

SYSTEM DATA SHEET

SikaCor®-6630 System

Future name: Kem Kromik® 6630 System

Versatile high-build coating for steel and galvanizing, non-ferrous metals, plastic and timber

DESCRIPTION

The SikaCor®-6630 System consists of:
SikaCor®-6630 High Solid, SikaCor®-6630 High Solid EG and SikaCor®-6630 Primer.

SikaCor®-6630 High Solid is a low-solvent, oxidative drying high-build coating with active corrosion protection pigments based on modified synthetic resin combination.

Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

SikaCor®-6630 System may only be used by experienced professionals.

For weather resistant, high-build coatings on steel and galvanizing in rural to industrial and marine atmosphere: pipelines, bridges, metal facades, roofs, lattice masts, street lights, wall- and ceiling cladding, outside protection of silos.

Suitability on galvanized steel is confirmed by independent test report.

SikaCor®-6630 High Solid is particularly suited for maintenance coating.

Versatile application on stainless steel, copper, aluminium and hard PVC and timber.

Not suitable for windows and doors.

CHARACTERISTICS / ADVANTAGES

- Low solvent content, easy to apply and environmental friendly
- Excellent corrosion protection even in chemically aggressive atmosphere
- Excellent adhesion to steel, galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber
- Good corrosion protection even on manually de-rusted surfaces
- Limited colour-shade retention and chalking resistance
- No brittleness due to an unique binder combination

PRODUCT INFORMATION

Packaging	SikaCor®-6630 Primer	15 kg net.	
	SikaCor®-6630 High Solid	30 kg and 15 kg net.	
	SikaCor®-6630 High Solid EG	15 kg net.	
	Sika® Thinner B	10 l and 3 l	
Appearance and colour	RAL- and Mio colour shades:		
	SikaCor®-6630 Primer	Sand-yellow, redbrown	
	SikaCor®-6630 High Solid	RAL colour shades	
	SikaCor®-6630 High Solid EG	Mio colour shades	
	In case of very intensive colour shades the colour pigments may be rubbed out of the surface. Therefore do not use for hand rails and other building components in public areas. Slight colour deviations are possible due to raw material characteristics. In case of strong UV exposure brilliant colour shades tend to brighten up.		
Shelf life	2 years		
Storage conditions	In originally sealed containers in a cool and dry environment.		
Density	SikaCor®-6630 Primer	~1.5 kg/l	
	SikaCor®-6630 High Solid	~1.4 kg/l	
	SikaCor®-6630 High Solid EG	~1.5 kg/l	
Solid content		<u>By volume</u>	<u>By weight</u>
	SikaCor®-6630 Primer	~62 %	~79 %
	SikaCor®-6630 High Solid	~62 %	~77 %
	SikaCor®-6630 High Solid EG	~61 %	~77 %

TECHNICAL INFORMATION

Chemical resistance	Excellent resistance to rural, urban, industrial and marine atmosphere and temporarily exposure to neutral salts. Not resistant to continuous exposure to diluted acids and lyes, fatty oils, fuels, mineral oils etc. Temporarily short-term exposure does not harm. Not suitable for continuous exposure to liquids (including water).
Temperature resistance	Dry heat up to + 80°C

SYSTEM INFORMATION

System	<u>Steel:</u> 2 - 3 x SikaCor®-6630 High Solid <u>In case of manual de-rusting:</u> 1 x SikaCor®-6630 Primer or SikaCor® Aktivprimer Rapid 2 x SikaCor®-6630 High Solid <u>Galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber:</u> 2 x SikaCor®-6630 High Solid <u>Maintenance coatings:</u> Patch-up with SikaCor®-6630 Primer or SikaCor® Aktivprimer Rapid 1 - 2 x SikaCor®-6630 High Solid
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APPLICATION INFORMATION

Thinner	Use Sika® Thinner B for SikaCor®-6630 High Solid and SikaCor®-6630 High Solid EG. If necessary max. 3 % Sika® Thinner B may be added to adapt the viscosity.		
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:		
	SikaCor®-6630 Primer	SikaCor®-6630 High Solid	SikaCor®-6630 High Solid EG
DFT	80 µm	80 µm	80 µm
WFT	130 µm	130 µm	135 µm
Consumption	~0.195 kg/m ²	~0.180 kg/m ²	~0.195 kg/m ²
VOC	~40.6 g/m ²	~41.5 g/m ²	~45.2 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		
Waiting time to overcoating	Min. 1 day		
Drying time	<u>Dust-dry after</u>	~4 - 5 h	
	<u>Touch dry after</u>	~8 - 10 h, but the coating is still sensitive to pressure	
	Final drying time	Several days depending on coating thickness, temperature and ventilation. Full mechanical and chemical resistance is only achieved 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:

In case of aggressive industrial atmosphere or highly polluted surfaces (e.g. by chlorides, sulphates, nitrates etc.):

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

In case of lower exposure as e.g. in rural atmosphere or indoors, manual surface preparation (power tool cleaning) to St 2 is acceptable.

Galvanizing, stainless steel, copper, aluminium, hard PVC:

Free from dirt, oil, grease and corrosion products.

Maintenance coating:

In case of well adhering coating systems, careful cleaning (e.g. by water jetting) is sufficient.

Loose particles must be removed, defective areas to be de-rusted to surface degree PSa 2 ½, PMa or PSt 2 and primed with SikaCor®-6630 Primer.

For contaminated and weathered surfaces e.g. galvanized or primed areas we recommend to clean with SikaCor® Wash.

MIXING

SikaCor®-6630 High Solid is supplied ready for use. Stir well 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 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

Conventional high pressure spraying:

- Nozzle size 1.7 - 2.5 mm
- Pressure 3 - 5 bar

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

Use Sika® Thinner B for SikaCor® High Solid and for SikaCor®-6630 High Solid EG.

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 Sherwin-Williams` products, are given in good faith based on Sherwin-Williams` current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sherwin-Williams` 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. Sherwin-Williams 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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