

# PRODUCT DATA SHEET

## SikaCor® SW-500

Epoxy coating with 100 % volume solids  
Mechanically resistant coating for hydraulic steel structures

Made in Germany

### DESCRIPTION

Abrasion resistant, economically 2-pack coating based on epoxy resin.  
Solvent free according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

SikaCor® SW-500 may only be used by experienced professionals.

Corrosion protection for hydraulic steel structures (flood gates, steel sheet piles, etc.), where a mechanically resistant coating is required.

### CHARACTERISTICS / ADVANTAGES

- Applicable in 1 layer up to 1000 microns (standard layer thickness: 500 microns)
- Tough hard, abrasion resistant
- Solvent-free
- Tar-free
- Suitable for cathodic protection systems
- Norsok-approval with and without SikaCor® Zinc R

### APPROVALS / CERTIFICATES

- Tested according to Norsok M-501, rev. 5, system no. 7 and rev. 6, system no. 7A and 7B at the Teknologisk Institutt as, Oslo.
- With SikaCor® Zinc R as primer tested and approved by RWE Power AG.

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor® SW-500	15 kg net.
	SikaCor® Cleaner	160 l and 25 l
<b>Appearance and colour</b>	Black, redbrown, approx. RAL 7032, approx. RAL 9002 Slight colour deviations are possible due to raw material characteristics.	
	SikaCor® SW-500 tends to chalking and yellowing if exposed to weathering. In case of higher demand to colour fastness, SikaCor® EG-4 or SikaCor® EG-5 respectively are recommended as top coats.	
<b>Shelf life</b>	2 years	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.	
<b>Density</b>	~1.5 kg/l	
<b>Solid content</b>	~100 % by volume ~100 % by weight	

## TECHNICAL INFORMATION

<b>Chemical resistance</b>	Resistant to industrial and marine environments, fresh-, brackish- and salt water, neutral salts, mineral oil and heating oil, grease and oils, detergents etc.
<b>Temperature resistance</b>	Dry heat up to approx. + 100°C Damp heat and warm water up to approx. + 40°C

## SYSTEM INFORMATION

<b>System</b>	1 - 2 x SikaCor® SW-500 In case of filigree constructions an additional application is recommended. If necessary SikaCor® Zinc R can be used as primer for steel, SikaCor® EG-1 can be used as primer for galvanized or stainless steel.
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## APPLICATION INFORMATION

<b>Mixing ratio</b>	Components A : B	
	<u>By weight</u>	<u>82 : 18</u>
<b>Consumption</b>	Theoretical material-consumption / coverage without loss for medium dry film thickness:	
	<u>Dry film thickness</u>	<u>500 µm</u>
	<u>Wet film thickness</u>	<u>500 µm</u>
	<u>Consumption</u>	<u>~0.750 kg/m<sup>2</sup></u>
	<u>Coverage</u>	<u>~1.35 m<sup>2</sup>/kg</u>
<b>Material temperature</b>	Min. + 20°C	
<b>Relative air humidity</b>	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.	
<b>Surface temperature</b>	Min. 0°C	
<b>Pot Life</b>	<u>At + 20°C</u>	<u>~45 min</u>
	<u>At + 30°C</u>	<u>~25 min</u>
<b>Drying stage 6</b>	<u>Dry film thickness 500 µm</u>	(ISO 9117-5)
	<u>+ 5°C after</u>	<u>48 h</u>
	<u>+ 23°C after</u>	<u>12 h</u>
	<u>+ 40°C after</u>	<u>3 h</u>
	<u>+ 80°C after</u>	<u>30 min</u>
<b>Waiting time to overcoating</b>	Min. until drying stage 6 is achieved (see above) Max. 3 months In case of longer waiting times please contact Sika.	
<b>Drying time</b>	<b>Final drying time</b> At + 20°C final curing is reached after 1 week. Material cures also under water.	

## 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.  
Average roughness depth  $R_z \geq 50$  microns.

## MIXING

Stir component A 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. Material temperature should be 20 - 30°C after the mixing procedure. 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. 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.

### Airless-spraying:

- Efficient airless equipment
- Pressure min. 180 bar
- Diameter of hoses min. 10 mm (¾ inch)
- Nozzle size 0.45 - 0.66 mm (0.021 - 0.026 inch)
- Spraying angle 40° - 80°

Depending on object conditions an adequate flow consistency can be achieved by a combination of:

- Using isolated hoses and
- Using an inline heater

### By brush and roller:

- Possible on small areas or to precoat edges
- For large areas we recommend the use of Sika Poxicolor® SW

## Do not thin SikaCor® SW-500!

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### **PRODUCT DATA SHEET**

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## 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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