

PRODUCT DATA SHEET

SikaCor®-6630 System

VERSATILE HIGH-BUILD COATING FOR STEEL AND GALVANIZING, NON-FERROUS METALS, PLASTIC AND TIMBER

PRODUCT DESCRIPTION

SikaCor®-6630 System and SikaCor®-6630 Primer

SikaCor®-6630 System 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.

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
- Excellent colour-shade retention and chalking resistance
- Non-brittling due to a unique binder combination

APPROVALS / STANDARDS

SikaCor®-6630 System and SikaCor®-6630 Primer are approved and controlled according to German standard 'TL/TP-KOR-Stahlbauten', page 93.

PRODUCT INFORMATION

Packaging	SikaCor®-6630 System	30 kg and 15 kg net.
	SikaCor®-6630 Primer	15 kg net.
	Sika® Thinner B	10 l and 3 l

Appearance / Colour

RAL colour shades.

SikaCor®-6630 Primer	Sand-yellow, redbrown, mat.-no. 693.02/06 resp. 677.01
SikaCor®-6630 System	RAL colour shades, mat.-no. 693.80-99

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	Min. 2 years		
Storage Conditions	In originally sealed containers in a cool and dry environment.		
Density	SikaCor®-6630 System	~1.4 kg/l	
	SikaCor®-6630 Primer	~1.5 kg/l	
Solid Content	Product	By volume	By weight
	SikaCor®-6630 System	~62%	~77%
	SikaCor®-6630 Primer	~62%	~79%

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 dilute 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).
Thermal Resistance	Dry heat up to + 80°C

SYSTEM INFORMATION

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

Thinner	Sika® Thinner B for SikaCor®-6630 System 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: <table border="1"><thead><tr><th>Product</th><th>SikaCor®-6630 System</th><th>SikaCor®-6630 Primer</th></tr></thead><tbody><tr><td>Dry (DFT)</td><td>80 µm</td><td>80 µm</td></tr><tr><td>Wet (WFT)</td><td>130 µm</td><td>135 µm</td></tr><tr><td>Consumption</td><td>~0.180 kg/m²</td><td>~0.195 kg/m²</td></tr><tr><td>VOC</td><td>~41.5 g/m²</td><td>~45.2 g/m²</td></tr></tbody></table>	Product	SikaCor®-6630 System	SikaCor®-6630 Primer	Dry (DFT)	80 µm	80 µm	Wet (WFT)	130 µm	135 µm	Consumption	~0.180 kg/m ²	~0.195 kg/m ²	VOC	~41.5 g/m ²	~45.2 g/m ²
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Product 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.															
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Waiting Time / Overcoating	Min. 1 day															
Drying time	Dust-dry after approx. 4 - 5 h Touch dry after approx. 8 - 10 h, but 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.															

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 EN ISO 12944, part 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 System 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 TOOLS

Sika® Thinner B for SikaCor®-6630 System

VALUE BASE

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

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

ECOLOGY, HEALTH AND SAFETY

Information on the safe handling of chemical products, as well as the essential physical, safety-related, toxicological and ecological data can be found in the current safety data sheets. Observe all relevant regulations, e.g. the hazardous substances act. Further notes and information data sheets on product safety and disposal can be found on the Internet at www.sika.de.

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

For product category IIA / i, Type SB, the maximum permissible content of VOC as per directive 2004/42/CE is 500 g/l (limit 2010).

The maximum content of SikaCor®-6630 System and SikaCor®-6630 Primer remains below 500 g/l VOC.

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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