

PRODUCT DATA SHEET

Sikagard[®]-63 N

2-PART EPOXY PROTECTIVE COATING / LINING SYSTEM

DESCRIPTION

Sikagard[®]-63 N is a two part, rigid, total solid, coloured epoxy resin based protective coating.

USES

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

- Chemical resistant protective layer on concrete, stone, cementitious mortars and renderings, epoxy cement, epoxy resin based products and steel
- Lining in storage tanks and silos
- Anti-corrosion coating on steel in food processing plants, sewage works, farms, agricultural enterprises, chemical and pharmaceutical facilities and beverage industry

CHARACTERISTICS / ADVANTAGES

- Solvent free
- Good mechanical and chemical resistance
- High build
- Impervious to liquids
- Easy to mix and to apply
- Resistant to Sulfuric Acid ~ 96% (immersion and Spill)
Please refer to Sika Technical department for further details

PRODUCT INFORMATION

Composition	Epoxy resin	
Packaging	Part A	8.70 kg drums
	Part B	1.3 kg drums
Appearance / Colour	Light grey	
Shelf life	24 months from date of production.	
Storage conditions	The packaging must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C	

and +30 °C. Protected from direct sunlight.

Density	Mixed resin approx. 1.35 kg/l Density values determined at +23 °C	(EN ISO 2811-1)
Solid content	~100 %	

TECHNICAL INFORMATION

Tensile Adhesion Strength	> 1.5 N/mm ² to concrete > 15 N/mm ² to steel >10 N/mm ² to aluminium	(ISO 4624) (EN 24624) (EN 24624)						
Chemical Resistance	For further information please contact Sika Technical Service.							
Temperature Resistance	<table><thead><tr><th>Exposure</th><th>Dry heat</th></tr></thead><tbody><tr><td>Permanent</td><td>+40 °C</td></tr><tr><td>max. 3 days</td><td>+60 °C</td></tr></tbody></table>	Exposure	Dry heat	Permanent	+40 °C	max. 3 days	+60 °C	
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Diffusion Resistance to Water Vapour	μH ₂ O ~ 100 000	(EN ISO 7783-1)						

SYSTEMS

Systems	<p>Standard Three Coat System: (DFT: from 600um - 800um)</p> <ul style="list-style-type: none">▪ <i>Primer:</i> Sikafloor 160 or 161 + <i>1st Coat:</i> Sikagard®-63 N + <i>2nd Coat:</i> Sikagard®-63 N <p>-----</p> <p>Fibreglass Laminate System: (DFT: from 1000um - 1200um) Subject to Glass thickness</p> <ul style="list-style-type: none">▪ <i>Primer:</i> Sikafloor 160, Fibreglass, Sikafloor 160 + <i>1st Coat:</i> Sikagard®-63 N + <i>2nd Coat:</i> Sikagard®-63 N <p>-----</p> <p>SikaGard EpoCem 720 System: (DFT: 1200um +) Subject to thickness of SikaGard EpoCem 720:</p> <p>Typically used on High Wear, Damaged or High moisture content substrate applications:</p> <ul style="list-style-type: none">▪ SikaGard EpoCem 720 + <i>1st Coat:</i> Sikagard®-63 N + <i>2nd Coat:</i> Sikagard®-63 N <p>-----</p> <p>Please refer to individual Product Data Sheets and consult the Sika Technical Department for specific Consumption Priming and Coverage Information pertaining to project requirements: Please see Important Considerations section at the bottom of this PDS</p>
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APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 83 : 17 by weight									
Consumption	~0.15 - 0.3kg kg/m ² per layer									
Layer Thickness	~0.1 - 0.3 mm per layer depending on substrate profile									
Ambient Air Temperature	+10 °C min. / +30 °C max.									
Relative Air Humidity	< 80 %									
Substrate Temperature	+10 °C min. / +40 °C max. Minimum 3 °C above dew point, beware of condensation									
Pot Life	<table><thead><tr><th>Temperature</th><th>Time</th></tr></thead><tbody><tr><td>+10 °C</td><td>~30 min</td></tr><tr><td>+20 °C</td><td>~20 min</td></tr><tr><td>+30 °C</td><td>~10 min</td></tr></tbody></table>	Temperature	Time	+10 °C	~30 min	+20 °C	~20 min	+30 °C	~10 min	
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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

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

The substrate must be sound, clean, dry, free from contaminants such as dirt, grease, oil, old coatings, release agents, laitance and other adhesion preventing or influencing substances.

On high absorbent, non-sound, contaminated, not cement based substrates precautions have to be taken and a suitable primer has to be used.

SUBSTRATE PREPARATION

Concrete Substrates

Concrete substrate must be prepared mechanically to achieve an open textured surface.

Weak areas in the substrate must be removed and surface defects such as blowholes and voids must be fully exposed.

All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush and/or vacuum.

Open voids and blowholes need to be closed with a suitable Sika® pore filling mortar. The roughness of the substrate needs to be levelled with a suitable Sika® rendering and levelling mortar.

Steel Surface

Steel surface must be prepared mechanically using abrasive blast cleaning. The level SSPC-SP 10 "near white metal blast cleaned" or level Sa 2 ½ according to ISO EN 12944-4 has to be achieved. Welds and joints have to be prepared according to EN 14879, part 1. After blast cleaning remove all dust dirt and blasting material. In order to maintain the surface conditions after blast cleaning air-conditioning is recommended.

MIXING

Prior to mixing stir part A mechanically. When all of part B has been added to part A mix continuously for 3 minutes until a uniform mix has been achieved. Use a low speed electrical stirrer (300–400 rpm) to avoid air entrapment. To ensure proper mixing pour material into a clean container and stir again.

APPLICATION

Apply by brush, roller or airless spray.

CLEANING OF EQUIPMENT

Clean all tools with Thinner C immediately after use. Hardened and/or cured material can only be removed mechanically.

IMPORTANT CONSIDERATIONS

- Do not apply Sikagard®-63 N on moist substrates: In

this case please use SikaGard EpoCem 720

- Sikagard®-63 N cannot be used to produce glass fibre reinforced linings. In this instance Sikafloor 160 Must be used to imbed the glass matt, Sikagard®-63 N can then be applied over the top of the glass reinforced Sikafloor 160 layer
- Freshly applied Sikagard®-63 N must be protected from rain, condensation and water for at least 24 hours.
- For exact colour matching ensure using material from the same control batch numbers.
- Sag resistance on vertical surface is < 250 µm.

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 declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

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.

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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Product Data Sheet

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