

## PRODUCT DATA SHEET

## Sikagard®-63 N

## 2-Part epoxy-novolac based chemical resistant protective coating

## DESCRIPTION

Sikagard®-63 N is a 2-part, epoxy-novolac resin based, chemical resistant protective coating. It can be used on many types of structures or elements with mineral, metallic or resin-based substrates. The high chemical resistance provides surface protection from aggressive chemicals that can cause rapid degradation.

## USES

Sikagard®-63 N may only be used by experienced professionals.

Chemical resistant protective coating on:

- Concrete
- Stone
- Cementitious mortars
- Renderings
- Epoxy cement
- Epoxy resin-based products
- Steel

Chemical resistant protective lining for:

- Silos
- Bund linings
- Chemical mixing tanks
- Chemical containment tanks
- Fuel and oil tanks
- Sludge tanks
- Industrial chemical areas

Anti-corrosion coating on steel elements within:

- Food processing plants
- Sewage treatment works
- Chemical and pharmaceutical facilities

## FEATURES

- High chemical resistance
- Good temperature resistance
- Low VOC emissions
- High build
- Impervious to liquids
- Easy to mix
- Can be applied by brush, roller or airless spray

## SUSTAINABILITY

- Conformity with LEED v4.1 MR: Environmental Product Declarations (Option 1)
- Conformity with LEED v4 MRc 4 (Option 2): Building Product Disclosure and Optimization - Material Ingredients
- Conformity with LEED v2009 IEQc 4.2: Low-Emitting Materials - Paints and Coatings

## CERTIFICATES AND TEST REPORTS

- CE Marking and Declaration of Performance to EN 1504-2 - Surface protection product for concrete - Coating

## PRODUCT INFORMATION

Composition	Epoxy novolac resin	
Packaging	10 kg Kit consisting of:	
	Part A	8.7 kg pail
	Part B	1.3 kg pail
Refer to current price list for packaging variations		

Appearance and colour	Standard colour: ~RAL 7032 (pebble grey) Other colours on request.
Shelf life	12 months from date of production if sored at below mentioned storage conditions.
Storage conditions	The product must be stored in original, unopened and undamaged pack-aging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging.
Density	Mixed Resin: ~ 1.44 kg/l Value at +23 °C (EN ISO 2811-1)
Product declaration	EN 1504-2 - Surface protection product for concrete - Coating
Solid content by mass	~100 %

## TECHNICAL INFORMATION

<b>Tensile adhesion strength</b>	> 2.5 MPa to concrete		(EN 1542)
<b>Chemical resistance</b>	Resistant to many chemicals. Contact Sika Technical Services for additional information.		
<b>Temperature resistance</b>	<b>Exposure</b>	<b>Dry heat</b>	
	Permanent	+40 °C	
	Maximum 3 days	+60 °C	
<b>Permeability to water vapour</b>	S <sub>D</sub> -value = 62 m (Class III)		(EN ISO 7783)
<b>Permeability to carbon dioxide</b>	S <sub>D</sub> -value > 1000 m		(EN 1062-6)

## APPLICATION INFORMATION

<b>Mixing ratio</b>	Part A : Part B = 87 : 13 by weight			
<b>Consumption</b>	<p>~0.15 kg/m<sup>2</sup> per layer, minimum 2 layers required. For harsh conditions 3 layers are required.</p> <p>One 10 kg pail will cover ~33 m<sup>2</sup> if applied with the minimum layer thickness of 200 µm in two layers respectively ~22 m<sup>2</sup> for a three-layer build-up with ~300 µm thickness.</p> <p>These consumptions are theoretical and can vary according to the absorption and roughness of the substrate. It is essential to carry out representative trials on site to evaluate the exact consumption.</p>			
<b>Layer thickness</b>	~0,1 mm per layer; minimum 2 layers required			
<b>Ambient air temperature</b>	+10 °C min. / +30 °C max.			
<b>Relative air humidity</b>	≤ 80 %			
<b>Dew point</b>	Beware of condensation! The substrate and uncured applied floor material must be at least +3 °C above dew point to reduce the risk of condensation or blooming on the finish.			
<b>Substrate temperature</b>	+10 °C min. / +40 °C max			
<b>Pot Life</b>	<b>Temperature</b>	<b>Pot life</b>		
	+10 °C	~30 minutes		
	+20 °C	~20 minutes		
	+30 °C	~10 minutes		
<b>Waiting time to overcoating</b>	<b>Temperature</b>	<b>Min.</b>	<b>Max.</b>	<b>Full Cure</b>
	+10 °C	~9 hours	~3 days	~14 days
	+20 °C	~5 hours	~2 days	~9 days
	+30 °C	~4 hours	~1 day	~5 days

## BASIS OF PRODUCT DATA

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.

## IMPORTANT CONSIDERATIONS

- The product shall not be diluted at any time during application.
- Do not apply Sikagard®-63 N on moist substrates.
- Sag resistance on vertical surface is  $\leq 100 \mu\text{m}$ .
- Do not use to produce glass fibre reinforced linings.
- Protect freshly applied product from rain, condensation and water for at least 24 hours.
- For consistent colour matching, ensure the Sikagard®-63 N in each area is applied from the same control batch numbers.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

Substrates must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings, laitance, surface treatments, loose friable materials and any other surface contaminants that could affect adhesion.

#### Concrete / Stone / Cementitious mortars & rendering

Concrete must be at least 3–6 weeks old.

Substrates must be prepared mechanically using suitable abrasive blast cleaning or planing / scarifying equipment to remove cement laitance and achieve an open textured gripping surface profile suitable for the product thickness.

High spots can be removed by grinding.

Weak substrates must be removed and surface defects such as blow holes and voids must be fully exposed.

Repairs to the substrate, filling of cracks, blowholes / voids and surface levelling must be carried out using products from the Sika® range of materials. Products must be cured before applying Sikagard®-63 N. If the moisture content exceeds 4%, Sikagard®-720 EpoCem® or Sikagard®-385 EpoCem® must be applied as a temporary moisture barrier.

**Steel / aluminium** Surfaces must be prepared mechanically using suitable abrasive blast cleaning, grinding, rotating wire brush or other suitable equipment to achieve a bright metal finish. Reference must be made to the preparation levels in the following standards if compliance is required:

- ISO EN 12944-4: level Sa 2 ½
- NACE International Standard: SSPC-SP 10 “near white metal blast cleaned”
- EN 14879, part 1

Apply a suitable compatible primer on the prepared steel as soon as possible to prevent oxide development. Contact Sika Technical Services for additional support.

### Epoxy resin-based products

Surfaces must be prepared by abrading using suitable equipment.

### General Note

All dust, loose and friable material must be completely removed from all surfaces before application of the product and associated system products, preferably by vacuum extraction equipment.

Avoid dew point conditions before and during product application.

### Priming

With the exception of metal surfaces, all substrates must be primed with a suitable resin-based primer like e.g. Sikafloor®-150 plus, Sikafloor®-151 or Sikagard® P 770 before application of Sikagard®-63 N. Please refer to the PDS of the primer for more detailed information.

## MIXING

Prior to mixing both parts, mix Part A (resin) separately using an electric single paddle mixer (300–400 rpm) or other similar equipment to mix liquid and all the coloured pigment until a uniform colour has been achieved. Add Part B (hardener) to Part A and mix continuously for 3 minutes until a uniformly coloured mix has been achieved. To ensure thorough mixing, pour materials into a clean container and mix again for at least 1 minute to achieve a smooth consistent mix. Excessive mixing must be avoided to minimise air entrainment. During the final mixing stage, scrape down the sides and bottom of the mixing container with a straight edge trowel or spatula at least once to ensure complete mixing. Mix full units only. Total mixing time for A+B: ~4 minutes.

## APPLICATION

Reference must be made to further documentation where applicable, such as relevant method statement, application manual and installation or working instructions.

Prior to application, confirm substrate moisture content, relative air humidity, dew point, substrate, air and product temperatures.

Apply Sikagard®-63 N onto the prepared substrate evenly using a roller, brush or airless spray at the required consumption rate. Minimum two coats are required. Respect the waiting times before application of the second coat.

## CLEANING OF EQUIPMENT

Clean all tools and application equipment with a suitable solvent based cleaner immediately after use. Hardened material can only be removed mechanically.

## LOCAL RESTRICTIONS

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

## LEGAL NOTES

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

### Sika Danmark A/S

Hirsemarken 5  
3520 Farum  
Tlf. +45 48 18 85 85  
[www.sika.dk](http://www.sika.dk)



### PRODUCT DATA SHEET

Sikagard®-63 N

July 2025, Version 04.01  
020303120020000061

Sikagard-63N-en-DK-(07-2025)-4-1.pdf