

PRODUCT DATA SHEET

SikaCor® HM Mastic

Future name: Macropoxy® HM Mastic

Bonding layer based on epoxy resin

DESCRIPTION

SikaCor® HM Mastic is a solvent-free 2-pack coating based on epoxy resin.
Solvent-free according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

SikaCor® HM Mastic may only be used by experienced professionals.

Protective coating system for orthotropic steel bridge decks underneath asphalt.

CHARACTERISTICS / ADVANTAGES

- Excellent bonding properties
- Exceptional elevated tightness
- Solvent-free

APPROVALS / CERTIFICATES

- Approved acc. to German Standard 'ZTV-ING, part 7, chapter 4' as reaction resin based high-build bonding layer underneath asphalt on orthotropic steel bridge decks.

PRODUCT INFORMATION

Packaging	SikaCor® HM Mastic	25 kg net.
	SikaCor® HM Primer Plus	30 kg net.
	Sikalastic®-827 HT	25 kg bag
	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	SikaCor® HM Primer Plus	~1.5 kg/l
	SikaCor® HM Mastic	~1.7 kg/l
	Sikalastic®-827 HT	~0.75 kg/l
Solid content	SikaCor® HM Primer Plus	~68 % by volume
	SikaCor® HM Mastic	~100 % by volume
	Sikalastic®-827 HT	~100 % by volume

TECHNICAL INFORMATION

Chemical resistance	The described system as well as the single layers are resistant to water, weathering, de-icing salts and petrol. When exposed to sunlight, the colour of SikaCor® HM Mastic may change to greyish red without any negative effects.
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SYSTEM INFORMATION

System	Primer	1 x SikaCor® HM Primer Plus
	Bonding layer	1 x SikaCor® HM Mastic,
	Adhesive layer (pellets)	broadcasted with Sikalastic®-827 HT
	Road surfacing	Mastic asphalt

APPLICATION INFORMATION

Mixing ratio	Components A : B	
	Product	By weight
	SikaCor® HM Primer Plus	90 : 10
	SikaCor® HM Mastic	75 : 25
Consumption	Theoretical material-consumption:	
	SikaCor® HM Primer Plus	~0.176 kg/m ² (at 80 µm)
	SikaCor® HM Mastic	~1.7 kg/m ² (at 1000 µm)
	Sikalastic®-827 HT	~0.8 - 1.0* kg/m ²
	*Spread evenly, not in excess	
Material temperature	SikaCor® HM Primer Plus	min. + 5°C
	SikaCor® HM Mastic	min. + 10°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	SikaCor® HM Primer Plus	SikaCor® HM Mastic
	At + 10°C	~12 h
	At + 20°C	~8 h
	At + 30°C	~5 h
Waiting time to overcoating	Between primer and bonding layer at 20°C: min. 1 day / max. 6 days. Between bonding layer broadcasted with the adhesive layer and asphalt: min. 1 day / max. 3 weeks. Prior to further applications possible contamination must be removed.	

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.

Priming of surface immediately after blast-cleaning.

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.

Do not thin SikaCor® HM Mastic!

APPLICATION

SikaCor® HM Primer Plus can be applied by spray, brush or roller (for further information see our product data sheet SikaCor® HM Primer Plus). Apply SikaCor® HM Mastic uniformly on the cured primer coat with trowel, squeegee, serrated trowel or airless spraying. Broadcast Sikalastic®-827 HT on the freshly applied, still sticky layer.

Data for airless-spraying:

- Equipment (capacity ≥ 10 l/min)
- Pressure min. 200 bar
- Diameter of hoses min. 10 mm (¾ inch)
- Nozzle size 0.019 - 0.023 inch (0.48 - 0.58 mm)
- Spraying angle 40° - 60°
- Temperature of material and equipment min. + 25°C
- At low temperatures the use of a flow heater as well as insulation of the hoses is strongly recommended

Do not thin SikaCor® HM Mastic!

After full curing of SikaCor® HM Mastic, remove non-adherent Sikalastic®-827 HT by sweeping with a broom.

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 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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