

PRODUCT DATA SHEET

SikaCor® Aktivprimer Rapid

PRIMER WITH ACTIVE ANTI-CORROSION PIGMENT FOR MANUALLY DE-RUSTED SURFACES, MAINTENANCE COATING, SWEEP-BLASTED GALVANIZING, ON STEEL, STAINLESS STEEL AND ALUMINIUM

DESCRIPTION

Quick-drying, 1-pack corrosion protection primer, containing zinc phosphate based on synthetic resin combination.
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

SikaCor® Aktivprimer Rapid may only be used by experienced professionals.
For surfaces and objects, where only manually de-rusting is possible and economical.
Suitable as high performance primer for surfaces blast-cleaned to Sa 2 ½, for stainless steel, aluminium and sweep-blasted galvanized surfaces.
Suitable for atmospherical corrosion protection and occasional condensation.
As intermediate coat / tie coat on well adhering old coating systems.

CHARACTERISTICS / ADVANTAGES

- Low solvent content, ecologically harmless
- VOC content < 350 g/l
- Versatilely overcoatable with 1-pack coatings and SikaCor® ZP Primer
- Economical
- High-build
- Fast-drying

PRODUCT INFORMATION

Packaging	SikaCor® Aktivprimer Rapid	15 kg net., 3 l and 0.75 l
	Sika® Thinner S	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
Appearance / Colour	Oxide red, beige yellow	
Shelf life	Min. 2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.6 kg/l	
Solid content	~60 % by volume	
	~78 % by weight	

TECHNICAL INFORMATION

Thermal Resistance Dry heat up to max. + 80°C

SYSTEM INFORMATION

Systems

Manually de-rusted steel:

1 x SikaCor® Aktivprimer Rapid
1 - 2 x top coat
Total dry film thickness: Min. 200 µm

Stainless steel, sweep-blasted galvanizing and aluminium:

1 x SikaCor® Aktivprimer Rapid
1 - 2 x top coat

Steel blast-cleaned to Sa 2 ½:

1 x SikaCor® Aktivprimer Rapid
1 - 2 x top coat

For atmospheric conditions SikaCor®-6630 High Solid is recommended as top coat.

Please note: If galvanized surfaces can't be sweep-blasted, SikaCor®-6630 Primer must be used!

APPLICATION INFORMATION

Thinner If necessary max. 2 % Sika® Thinner S may be added to adapt the viscosity.

Consumption

Theoretical material-consumption/VOC without loss for medium dry film thickness:

Dry film thickness	80 µm
Wet film thickness	130 µm
Consumption	~0.215 kg/m ²
VOC	~46.9 g/m ²

Product Temperature Min. + 5°C

Relative Air Humidity Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.

Surface Temperature Min. + 5°C

Drying Stage 6

	Dry film thickness 80 µm	(ISO 9117-5)
+ 5°C after	4 h	
+ 20°C after	3 h	

Waiting Time / Overcoating

Between priming coats:

After drying stage 6 is achieved (see above)

Between SikaCor® Aktivprimer Rapid and 1-pack top coats:

Min. 1 day at + 20°C

Between SikaCor® Aktivprimer Rapid and SikaCor® ZP Primer:

Min. 3 days at + 20°C

Drying time

Final drying time

Depending on film thickness, temperature and ventilation full hardness is achieved within several days.

Depending on local conditions full curing with top coat is achieved within 1 - 2 weeks.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Manually de-rusted surfaces:

Prepare surface by wire brush, trowel, power tool to surface preparation grade St 2 resp. St 3 according to ISO 12944-4.

Steel:

Blast-cleaning to Sa 2 ½ according to ISO 12944, part 4.

Galvanized surfaces:

Sweep-blasting to a uniform rough, grey surface is achieved.

Stainless steel and aluminium:

The substrate must be free from dirt, oil, grease and corrosion products.

Maintenance coatings:

In case of well adhering old coating systems, careful cleaning is sufficient. Loose particles must be removed, defective areas must be de-rusted to PSa 2 ½, PMa or PSt 2 and patch-primed with SikaCor® Aktivprimer Rapid.

For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.

MIXING

SikaCor® Aktivprimer Rapid is supplied ready for use. Stir thoroughly prior to application.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush and roller:

- As a good wetting and penetration into the substrate is essential for the efficiency of the priming coat, the best result is achieved by using a distemper brush or similar
- Dry film thickness per application 40 - 60 µm by brush application

Conventional high pressure spraying:

- Nozzle size 1.5 - 2.0 mm
- Pressure 4 - 6 bar

Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 65° - 80°
- Dry film thickness per application 60 - 80 µm by spray application

CLEANING OF TOOLS

Removal of fresh remnants from tools and application equipment can be carried out using SikaCor® Cleaner immediately after use. Hardened / cured material can only be mechanically removed.

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. 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

Information on the safe handling of chemical products, as well as the essential physical, safety-related, toxicological and ecological data can be found in the current safety data sheets. Observe all relevant regulations, e.g. the hazardous substances act. Further notes and information data sheets on product safety and disposal can be found on the Internet at www.sika.de.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

For product category IIA / i, Type SB, the maximum permissible content of VOC as per directive 2004/42/CE is 500 g/l (limit 2010).

The maximum content of SikaCor® Aktivprimer Rapid remains below 500 g/l VOC.

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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