



Icosit® 6630

Polyurethane Alkyd Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit 6630 is a low VOC, one component, high build polyurethane alkyd coating for steel and galvanized structures.

USES

- * Duplex coating of galvanized masts, towers, gates etc.
- * Maintenance coating for bridges, towers, masts etc.
- * High build corrosion protection for pipelines etc.
- * Maintenance/new coating for street furniture.

ADVANTAGES

- * Low VOC.
- * Very mild solvent, suitable for maintenance painting over unknown single component paints.
- * Direct site application to new hot dip galvanized structures.
- * Excellent colour retention.
- * Excellent weathering properties and corrosion protection.
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- * Does not require 'T' wash or etch primer primer when applied to new/weathered galvanized substrates.

Technical Data

Colour:	Available in a selection of RAL and BS4800 colours and tinted to suit customer requirements. Refer to Sika standard colour shade chart.	
Finish:	Semi gloss	
Density (SG):	1.4 kg/litre	
Volume solids:	63%	
Typical film thickness per coat:	100 - 150 microns dry 160 - 240 microns wet	
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point	
Coverage:	8 m ² /litre @ 80 microns dft	
Service temperature:	Max dry heat +80°C Max damp heat +50°C	
Method of Application:	Airless spray, brush or roller	
Drying times:	20°C	30°C
Touch dry (mins):	60	30
Hard dry (hours):	24	18
Overcoating:		
Min (hours)	24	24
Max (weeks)		unlimited
No of coats:	1-2 depending on exposure (see ISO 12 944 Pt 5)	
VOC:	299 g/litre	
Flashpoint:	34°C	
All above values are approximate.		

SURFACE PREPARATION

Coated surfaces:

Icosit 6630 is an intermediate/finishing coat which should be applied over a sound, prepared, primed or coated surface.

Test areas in accordance with ISO 129 44 should be carried out to confirm compatibility and adhesion.

The surface to be coated should be dry and free from contaminants, such as dust, oil, grease, algal growth etc.

Galvanized surfaces:

Refer to **Sika®** Galvanized Steel Duplex Guidelines. Available on request.

MIXING

Stir thoroughly before use. DO NOT THIN.

APPLICATION

Airless spray: Typically 100 - 300 microns per coat wft on vertical surfaces

Tip range 0.38 - 0.66 mm (15 - 25 thou)
Output fluid pressure at tip
Min (141 kg/cm²) (2000 psi)

Brush: Typically 150 - 200 microns per coat wft on vertical surfaces

Roller: Typically 75 - 150 microns per coat wft on vertical surfaces

THINNING

When applying by brush or roller **Sika® Thinner B** up to 10% by volume may be used to improve workability. For airless spraying thinning is not necessary.

IMPORTANT CONSIDERATIONS

- * Colour shade may vary from colour cards.
- * Apply only to dry surfaces.
- * Do not apply during mist or fog conditions or when snow or rain is imminent.
- * Avoid condensation on the coating during the initial drying period.
- * Apply in ventilated areas

CLEANING OF EQUIPMENT

Use **Thinner B**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 8 m²/litre @ 80 microns dft. These figures do not allow for surface porosity, profile or wastage).

STORAGE AND SHELF LIFE

Minimum 24 months in sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Please consult our Technical Sales Department for further information

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