



Icosit® Poxicolor

Epoxy Combination Finishing Coat

Technical Data Sheet

DESCRIPTION

Icosit Poxicolor is a low VOC, two component, high solids, epoxy combination finishing coat for steel and galvanized structures.

USES

- * Bridges.
- * Coastal structures.
- * Sewage treatment plants.
- * Highway structures.
- * Pipelines.

ADVANTAGES

- * Low VOC.
- * Low solvent.
- * High solids - economical coating.
- * Duplex system for galvanized structures.
- * Fast curing.
- * Excellent corrosion protection.
- * Does not require 'T' wash or etch 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:	Eggshell		
Density (SG):	1.6 kg/litre		
Volume solids:	76%		
Typical film thickness per coat:	100 - 120 microns dry 130 - 155 microns wet		
Application temperatures & humidity conditions:	+5°C minimum (substrate and ambient) +3°C (5°F) above the dew point		
Coverage:	7.6 m ² /litre @ 100 microns dft		
Service temperature:	Max dry heat +150°C Max damp heat +80°C		
Method of Application:	Airless spray, brush or roller		
Drying times:	10°C	20°C	30°C
Hard dry (hours):	6	4	1
Overcoating:			
Min (hours)	24	24	24
Max (weeks)	----- unlimited -----		
Mix ratio: (A:B)	88:12 by wt		
No of coats:	1 - 2		
In accordance with ISO 12 944 Pt 5			
Pot life: (hours)	20°C	30°C	
	8	5	
VOC:	200 g/litre		
Flashpoint:	Pt A 25°C Pt B 35°C		

All above values are approximate.

SURFACE PREPARATION

Coated surfaces:

Icosit Poxicolor 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

Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components.

APPLICATION

Airless spray: Typically 130 - 150 microns per coat wft on vertical surfaces

Tip range 0.42 - 0.53 mm (15 - 23 thou)
Output fluid pressure at tip
Min (212 kg/cm²) (2000 psi)

Brush: Typically 75 - 100 microns per coat wft on vertical surfaces

Roller: Typically 75 - 100 microns per coat wft on vertical surfaces

THINNING

Depending on ambient temperature addition of up to 5% of **Sika Thinner EG** may be required to improve atomisation.

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 EG**. Hardened material may have to be mechanically removed.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 7.6 m²/litre @ 100 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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