Product Data Sheet
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Construction

Icosit® 6630 High Solid

Universal High-build Coating, for Protection against Corrosion and Weathering

Product Description	**Icosit® 6630 High Solid** is a low-solvent, oxidative drying, high-build coating based on a specially modified synthetic resin combination with active corrosion protection pigments. Suitable for use in hot and tropical climates.
Uses	■ For weather resistant, thick coatings on steel and galvanized surfaces From rural to industrial and marine atmospheres: pipelines, bridges, facades, roofs, lattice masts, street furniture, wall cladding, outside protection of silos etc. ■ For coatings on galvanized steel - test report is available. ■ Particularly suited as maintenance coat on top of old coating systems. ■ Universally applicable on stainless steel, copper, aluminum, hard PVC. ■ Not suitable for windows and doors.
Advantages	■ Low solvent content, easily applied and environmental friendly ■ Excellent corrosion protection even in chemically aggressive atmospheres ■ Excellent adhesion directly to steel, galvanized surfaces, stainless steel, copper, aluminum and hard PVC ■ Good corrosion protection even in case of manually de-rusted surfaces ■ Excellent colour-shade retention and chalking resistance ■ Non-brittling due to a unique binder combination.
Test Report	**Icosit® 6630 High Solid** and Icosit® 6630 Primer have been tested and approved by German Railways and comply with TL 918 300, page 93

Product Data

Type	Synthetic Resin
Grades	Icosit® 6630 Primer, red-brown, Mat.-Nr. 693.02/06 **Icosit® 6630 High Solid**, metallic shades, Mat.-Nr. 693.12-14 **Icosit® 6630 High Solid**, metallic shades, Mat.-Nr. 693.30-74 **Icosit® 6630 High Solid**, RAL colour shades, Mat.-Nr. 693.80-99.
Colours	36 RAL and 14 metallic colour shades as per our colour shade card. In case of very intensive colour shades the colour pigments may be rubbed out of the surface. Therefore, wet-clean only and do not use for handrails and other building components in public areas. Slight colour shade deviations of the mentioned colour shades are unavoidable due to the nature of the raw materials.
Packaging	**Icosit® 6630 High Solid**: RAL colour shades: 30 and 15 kg. Metallic colour shades: 15 kg. Icosit® 6630 Primer, red-brown + grey: 15 kg. Thinner B: 25, 10, and 3 ltr.

Storage Condition	Store in moisture tight, closed and undamaged original containers at temperatures between + 5°C and + 25°C away from direct sunlight
Shelf life	12 months minimum from date of production if stored properly in original unopened packaging.

Technical Data

Coating system

Steel:
2-3 x **Icosit® 6630 High Solid**
in case of manual de-rusting: 1x Icosit 6630 Primer and 2 x Icosit 6630 high-solid.
Icosit Aktivprimer can also be used as a primer.

Galvanized surfaces, stainless steel, copper, aluminium and hard PVC:
2 x **Icosit® 6630 High Solid**

Maintenance coatings:
Patch-up with Icosit® 6630 Primer or Icosit Aktivprimer.
1-2 x **Icosit® 6630 High Solid**.

Material consumption

	Specific gravity liquid	**Solids content approx. ɀ**		**Theoretical layer thickness with a consumption of 100 g/m2**		**Theoretical mat. consumption for medium dry film thickness of**	
	approx. kg/ltr.	by vol.	By weight	wet microns	dry microns	microns	approx. kg/m²
Icosit® 6630 High Solid RAL-Colours	1,4	63	80	73	45	80 100	0,175 0,220
Icosit® 6630 Primer	1,5	62	80	68	42	80	0,190
DB (MIO)-colour shades	1,5	62	80	68	42	80	0,190

Chemical Resistance

Excellent resistance to rural, town, industrial and marine atmospheres as well as against temporary exposure to neutral salts.
Not resistant to continuous exposure of dilute acids and lyes, fatty oils, fuels, mineral oils etc.
Temporary short-term exposure does not harm.
Not suitable for continuous exposure to liquids (including water).
Service Temperature: +80°C

Application

Substrate preparation

Steel:
In case of aggressive industrial atmospheres or highly contaminated surfaces (e.g. by chlorides, sulphates, nitrates etc.):
Blast cleaning to Sa 2½ as per ISO 12 944, part 4.
In case of lower exposure as e.g. in rural atmospheres or indoors:
Manual surface preparation (power tool cleaning) to St 2 may be sufficient.

Galvanized surfaces, stainless steel, copper, aluminium, hard PVC:
Free of dirt, oil, fat and other contamination.

Maintenance of existing coating systems:
In case of well adhering old coating systems, careful cleaning (e.g. by high pressure water jetting) is sufficient. Loose particles must be removed and defective areas must be de-rusted to partially PSa 2% PMa or PSt 2 and subsequently patch-primed with Icosit® 6630 Primer.

Mixing

Icosit® 6630 High Solid is supplied ready for use. Stir well prior to application.

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Application	The method of application has a major effect on achieving uniform thickness and appearance. Spray application will usually give the best results. The indicated dry-film thickness is easily achieved by airless spray and usually also achievable by brush. Adding solvents reduces the sag resistance and the dry-film thickness. In case of application by roller, sometimes also by brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Before starting major coating operations, it may be useful to check with a test application on site whether the selected application method with the specified product will provide the desired results. **By brush or roller**. **Conventional high pressure spraying:** nozzle size 1,8 - 2,5 mm, pressure 3 - 5 bar. **By airless spray**: minimum pressure 180 bar at spray gun. Nozzle size 0,38 - 0,66 mm, spray angle 40-80°.
Application temperature	Minimum: +5°C. Maximum: +40ºC (ambient and substrate**)**
Waiting time between coats	Minimum 1 day.
Drying time	Dust-free after approximately 4-5 hours. Coated objects may be handled with care after approximately 8-10 hours but coating is still sensitive to scratches.
Final drying	Several days depending on film-thickness, temperature and ventilation. Full mechanical and chemical resistance is only achieved after final drying.
Cleaning	Clean tools and equipment immediately after use with Sika Thinner B. Do not use water or water-based cleaning liquids for equipment and tools!
Notes	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.
Safety	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.
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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