



# Icosit<sup>®</sup> SW 500

## Solvent Free Epoxy Coating

### Technical Data Sheet

#### DESCRIPTION

Icosit SW 500 is a two component, highly abrasive resistant, solvent free epoxy coating. Steel surfaces require no priming before application of the product.

#### USES

- \* Hydraulic steel structures.
- \* Sheet steel piles.
- \* Penstocks/gates.
- \* Valves.
- \* Harbour deck installations.

#### ADVANTAGES

- \* Solvent free.
- \* Tar free.
- \* Isocyanate free.
- \* Extreme abrasion resistance.
- \* Application by airless spray.
- \* 500 microns to 1000 microns in one application.
- \* More flexible and equally abrasion resistant to most high quality glass flake epoxy systems.

#### Technical Data

<b>Colour:</b>	Black, Red Brown Grey (approx RAL 7032)		
<b>Finish:</b>	Semi Gloss		
<b>Density (SG):</b>	1.5 kg/litre		
<b>Volume solids:</b>	100%		
<b>Typical film thickness per coat:</b>	500 - 1000 microns		
<b>Application temperatures:</b>	0°C min, +40°C max (ambient)		
<b>Coverage:</b>	2 m <sup>2</sup> /litre @ 500 microns dft		
<b>Service temperature:</b>	Max dry heat +100°C Max damp heat +40°C		
<b>Method of Application:</b>	Airless spray (brush for small areas)		
<b>Drying times:</b>	<b>+5°C</b>	<b>+23°C</b>	<b>+40°C</b>
Hard dry (hours):	48 hours	12 hours	3 hours
Overcoating times:	48 hours	12 hours	3 hours
<b>Final drying time:</b> (20°C)	1 week		
<b>Mix ratio:</b> (A:B)	82:18 by wt		
<b>No of coats:</b>	1 or 2 (depending on exposure)		
<b>Pot life:</b> (hours)	<b>15°C</b> 1 hour	<b>20°C</b> 45 mins	<b>30°C</b> 25 mins
<b>VOC:</b>	0 g/litre		
<b>Flashpoint:</b>	Pt A 101°C Pt B 101°C		

All above values are approximate.

## SURFACE PREPARATION

### Steel:

Blast clean to SA 2.5 according to ISO 129 44 Pt 4 to produce a peak trough amplitude of 100 microns.

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

## MIXING

Stir component A and B thoroughly before use. Always mix complete units as supplied. Power agitate component A, add component B and completely mix both components (approx 3 minutes). It is advisable to preheat materials to 20°C at low temperatures before mixing.

## APPLICATION

**Airless spray:** Typically 500 - 1000 microns per coat wft on vertical surfaces. High performance airless pump such as Graco King (transmission 1:68) with air supply 5 m<sup>3</sup>/mm 8 bar initial pressure.

Hose diameter - 8mm  
Hose length <20m if possible  
In line heaters - recommended to achieve 20°C at nozzle.

Tip range 0.53 - 0.66 mm  
Spray angle 40°-80°

**Brush:** Typically 250 - 400 microns per coat wft on vertical surfaces

## THINNING

**Thinner S** max 4% by weight.

## IMPORTANT CONSIDERATIONS

- \* 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.
- \* Do not use as a foot or vehicle traffickable coating.
- \* Maximum overcoating time 3 months.
- \* Moisture exposure during curing may cause colour shade variations. This will not affect technical performance.

## CLEANING OF EQUIPMENT

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

## PACKAGING

Refer to latest price list

## CONSUMPTION

Approximately 2 m<sup>2</sup>/litre @ 500 microns dft. (These figures do not allow for surface porosity, profile or wastage).

## STORAGE AND SHELF LIFE

Minimum 12 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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