

# SYSTEM DATA SHEET

## SikaCor®-6630 System

VERSATILE HIGH-BUILD COATING FOR STEEL AND GALVANIZING, NON-FERROUS METALS, PLASTIC AND TIMBER

### DESCRIPTION

The SikaCor®-6630 System consists of:  
**SikaCor®-6630 High Solid, SikaCor®-6630 High Solid EG, SikaCor®-6630 Primer and SikaCor®-6630 CU.**  
SikaCor®-6630 High Solid is a low-solvent, oxidative drying high-build coating with active corrosion protection pigments based on modified synthetic resin combination.  
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

SikaCor®-6630 System may only be used by experienced professionals.  
For weather resistant, high-build coatings on steel and galvanizing in rural to industrial and marine atmosphere: pipelines, bridges, metal facades, roofs, lattice masts, street lights, wall- and ceiling cladding, outside protection of silos.  
Suitability on galvanized steel is confirmed by independent test report.  
SikaCor®-6630 High Solid is particularly suited for maintenance coating.  
Versatile application on stainless steel, copper, aluminium and hard PVC and timber.  
Not suitable for windows and doors.

### CHARACTERISTICS / ADVANTAGES

- Low solvent content, easy to apply and environmental friendly
- Excellent corrosion protection even in chemically aggressive atmosphere
- Excellent adhesion to steel, galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber
- Good corrosion protection even on manually de-rusted surfaces
- Limited colour-shade retention and chalking resistance
- No brittleness due to an unique binder combination

## PRODUCT INFORMATION

<b>Packaging</b>	SikaCor®-6630 Primer	15 kg net.	
	SikaCor®-6630 High Solid	30 kg and 15 kg net.	
	SikaCor®-6630 High Solid EG	15 kg net.	
	SikaCor®-6630 CU old copper	12.5 kg net.	
	Sika® Thinner B	10 l and 3 l	
	Sika® Thinner S (only for SikaCor®-6630 CU old copper)	10 l and 3 l	
<b>Appearance / Colour</b>	RAL- and metallic colour shades:		
	SikaCor®-6630 Primer	Sand-yellow, redbrown	
	SikaCor®-6630 High Solid	RAL colour shades	
	SikaCor®-6630 High Solid EG	Mio colour shades	
	SikaCor®-6630 CU	Copper, old copper	
In case of very intensive colour shades the colour pigments may be rubbed out of the surface. Therefore do not use for hand rails and other building components in public areas. Slight colour deviations are possible due to raw material characteristics. In case of strong UV exposure brilliant colour shades tend to brighten up.			
<b>Shelf life</b>	24 months from date of production		
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.		
<b>Density</b>	SikaCor®-6630 Primer	~1.5 kg/l	
	SikaCor®-6630 High Solid	~1.4 kg/l	
	SikaCor®-6630 High Solid EG	~1.5 kg/l	
<b>Solid content</b>		<b>By volume</b>	<b>By weight</b>
	SikaCor®-6630 Primer	~62 %	~79 %
	SikaCor®-6630 High Solid	~62 %	~77 %
	SikaCor®-6630 High Solid EG	~61 %	~77 %

## TECHNICAL INFORMATION

<b>Chemical Resistance</b>	Excellent resistance to rural, urban, industrial and marine atmosphere and temporarily exposure to neutral salts.  Not resistant to continuous exposure to diluted acids and lyes, fatty oils, fuels, mineral oils etc. Temporarily short-term exposure does not harm. Not suitable for continuous exposure to liquids (including water).
<b>Temperature Resistance</b>	Dry heat up to + 80°C

## SYSTEMS

<b>Systems</b>	<u>Steel:</u> 2 - 3 x SikaCor®-6630 High Solid  <u>In case of manual de-rusting:</u> 1 x SikaCor®-6630 Primer or SikaCor® Aktivprimer Rapid 2 x SikaCor®-6630 High Solid  <u>Galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber:</u> 2 x SikaCor®-6630 High Solid  <u>Maintenance coatings:</u> Patch-up with SikaCor®-6630 Primer or SikaCor® Aktivprimer Rapid 1 - 2 x SikaCor®-6630 High Solid
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## APPLICATION INFORMATION

<b>Thinner</b>	Use Sika® Thinner B for SikaCor®-6630 High Solid and SikaCor®-6630 High Solid EG. If necessary max. 3 % Sika® Thinner B may be added to adapt the viscosity.  Use Sika® Thinner S for SikaCor®-6630 CU. If necessary max. 3 % Sika® Thinner S may be added to adapt the viscosity.																				
<b>Consumption</b>	Theoretical material-consumption/VOC without loss for medium dry film thickness: <table border="1"><thead><tr><th></th><th><b>SikaCor®-6630 Primer</b></th><th><b>SikaCor®-6630 High Solid</b></th><th><b>SikaCor®-6630 High Solid EG</b></th></tr></thead><tbody><tr><td>DFT</td><td>80 µm</td><td>80 µm</td><td>80 µm</td></tr><tr><td>WFT</td><td>130 µm</td><td>130 µm</td><td>135 µm</td></tr><tr><td>Consumption</td><td>~0.195 kg/m<sup>2</sup></td><td>~0.180 kg/m<sup>2</sup></td><td>~0.195 kg/m<sup>2</sup></td></tr><tr><td>VOC</td><td>~40.6 g/m<sup>2</sup></td><td>~41.5 g/m<sup>2</sup></td><td>~45.2 g/m<sup>2</sup></td></tr></tbody></table>		<b>SikaCor®-6630 Primer</b>	<b>SikaCor®-6630 High Solid</b>	<b>SikaCor®-6630 High Solid EG</b>	DFT	80 µm	80 µm	80 µm	WFT	130 µm	130 µm	135 µm	Consumption	~0.195 kg/m <sup>2</sup>	~0.180 kg/m <sup>2</sup>	~0.195 kg/m <sup>2</sup>	VOC	~40.6 g/m <sup>2</sup>	~41.5 g/m <sup>2</sup>	~45.2 g/m <sup>2</sup>
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<b>Product Temperature</b>	Min. + 5°C																				
<b>Relative Air Humidity</b>	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.																				
<b>Surface Temperature</b>	Min. + 5°C																				
<b>Waiting Time / Overcoating</b>	Min. 1 day																				
<b>Drying time</b>	Dust-dry after ~4 - 5 h Touch dry after ~8 - 10 h, but the coating is still sensitive to pressure																				
	<b>Final drying time</b> Several days depending on coating thickness, temperature and ventilation. Full mechanical and chemical resistance is only achieved after final drying.																				

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION

#### Steel:

In case of aggressive industrial atmosphere or highly polluted surfaces (e.g. by chlorides, sulphates, nitrates etc.):  
Blast cleaning to Sa 2 ½ according to ISO 12944, part 4.  
Free from dirt, oil and grease.

In case of lower exposure as e.g. in rural atmosphere or indoors, manual surface preparation (power tool cleaning) to St 2 is acceptable.

#### Galvanizing, stainless steel, copper, aluminium, hard PVC:

Free from dirt, oil, grease and corrosion products.

#### Maintenance coating:

In case of well adhering coating systems, careful cleaning (e.g. by water jetting) is sufficient.  
Loose particles must be removed, defective areas to be de-rusted to surface degree PSa 2 ½, PMA or PSt 2 and primed with SikaCor®-6630 Primer.

For contaminated and weathered surfaces e.g. galvanized or primed areas we recommend to clean with SikaCor® Wash.

### MIXING

SikaCor®-6630 High Solid is supplied ready for use.  
Stir well 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

#### Conventional high pressure spraying:

- Nozzle size 1.7 - 2.5 mm
- Pressure 3 - 5 bar

#### Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

## CLEANING OF EQUIPMENT

Use Sika® Thinner B for SikaCor® High Solid and for SikaCor®-6630 High Solid EG.  
Use Sika® Thinner S for SikaCor®-6630 CU.

## 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.

## 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

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

## VOC DATA

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / i type Sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of SikaCor®-6630 System is < 500 g/l VOC for the ready to use product.

## 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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System Data Sheet  
SikaCor®-6630 System  
October 2018, Version 03.01  
020601900000000002

SikaCor-6630System-en-GR-(10-2018)-3-1.pdf