

# PRODUCT DATA SHEET

## Sikalastic® Metal Primer

TWO-COMPONENT EPOXY PRIMER FOR EXPOSED METAL AND BITUMEN SUBSTRATES.

### 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

<b>Composition</b>	Epoxy, solvent borne and polyamide curative
<b>Packaging</b>	5.0 l (~7.17 kg) containers Component A: 2.5 l (~3.7 kg) Component B: 2.5 l (~3.47 kg)
<b>Appearance / Colour</b>	Component A: pearl grey liquid resin Component B: brown liquid resin
<b>Shelf life</b>	12 months from date of production
<b>Storage conditions</b>	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.
<b>Density</b>	~1.43 kg/l (23 °C) <span style="float: right;">(EN ISO 2811-1)</span>

## APPLICATION INFORMATION

<b>Mixing Ratio</b>	Component A : Component B = 1:1 (by volume)																
<b>Consumption</b>	Apply in one coat, with a consumption of 0.15 l/m <sup>2</sup> approx. (0.20 kg/m <sup>2</sup> approx.) per coat depending upon surface roughness and absorption.																
<b>Ambient Air Temperature</b>	+5 °C min. / +40 °C max.																
<b>Relative Air Humidity</b>	80 % r.h. max.																
<b>Dew Point</b>	Beware of condensation. The substrate and uncured coating must be ≥3 °C above dew point to reduce.																
<b>Substrate Temperature</b>	+5 °C min. / +40 °C max.																
<b>Substrate Moisture Content</b>	Visibly free from moisture and condensation																
<b>Waiting Time / Overcoating</b>	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>Minimum waiting time</th><th>Maximum waiting 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> 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.	Substrate temperature	Minimum waiting time	Maximum waiting 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 2 1/2 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 EQUIPMENT

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

## IMPORTANT CONSIDERATIONS

- 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.

## 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.

## 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

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 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.

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