

## Icosit<sup>®</sup> 6630 high-solid

Versatile high-build coating directly on steel and galvanized steel, non-ferrous metals, plastic and timber.

---

### Product description

Icosit 6630 high-solid is a low-solvent, oxidative drying high-build coating based on a specially modified synthetic resin combination with active corrosion protection pigments.

Icosit 6630 high-solid and Icosit 6630 Primer are approved and controlled according to German standard "TL/TP-KOR-Stahlbauten", page 93.

---

### Fields of application:

For weather resistant, thick coating on steel and galvanized surfaces from rural to industrial and marine atmosphere: pipelines, bridges, metal facades, roofs, lattice masts, street lights, wall- and ceiling cladding, outside protection of silos.

For coatings on galvanized steel, test report is available upon request.

Particularly suited as maintenance coat on top of old coating systems.

Versatile applicable on stainless steel, copper, aluminium and hard PVC and timber. Not suitable for windows and doors.

---

### Properties:

- low solvent content, easy application and environmental friendly
- excellent corrosion protection even in chemically aggressive atmosphere
- excellent adhesion directly to steel, galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber
- good corrosion protection even on manually de-rusted surfaces
- excellent colour-shade retention and chalking resistance
- non-brittling due to a unique binder combination.

---

### Product data

---

#### Colour shades:

Group 1, 2, 3 & 4 colours and in-pail tinting for BS 4800/381C and RAL colours.

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.

Because of the raw materials used, slight batch to batch colour variations are unavoidable. In case of strong UV exposure brilliant colour shades tend to brighten up.

---

#### Packaging:

3 litre and 15 kg net.

---

#### Shelf life:

In originally sealed containers in a cool and dry environment: min. 2 years.

---

## Systems

### Coating systems:

#### Steel:

2-3 x Icosit 6630 high-solid/EG

#### In case of manual de-rusting:

1 x Icosit 6630 Primer or Icosit Aktivprimer

2 x Icosit 6630 high-solid/EG

#### Galvanized surfaces, stainless steel, copper, aluminium, hard PVC and timber:

2 x Icosit 6630 high-solid/EG

#### Maintenance coatings:

Patch-up with Icosit 6630 Primer or Icosit Aktivprimer.

1-2 x Icosit 6630 high-solid/EG.

### Surface Preparation:

#### Steel:

In case of aggressive industrial atmosphere or highly polluted surfaces

(e.g. by chlorides, sulphates, nitrates etc.):

blast cleaning to Sa 2½ according to EN 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 may be sufficient.

#### Galvanized surface, stainless steel, copper, aluminium, hard PVC:

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

#### Maintenance of old coating systems:

In case of well adhering old coating systems, careful cleaning (e.g. by high pressure water jetting) is sufficient. Loose particles must be removed, defective areas must be de-rusted to partially Psa 2½, Pma or PSt 2 and subsequently patch-primed with Icosit 6630 Primer.

## Technical data

### Material consumption:

	Specific gravity liquid approx. kg/L	Solids content approx. %		Theoretical thickness with 100 g/m <sup>2</sup> consumption		Material-consumption for medium dry film thickness of	
		by vol.	By weight	wet microns	dry microns	microns	approx. kg/m <sup>2</sup>
Icosit 6630 high-solid	1,4	62	77	71	44	80	0,180
Icosit 6630 Primer	1,5	62	79	67	41	80	0,195
Icosit 6630 high-solid EG (MIO)	1,5	61	77	67	41	80	0,195

### Resistance:

#### Chemical influences:

Excellent resistance to rural, urban, industrial and marine atmosphere and temporarily exposure to neutral salts.

Not resistant to continuous exposure of dilute 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).

Temperature: +80 °C

---

## Hints on application

---

**Preparation of material:** Icosit 6630 high-solid is supplied ready for use. Stir well prior to application.

---

**Application method:** 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 and by brush. 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:  
With a spray pressure in gun of min. 180 bar;  
nozzle size 0,38 – 0,53 mm (0,015 – 0,021 inch); spraying angle 40° - 80°;  
up to max. 3% Thinner B may be added

---

**Application temperature:** Min. +5° C  
(material and surface)

---

**Waiting time between coats:** Minimum 1 day

---

**Drying time:** Dust free after approx. 4-5 hours  
Touch dry after approx. 8-10 hours, but coating is still sensitive to pressure.

---

**Final drying time:** Depending on layer thickness, temperature and ventilation several days. Full mechanical and chemical resistance is only achieved after final drying.

---

**Cleaning of implements:** Thinner B

---

## Important notice

---

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

The maximum content of Icosit 6630 high-solid remains below 500 g/litre VOC".

---

**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.

---

**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.

---

**Health and Safety Information** For information and advice on the safe handling, storage and disposal of chemical products, users should 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.

---



Sika Limited  
Watchmead  
Welwyn Garden City  
Hertfordshire  
AL7 1BQ  
United Kingdom

Phone +44 1707 394444  
Telefax +44 1707 329129  
[www.sika.co.uk](http://www.sika.co.uk), email: [sales@uk.sika.com](mailto:sales@uk.sika.com)

