

PRODUCT DATA SHEET

Sika Poxicolor®

High solid epoxy-combination for steel and zinc

Made in Germany

DESCRIPTION

Highly resistant, economical 2-pack coating based on MIO (micaceous iron oxide) free epoxy-resin combination of low solvent content.
Low solvent content acc. to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

Sika Poxicolor® may only be used by experienced professionals.

Durable, easily applied high-build system for steel and galvanized surfaces for strong corrosive exposure, e. g. pipelines, containers, industrial and harbour installations, sewage treatment plant etc.

CHARACTERISTICS / ADVANTAGES

- Application of dry film thicknesses up to 150 microns per coat
- Excellent adhesion on galvanized surfaces
- Tough elastic and hard but not brittle
- Largely insensitive against shock and impact
- Very economical due to high volume solids and low solvent content

APPROVALS / CERTIFICATES

- Approved according to German standard 'TL/TP-KOR Stahlbauten, Blatt 81'.

PRODUCT INFORMATION

Packaging	Sika Poxicolor®	28 kg and 14 kg net.
	Sika® Thinner EG	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
Appearance and colour	RAL-colour shades and approx. DB-colour shades black, Mat. Nr. 681.11; black-red, Mat. Nr. 681.12 RAL 7032, Mat. Nr. 681.94; RAL 9002; Mat. Nr. 681.97 Sika Poxicolor® contains no MIO in DB colour shades. Slight colour deviations are possible due to raw material characteristics.	
Shelf life	2 years	
Storage conditions	In original sealed containers in a cool and dry environment.	
Density	~1.6 kg/l	
Solid content	~76 % by volume	
	~87 % by weight	

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TECHNICAL INFORMATION

Chemical resistance	Industrial and marine environments, weather, domestic sewage, de-icing salts, oils and grease and short term exposure to fuels and solvents.
Temperature resistance	Dry heat: Short term resistance (a few hours) up to max. + 150°C Permanent exposure up to max. + 80°C

SYSTEM INFORMATION

System	Steel 2 x Sika Poxicolor® Used as intermediate coat on 2-pack primers e.g.: <ul style="list-style-type: none">▪ SikaCor® Zinc R (Plus)▪ Sika® Poxicolor Primer HE NEU Hot-dip galvanised steel 2 x Sika Poxicolor® Colour retention and resistance against chalking of Sika Poxicolor® is much better than with pure epoxy resins. In case of higher requirements an additional 2-pack PU top coat e. g. SikaCor® EG-4 or SikaCor® EG-5 is recommended.
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APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	92 : 8
	By volume	6.5 : 1
Thinner	Sika® Thinner EG If necessary max. 5% Sika® Thinner EG may be added to adapt the viscosity.	
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:	
	Dry film thickness	100 µm 120 µm
	Wet film thickness	135 µm 160 µm
	Consumption	~0.211 kg/m ² ~0.250 kg/m ²
	VOC	~27 g/m ² ~33 g/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.	
Surface temperature	Min. + 5°C	
Pot Life	At + 5°C	~8 h
	At + 20°C	~6 h
	At + 30°C	~3 h
Drying stage 6	Dry film thickness 100 µm	(ISO 9117-5)
	+ 5°C after	24 h
	+ 20°C after	6 h
	+ 30°C after	3 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.: 24 months

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.

Drying time

Final drying time

Depending on film thickness and temperature full hardness is achieved after 1 - 2 weeks. Tests of the completed coating system should only be carried out after final curing.

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.

Hot dip galvanized steel, stainless steel and aluminium:

Free from dirt, oil, grease and corrosion products. In case of permanent immersion and condensation the surfaces must be slightly sweep blasted with a ferrite-free blasting abrasive.

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 (¾ inch)
- Nozzle size 0.42 - 0.53 mm (0.017 - 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

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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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