

Product Data Sheet
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Friazinc® R

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Epoxy based zinc rich primer for steel

Product Description Two component, low solvent, zinc rich epoxy resin based primer for steel.

Uses

- Used as protective coating or as primer
- Specially suitable for objects which are subjected to mechanical wear, e.g. weirs, interior of pressure pipe line, gates, steel liner of penstocks and tanks etc.

Characteristics / Advantages

- Easy to apply
- Fast application
- High mechanical properties
- Good adhesion to substrate
- Fast curing
- Resistance to weathering

Product Data

Form

Appearance / Colours Part A: grey liquid
Part B: light brown liquid

Packaging Part A: 1.88 kg x 2 containers
Part B: 0.12 kg x 2 containers
Part A+B: 2.00 kg x 2 ready to use units

Storage

Storage Conditions / Shelf-Life 12 months from date of production if stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5°C and +35°C. Protect from frost

Technical Data

Chemical Base Epoxy resin

Construction



Density	Part A: ~ 2.37kg/l Part B: ~ 0.96kg/l Mixed resin: ~ 2.28 kg/l All density values at +27°C
Solid Content	~76% (by weight)
Application Temperature	Min 8°C, Max 30°C

Mechanical / Physical Properties

Resistance

Thermal Resistance

Exposure*	Dry heat
Permanent	+ 50 °C

*No simultaneous chemical and mechanical exposure.

System Information

System Structure	With out Top coat: 2 x Friazinc® R Priming under Top coat: 1 x Friazinc® R
	* For the application onto gypsum plaster boards, please refer to 'Notes on Application / Limitations'.

Application Details

Consumption / Dosage

Coating System	Product	Consumption
Primer	Friazinc® R	~ 0.15 -0.25 kg/m ²

These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile ,variations in level and wastage etc.

Substrate Quality	The substrate must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings and surface treatments, etc. If in doubt apply a test area first.
Substrate Preparation	Steel must be Blast cleaned to Sa 21/2 according to EN ISO 12944, Part 4. Blast cleaning is the best. If cleaned by alternate means, substrate should be free from rust.

Application Conditions / Limitations

Substrate Temperature	+8°C min. / +35°C max.
Ambient Temperature	+8°C min. / +35°C max.
Substrate Moisture Content	≤ 4% moisture content. Test method: Sika® Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).
Relative Air Humidity	75% r.h. max.

Application Instructions

Mixing	Part A : Part B = 94 : 6 (by weight)
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Mixing Time	Friaizinc® R is supplied in two parts. Stir Part A well to remix any settled material. Add Part A to Part B in the ratio of 94 : 6. Then mix thoroughly for about 3 to 5 minutes until a smooth and even consistency is achieved.		
Mixing Tools	Friaizinc® R must be thoroughly mixed using a low speed electric stirrer (300 - 400 rpm) or other suitable equipment.		
Application Method / Tools	The surface to be coated should be prepared well before mixing of the two components of the Friaizinc® R. The mixed material should be applied by appropriate brush and should be consumed within two hours after mixing at 30°C.		
Cleaning of Tools	Wash all the tools with Sika® Colma Cleaner immediately after use. Hardened material can only be removed mechanically.		
Potlife	2 kg mass		
	Temperature	Time	
	30° C	~2 hours	
Waiting Time / Overcoating	Friaizinc® R on Friaizinc® R		
	Temperatures	Time	
	+10°C	~ 240 minutes	
	+20°C	~ 120 minutes	
	+30°C	~ 60 minutes	
	Top coat on Friaizinc® R		
	Temperatures	Time	
	+10°C	~ 480 minutes	
	+20°C	~ 240 minutes	
	+30°C	~ 120 minutes	
Curing Details			
Applied Product ready for use	Temperature	Tack free time	Full cure
	+10°C	~ 8 hours	~ 10 days
	+20°C	~4 hours	~ 7 days
	+30°C	~ 2 hours	~ 7 days
Value Base	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.		
Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users shall 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.		

