BUILDING TRUST

PRODUCT DATA SHEET

Sikagard®-63 N

2-PART EPOXY PROTECTIVE COATING

DESCRIPTION

Sikagard®-63 N is a two part, rigid, total solid, coloured epoxy resin based protective coating.

USES

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

- Chemical resistant protective layer on concrete, stone, cementitious mortars and renderings, epoxy cement, epoxy resin based products and steel
- Lining in storage tanks and silos
- Anti-corrosion coating on steel in food processing plants, sewage works, farms, agricultural enterprises, chemical and pharmaceutical facilities and beverage industry

CHARACTERISTICS / ADVANTAGES

- Solvent free
- Good mechanical and chemical resistance
- High build
- Impervious to liquids
- Easy to mix and to apply

SUSTAINABILITY

Conformity with LEED v2009 IEQc 4.2: Low-Emitting Materials - Paints and Coatings

APPROVALS / CERTIFICATES

Coating for concrete protection according the requirements of EN 1504-2/2004, DoP 020606010030000000011008, certified by FPC Notified Body and provided with CE-Marking.

PRODUCT INFORMATION

Composition	Epoxy resin	
Packaging	Part A	8.70 kg drums
	Part B	1.3 kg drums
Appearance / Colour	RAL 7032 (pebble grey), other on request	
Shelf life	12 months from date of production	
Storage conditions	The packaging must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +30 °C. Protected from direct sunlight.	

Density	Mixed resin approx. 1.35 kg/l Density values determined at +23 °C	(EN ISO 2811-1)
Solid content	~100 %	

TECHNICAL INFORMATION

Tensile Adhesion Strength	> 1.5 N/mm² to concrete >15 N/mm² to steel >10 N/mm² to aluminium	(ISO 4624) (EN 24624) (EN 24624)
Chemical Resistance	For further information please contact Sika Technical Service.	

Temperature Resistance

Exposure	Dry heat
Permanent	+40 °C
max. 3 days	+60 °C

Diffusion Resistance to Water Vapour	µH2O ~ 100 000	(EN ISO 7783-1)

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 83 : 17 by weight
Consumption	~0.15 kg/m² per layer
Layer Thickness	~0.1 mm per layer
Ambient Air Temperature	+10 °C min. / +30 °C max.
Relative Air Humidity	< 80 %
Substrate Temperature	+10 °C min. / +40 °C max. Minimum 3 °C above dew point, beware of condensation

Pot Life

Temperature	Time
+10 °C	~30 min
+20 °C	~20 min
+30 °C	~10 min

Waiting Time / Overcoating

Temperature	Min.	Max.	Full Cure
+10 °C	~9 hours	~3 days	~14 days
+20 °C	~5 hours	~2 days	~9 days
+30 °C	~4 hours	~1 day	~5 days

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

The substrate must be sound, clean, dry, free from contaminants such as dirt, grease, oil, old coatings, release agents, laitance and other adhesion preventing or influencing substances.
On high absorbent, non-sound, contaminated, not cement based substrates precautions have to be taken and a suitable primer has to be used.

SUBSTRATE PREPARATION

Concrete Substrates
Concrete substrate must be prepared mechanically to achieve an open textured surface.
Weak areas in the substrate must be removed and surface defects such as blowholes and voids must be fully exposed.
All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush and/or vacuum.
Open voids and blowholes need to be closed with a suitable Sika® pore filling mortar. The roughness of the substrate needs to be levelled with a suitable Sika® rendering and levelling mortar.

Steel Surface
Steel surface must be prepared mechanically using abrasive blast cleaning. The level SSPC-SP 10 “near white metal blast cleaned” or level Sa 2 ½ according to ISO EN 12944-4 has to be achieved. Welds and joints have to be prepared according to EN 14879, part 1. After blast cleaning remove all dust dirt and blasting material. In order to maintain the surface conditions after blast cleaning air-conditioning is recommended.

MIXING

Prior to mixing stir part A mechanically. When all of part B has been added to part A mix continuously for 3 minutes until a uniform mix has been achieved. Use a low speed electrical stirrer (300–400 rpm) to avoid air

entrapment. To ensure proper mixing pour material into a clean container and stir again.

APPLICATION

Apply by brush, roller or airless spray.

CLEANING OF EQUIPMENT

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

IMPORTANT CONSIDERATIONS

- Do not apply Sikagard®-63 N on moist substrates.
- Sag resistance on vertical surface is < 100 µm.
- Sikagard®-63 N cannot be used to produce glass fibre reinforced linings.
- Freshly applied Sikagard®-63 N must be protected from rain, condensation and water for at least 24 hours.
- For exact colour matching ensure using material from the same control batch numbers.

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.

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.

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.

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 Sikagard®-63 N is <500 g/l VOC for the ready to use product.

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 of 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.