

PRODUCT DATA SHEET

Sikagard®-63 N

2-part epoxy-novolac based chemical resistant protective coating

DESCRIPTION

Sikagard®-63 N is a 2-part, epoxy-novolac resin based, chemical resistant protective coating. It can be used on many types of structures or elements with mineral, metallic or resin-based substrates. The high chemical resistance provides surface protection from aggressive chemicals that can cause rapid degradation.

USES

Sikagard®-63 N may only be used by experienced professionals.

Chemical resistant protective coating on:

- Concrete
- Stone
- Cementitious mortars
- Renderings
- Epoxy cement
- Epoxy resin-based products
- Steel

Chemical resistant protective lining for:

- Silos
- Bund linings
- Chemical mixing tanks
- Chemical containment tanks
- Fuel and oil tanks
- Sludge tanks
- Industrial chemical areas

Anti-corrosion coating on steel elements within:

- Food processing plants
- Sewage treatment works
- Chemical and pharmaceutical facilities

CHARACTERISTICS / ADVANTAGES

- High chemical resistance
- Good temperature resistance
- Low VOC emissions
- High build
- Impervious to liquids
- Easy to mix
- Can be applied by brush, roller or airless spray

ENVIRONMENTAL INFORMATION

- Conformity with LEED v4.1 MR: Environmental Product Declarations (Option 1)
- Conformity with LEED v4 MRc 4 (Option 2): Building Product Disclosure and Optimization - Material Ingredients
- Conformity with LEED v2009 IEQc 4.2: Low-Emitting Materials - Paints and Coatings

CERTIFICATES AND TEST REPORTS

- CE Marking and Declaration of Performance to EN 1504-2 - Surface protection product for concrete - Coating

PRODUCT INFORMATION

Composition	Epoxy novolac resin
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Packaging	Part A	8.7 kg pail
	Part B	1.3 kg pail
	Part A + B	10.0 kg set
Appearance / Colour	Standard colour: ~RAL 7032 (pebble grey). Other colours on request.	
Shelf Life	12 months from date of production if stored at below mentioned storage conditions.	
Storage Conditions	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging.	
Density	Mixed Resin: ~ 1.44 kg/l Value at +23 °C	(EN ISO 2811-1)
Product Declaration	EN 1504-2 - Surface protection product for concrete - Coating	
Solid content by weight	~100 %	

TECHNICAL INFORMATION

Tensile Adhesion Strength	> 2.5 MPa to concrete	(EN 1542)
Chemical Resistance	Resistant to many chemicals. Contact Sika Technical Services for additional information.	
Temperature Resistance	Exposure	Dry heat
	Permanent	+40 °C
	Maximum 3 days	+60 °C
Permeability to Water Vapour	S _D -value = 62 m (Class III)	(EN ISO 7783)
Permeability to Carbon Dioxide	S _D -value > 1000 m	(EN 1062-6)

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 87 : 13 by weight	
Consumption	~0.15 kg/m² per layer, minimum 2 layers required. For harsh conditions 3 layers are required. One 10 kg pail will cover ~33 m² if applied with the minimum layer thickness of 200 µm in two layers respectively ~22 m² for a three-layer build-up with ~300 µm thickness. These consumptions are theoretical and can vary according to the absorption and roughness of the substrate. It is essential to carry out representative trials on site to evaluate the exact consumption.	
Layer Thickness	~0.1 mm per layer; minimum 2 layers required	
Ambient Air Temperature	+10 °C min. / +30 °C max.	
Relative Air Humidity	≤ 80 %	
Dew Point	Beware of condensation! The substrate and uncured applied floor material must be at least +3 °C above dew point to reduce the risk of condensation or blooming on the finish.	
Substrate Temperature	+10 °C min. / +40 °C max	
Pot Life	Temperature	Pot life
	+10 °C	~30 minutes
	+20 °C	~20 minutes
	+30 °C	~10 minutes

Waiting Time / Overcoating

Temperature	Min.	Max.	Full Cure
+10 °C	~9 hours	~3 days	~14 days
+20 °C	~5 hours	~2 days	~9 days
+30 °C	~4 hours	~1 day	~5 days

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.

IMPORTANT CONSIDERATIONS

- The product shall not be diluted at any time during application.
- Do not apply Sikagard®-63 N on moist substrates.
- Sag resistance on vertical surface is $\leq 100 \mu\text{m}$.
- Do not use to produce glass fibre reinforced linings.
- Protect freshly applied product from rain, condensation and water for at least 24 hours.
- For consistent colour matching, ensure the Sikagard®-63 N in each area is applied from the same control batch numbers.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

Substrates must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings, laitance, surface treatments, loose friable materials and any other surface contaminants that could affect adhesion.

Concrete / Stone / Cementitious mortars & rendering
Concrete must be at least 3–6 weeks old.

Substrates must be prepared mechanically using suitable abrasive blast cleaning or planing / scarifying equipment to remove cement laitance and achieve an open textured gripping surface profile suitable for the product thickness.

High spots can be removed by grinding.

Weak substrates must be removed and surface defects such as blow holes and voids must be fully exposed.

Repairs to the substrate, filling of cracks, blowholes / voids and surface levelling must be carried out using products from the Sika® range of materials. Products must be cured before applying Sikagard®-63 N.

If the moisture content exceeds 4 %, Sikagard®-720 EpoCem® or Sikagard®-385 EpoCem® must be applied as a temporary moisture barrier.

Steel / aluminium Surfaces must be prepared mechanically using suitable abrasive blast cleaning, grinding, rotating wire brush or other suitable equipment to

achieve a bright metal finish. Reference must be made to the preparation levels in the following standards if compliance is required:

- ISO EN 12944-4: level Sa 2 ½
- NACE International Standard: SSPC-SP 10 “near white metal blast cleaned”
- EN 14879, part 1

Apply a suitable compatible primer on the prepared steel as soon as possible to prevent oxide development. Contact Sika Technical Services for additional support.

Epoxy resin-based products

Surfaces must be prepared by abrading using suitable equipment.

General Note

All dust, loose and friable material must be completely removed from all surfaces before application of the product and associated system products, preferably by vacuum extraction equipment.

Avoid dew point conditions before and during product application. **Priming**

With the exception of metal surfaces, all substrates must be primed with a suitable resin-based primer like e.g. Sikafloor®-150 plus, Sikafloor®-151 or Sikagard® P 770 before application of Sikagard®-63 N. Please refer to the PDS of the primer for more detailed information.

MIXING

Prior to mixing both parts, mix Part A (resin) separately using an electric single paddle mixer (300–400 rpm) or other similar equipment to mix liquid and all the coloured pigment until a uniform colour has been achieved. Add Part B (hardener) to Part A and mix continuously for 3 minutes until a uniformly coloured mix has been achieved. To ensure thorough mixing, pour materials into a clean container and mix again for at least 1 minute to achieve a smooth consistent mix. Excessive mixing must be avoided to minimise air entrainment. During the final mixing stage, scrape down the sides and bottom of the mixing container with a straight edge trowel or spatula at least once to ensure complete mixing. Mix full units only. Total mixing time for A+B: ~4 minutes.

APPLICATION

Reference must be made to further documentation where applicable, such as relevant method statement, application manual and installation or working instructions.

Prior to application, confirm substrate moisture content, relative air humidity, dew point, substrate, air and product temperatures.

Apply Sikagard®-63 N onto the prepared substrate evenly using a roller, brush or airless spray at the required consumption rate. Minimum two coats are required. Respect the waiting times before application

of the second coat.

CLEANING OF TOOLS

Clean all tools and application equipment with a suitable solvent based cleaner immediately after use. Hardened material can only be removed mechanically.

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.

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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