5°C	<u>~ 8 h</u>
	At + 20°C	<u>~ 6 h</u>

Drying stage 6	Dry film thickness	Dry film thickness	(ISO 9117-5)
	<u>100 µm</u>	<u>160 µm</u>	
	+ 0°C after	<u>12 h</u>	<u>24 h</u>
	+ 5°C after	<u>6.5 h</u>	<u>12 h</u>
	+ 20°C after	<u>3.5 h</u>	<u>4.5 h</u>

Waiting time to overcoating

Waiting time

Min.:

	Dry film thickness 100 µm	Dry film thickness 160 µm
At + 5°C	4 h	12 h
At + 20°C	2 h	4.5 h

Between Sika Poxicolor® Rapid and 2-pack-PUR top coats:

Min.:

	Dry film thickness 100 µm	Dry film thickness 160 µm
At + 5°C	8 h	16 h
At + 20°C	4 h	6 h

Higher layer thicknesses, but also lower temperatures as well as lower air humidity 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 us.

Prior to further applications: After a waiting period or after exposure to weathering, all possible contamination must be removed from the surface before the subsequent coating is applied.

Note, if using as a sealer: Pre-spray the thinned Sika Poxicolor® Rapid thinly onto the thermal-sprayed metallic coat and after a waiting time of approx. 15 minutes, spray 'wet on wet' the missing layer thickness of Sika Poxicolor® Rapid.

Drying time

Final drying time

Depending on layer thickness and temperature final hardness is achieved within 5 - 7 days.

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.

Thermal-sprayed metallic coating:

Free from dirt, oil, grease and corrosion products.

For contaminated 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 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 and roller

Airless-spraying:

- Pressure min. 180 bar
- Diameter of hoses min. 10 mm ($\frac{3}{8}$ inch)
- 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 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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