

# PRODUCT DATA SHEET

## SikaCor® Zinc R

Low-solvent Epoxy zinc-rich primer for steel

### PRODUCT DESCRIPTION

2-pack, highly pigmented zinc-rich primer of low solvent content, based on epoxy resin.  
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

SikaCor® Zinc R installation works to be carried out only by Sika Approved Contractors. Please observe information given by Product Data Sheets.

Robust corrosion protection primer for steel offering a wide range of applications.

Mainly for bridges, pipe lines, containers, industrial and harbour installations, sewage treatment plants and large machinery; submerged or non-submerged in industrial or marine environments.

Particularly suited for workshop application as heavy duty transportable coating.

In a dry film thickness of 20 µm SikaCor® Zinc R can also be employed as welding primer. Test report is available upon request.

### CHARACTERISTICS / ADVANTAGES

- Excellent corrosion protection
- Mechanically extraordinary resistant
- Extremely high water and condensation water resistance
- Fast drying and curing characteristics

### APPROVALS / STANDARDS

- Approved according to German standard 'TL/TP-KOR-Stahlbauten, Blatt 87'.
- Approved according to Austrian standard RVS 15.05.11 and RVS 08.09.02.

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor® Zinc R	26 kg, 15 kg and 7 kg net.
	Sika® Thinner K	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
<b>Appearance / Colour</b>	Zinc grey, mat.-no. 687.03 Tinted red, mat.-no. 687.04	
<b>Shelf Life</b>	1 year	
<b>Storage Conditions</b>	In original sealed containers in a cool and dry environment.	
<b>Density</b>	~2.9 kg/l	
<b>Solid Content</b>	~67 % by volume	

~89 % by weight

## TECHNICAL INFORMATION

<b>Chemical Resistance</b>	The fully cured material is resistant to weathering, water and mechanical wear.
<b>Thermal Resistance</b>	Dry heat up to approx. + 150°C, short term up to max. + 200°C Damp heat up to approx. + 50°C

## SYSTEM INFORMATION

<b>Systems</b>	<b>Steel</b>  Without top coat: 2 x SikaCor® Zinc R  For priming under intermediate coat: 1 x SikaCor® Zinc R  Weldable shop primer: 1 x SikaCor® Zinc R, dry film thickness 20 µm.  Suitable intermediate and top coats: Universally recoatable with 1- and 2-pack products of Sika Deutschland GmbH.
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## APPLICATION INFORMATION

<b>Mixing Ratio</b>		<b>Components A : B</b>	
	By weight	94 : 6	
	By volume	4.4 : 1	
<b>Thinner</b>	Sika® Thinner K If necessary max. 3 % Sika® Thinner K may be added to adapt the viscosity. In case of using as weldable shop primer add ~12 % b.w. Sika® Thinner K.		
<b>Consumption</b>	Theoretical material-consumption/VOC without loss for medium dry film thickness:		
	Dry film thickness	60 µm	80 µm*)
	Wet film thickness	90 µm	120 µm
	Consumption	~0.260 kg/m <sup>2</sup>	~0.345 kg/m <sup>2</sup>
	VOC	~29 g/m <sup>2</sup>	~38 g/m <sup>2</sup>
	*) for spray application Apart from small areas the dry film thickness of SikaCor® Zinc R should not exceed 150 µm per layer.		
<b>Product Temperature</b>	Min. + 5°C		
<b>Relative Air Humidity</b>	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.		
<b>Surface temperature</b>	Min. + 5°C		
<b>Pot Life</b>	At + 10°C	~12 h	
	At + 20°C	~8 h	
	At + 30°C	~5 h	

	DFT 20 µm	DFT 80 µm
+ 5°C after	1 h	3 h
+ 10°C after	1 h	2.5 h
+ 20°C after	45 min	2 h
+ 40°C after	30 min	1.5 h
+ 80°C after	20 min	45 min

**Waiting Time / Overcoating**

Min. until drying stage 6 is achieved  
 Max. 1 year  
 In case of longer waiting times please contact Sika.

Prior to further applications possible contamination must be removed.

**Drying time****Final drying time**

Depending on film thickness and temperature full hardness is achieved after 1 - 2 days.

If used as primer for a coating system with top coats the final drying time depend on them and the full hardness is usually achieved after 1 - 2 weeks, depending on film thickness and ambient temperature. Tests of the completed system should only be carried out after final drying.

**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.

**ECOLOGY, HEALTH AND SAFETY**

Local safety regulations must be observed and it advisable to wear PPI when working with this product with particular attention paid to cutting and handling. Transportation Class: The product is not classified as hazardous good for transport. Disposal: The material is recyclable. Disposal must be according to local regulations. Please contact your local Sika sales organisation for more information.

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

According to the EU Directive 2004/42/CE, 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 SikaCor® Zinc R is < 500 g/l VOC for the ready to use product.

**APPLICATION INSTRUCTIONS****SURFACE PREPARATION**Steel:

Blast-cleaning to Sa 2 ½ according to ISO 12944-4. Free from dirt, oil and grease.

For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.

**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.

**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 brushConventional high pressure spraying:

- Nozzle size 1.7 - 2.5 mm
- Pressure 3 - 4 bar
- Oil and water trap is compulsory

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**

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 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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### Product Data Sheet

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