

PRODUCT DATA SHEET

Sikalastic® Metal Primer

Primer for metal substrates prior to the application of Sikalastic®-621 TC used in Sika-Trocall® Liquid Detailing System.

PRODUCT DESCRIPTION

Sikalastic® Metal Primer is a two-component, anticorrosive primer for exposed metal substrates and blocking primer over bituminous felts and coatings.

USES

Versatile and anti-corrosive primer on metal substrates for use with:

- SikaRoof® MTC
- Sikalastic® roofing systems
- Sikafloor® balcony waterproofing systems
- Sikagard® hygiene coatings

Barrier against migration of volatile bitumen or plasticizer migration

CHARACTERISTICS / ADVANTAGES

- Fast curing, overcoat possible after 6 hours
- Corrosion protection in industrial and marine environments
- Easy application by brush or roller
- Enhances adhesion to a broad range of metallic substrates
- Protects against migration of volatile bitumen or plasticizers

PRODUCT INFORMATION

Chemical Base	Epoxy, solvent borne and polyamide curative
Packaging	5.0 l (~7.17 kg) containers Component A: 2.5 l (~3.7 kg) Component B: 2.5 l (~3.47 kg)
Appearance / Colour	Component A: pearl grey liquid resin Component B: brown liquid resin
Shelf Life	12 months from date of production
Storage Conditions	The product must be stored properly in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +35 °C. Higher storage temperatures may reduce shelf life of product. Reference shall also be made to the storage recommendations within the safety data sheet.
Density	~1.43 kg/l (23 °C) (EN ISO 2811-1)

APPLICATION INFORMATION

Mixing Ratio	Component A : Component B = 1:1 (by volume)																
Consumption	Apply in one coat, with a consumption of 0.15 l/m ² approx. (0.20 kg/m ² approx.) per coat depending upon surface roughness and absorption.																
Ambient Air Temperature	+5 °C min. / +40 °C max.																
Relative Air Humidity	80 % r.h. max.																
Dew Point	Beware of condensation. The substrate and uncured coating must be ≥3 °C above dew point to reduce.																
Substrate Temperature	+5 °C min. / +40 °C max.																
Substrate Moisture Content	Visibly free from moisture and condensation																
Waiting Time / Overcoating	Apply Sikalastic® Metal Primer within 4 hours of blasting, before re-oxidation. Before applying any recommended SikaRoof® MTC, Sikalastic®, Sikafloor® or Sikagard® products- on Sikalastic® Metal Primer, allow: <table border="1"> <thead> <tr> <th>Substrate temperature</th> <th>Mimimum wait- ing time</th> <th>Maximum wait- ing time</th> <th>Touch dry after:</th> </tr> </thead> <tbody> <tr> <td>+10 °C</td> <td>12 hours approx</td> <td>7 days</td> <td>6 hours approx.</td> </tr> <tr> <td>+20 °C</td> <td>6 hours approx.</td> <td>7 days</td> <td>3 hours approx.</td> </tr> <tr> <td>+30 °C</td> <td>5 hours approx.</td> <td>7 days</td> <td>2 hours approx.</td> </tr> </tbody> </table> <p>Note: Apply an additional coat if more than 7 days pass before coating. Times are approximate and will be affected by changing ambient conditions particularly temperature and relative humidity.</p>	Substrate temperature	Mimimum wait- ing time	Maximum wait- ing time	Touch dry after:	+10 °C	12 hours approx	7 days	6 hours approx.	+20 °C	6 hours approx.	7 days	3 hours approx.	+30 °C	5 hours approx.	7 days	2 hours approx.
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APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

The surfaces must be clean, dry, free of stripping agents and free of oil, grease, silanes, salts, silicone, siloxanes and other chemicals which could cause poor adhesion.

SUBSTRATE PREPARATION

All surfaces to be coated should be thoroughly cleaned by conventional means.

Steel is ideally prepared by shot blasting to Sa 21/2 or SSPC 10 (nearly white metal). Where blasting is not permitted then clean metal preparation by power tools is acceptable.

Non-ferrous metals are prepared by removing deposits of dust and oxidation and abrade to white metal.

Wire brushing can be used on soft metals, i.e. copper. Ensure that surfaces are free from visible dampness and that all dust, loose and friable material is completely removed from all surfaces before application of the product, preferably by brush and/or vacuum. If in doubt apply a test area first.

For detailed information regarding substrate quality / preparation and primer chart please refer to Method Statement.

APPLICATION

Prepare Sikalastic® Metal Primer by stirring component A until uniform, add component B and mix by electric drill until a homogeneous colour is achieved and

the product is free of streaks.

Sikalastic® Metal Primer can be applied by short-piled roller or brush.

Allow primer to dry sufficiently (see table waiting time / overcoating) before overcoating.

CLEANING OF TOOLS

Clean all tools and application equipment with Thinner C immediately after use. Hardened and/or cured material can only be removed mechanically.

LIMITATIONS

- Do not apply in wet weather or to wet surfaces.
- Do not use Sikalastic® Metal Primer for indoor applications.
- Always ensure good ventilation when using Sikalastic® Metal Primer in a confined space, to ensure drying and full curing.
- Any surfaces left uncovered for a period of more than 7 days should be re-primed.

VALUE BASE

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

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 exact product data and uses.

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.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

According to the EU-Directive 2004/42, the maximum allowed content of VOC (Product category IIA / j type sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sikalastic® Metal Primer is < 500 g/l VOC for the ready to use product.

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.

TECHNICAL ENQUIRIES

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