

PRODUCT DATA SHEET

Sikagard®-67

2-PART WATER BASED PROTECTIVE EPOXY COATING

DESCRIPTION

Sikagard®-67 is a water based, solvent free, odourless, epoxy resin protective coating.

USES

Sikagard®-67 may only be used by experienced professionals.

- Applied on concrete, rendering, stone, asbestos and cement.
- Protective coating against weathering and mild chemical attack in areas such as cantilevers, galleries, retaining walls, basements, workshops, reservoirs and balconies.

CHARACTERISTICS / ADVANTAGES

- Protect cementitious structures against weathering
- Resistant to oil and grease
- Weather-proof
- Mild dew-resistant
- Solvent free
- Suitable for portable water reservoirs
- Easy to apply
- Adheres to damp surfaces
- Odourless

APPROVALS / STANDARDS

- Food grade (USFDA 175.300 1st April 2017) from CFTRI, Mysore

PRODUCT INFORMATION

Packaging	Part A:	2 kg x 2 containers
	Part B:	2 kg x 2 containers
	Part A+B:	4 kg x 2 ready to use units

Appearance / Colour	Part A (Resin):	coloured, paste
	Part B (Hardener):	off white, liquid
	Available colour shades: RAL1002 (Sand yellow), 1013 (Oyster white), 1014 (Ivory), 2009 (Traffic orange), 6034 (Pastel turquoise), 7001 (Silver grey), 7034 (Yellow grey), 7035 (Light grey), 7038 (Agate grey), 8001 (Ochre brown), 9001 (Cream), 9003 (Signal white) Above colours are approximate Under direct sun light there may be some discolouration and colour variation, this has no influence on the function and performance of the coating.	
Shelf Life	12 months from date of production	
Storage Conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +10 °C and +30 °C	
Density	Part A:	~1.48 kg/l
	Part B:	~ 1.00kg/l
	Mixed resin:	~ 1.22kg/l
	All density values at +27°C	
Solid content by weight	~ 49%	
Chemical Resistance	Resistant to many chemicals. Please contact Sika® representative	

SYSTEM INFORMATION

Systems	Primer:	1 x Sikagard®-67 + 20 % water by weight
	Seal coat:	2 - 3 x Sikagard®-67 (roller application) or 1 - 2 x Sikagard®-67 (spray application)
	For the application onto gypsum plaster boards, please refer to 'Notes on Application / Limitations'.	

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 1 : 1 (by weight)		
Consumption	Coating System	Product	Consumption
	Primer	Sikagard®-67 + 20 % water by weight	~ 0.1 – 0.2 kg/m ²
	Seal coat	2 - 3 x Sikagard®-67 (roller application)	~ 0.15 - 0.25 kg/m ² per coat
	These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level and wastage etc.		
Ambient Air Temperature	+8°C min. / +35°C max.		
Relative Air Humidity	75% r.h. max.		
Dew Point	Beware of condensation! The substrate must be at least 3°C above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or "blushing" on the floor finish. Be aware that the substrate temperature may be lower than the ambient temperature		
Substrate Temperature	+8°C min. / +35°C max.		
Substrate Moisture Content	< 6% moisture content. Test method: Sika® Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).		

Pot Life	4 kg mass	
	Temperatures	Time
	+10°C	~ 120 minutes
	+20°C	~ 60 minutes
	+30°C	~ 40 minutes
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Curing Time	Full cure 7 days at 30°C	
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Waiting Time / Overcoating	Before applying Sikagard®-67 on Sikagard®-67 allow	
	Substrate temperature	Minimum Maximum
	+10°C	180 minutes 7 days
	+20°C	180 minutes 7 days
	+30°C	180 minutes 7 days
Times are approximate and will be affected by changing ambient conditions particularly temperature and relative humidity		
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Applied Product Ready for Use	Temperature	Tack free time Full cure
	+10°C	~ 20 hours ~ 10 days
	+20°C	~ 6 hours ~ 7 days
	+30°C	~ 3 hours ~ 7 days
Note: Times are approximate and will be affected by changing ambient conditions.		

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY / PRE-TREATMENT

The concrete substrate must be sound and of sufficient compressive strength (minimum 20 N/mm²) with a minimum pull off strength of 1.5 N/mm². 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. Concrete substrates must be prepared mechanically using grinding equipment, abrasive blast cleaning or scarifying equipment to remove cement laitance and achieve an open textured surface. Weak concrete must be removed and surface defects such as blowholes and voids must be fully exposed. Repairs to the substrate, filling of blowholes/voids and surface levelling must be carried out using appropriate products from the Sikafloor®, Sikadur® and Sikagard® range of materials. The concrete or screed substrate has to be primed or leveled in order to achieve an even surface. High spots must be removed by e.g. grinding. All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush and/or vacuum

MIXING

Prior to mixing, stir part A mechanically. When all of part B has been added to part A, mix continuously for 2 minutes until a uniform mix has been achieved. To ensure thorough mixing pour materials into another container and mix again to achieve a consistent mix. Over mixing must be avoided to minimize air entrainment.

APPLICATION

Prior to application, confirm substrate moisture content, relative humidity and dew point. If > 6% pbw moisture content, Sikagard®-720 Epo-Cem® may be applied as a T.M.B. (temporary moisture barrier) system. **Primer:** Make sure that a continuous, pore free coat covers the substrate. Apply the Sikafloor® primer by brush or roller. **Wall coating:** Apply Sikagard®-67 by roller.

CLEANING OF TOOLS

Clean all tools and application equipment with water immediately after use. Hardened and/or cured material can only be removed mechanically

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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