

# PRODUCT DATA SHEET

## Friazinc R

### EPOXY BASED ZINC RICH PROTECTIVE COATING AND PRIMER FOR STEEL

#### DESCRIPTION

Friazinc R is two component, low solvent, zinc rich epoxy resin based protective coating and anti-corrosive primer for steel.

#### USES

- Used as protective coating or as primer
- Specially suitable for steel 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

- Excellent corrosion protection
- Easy to apply
- Fast application
- High mechanical properties
- Good adhesion to substrate
- Fast drying and curing characteristics
- Resistance to weathering

#### PRODUCT INFORMATION

<b>Chemical Base</b>	Epoxy resin	
<b>Packaging</b>	Part A	1.88 kg
	Part B	0.12 kg
	Part A+B	2.00 kg x 2 sets
<b>Appearance / Colour</b>	Part A: grey liquid Part B: light brown liquid	
<b>Shelf Life</b>	12 months from date of production	
<b>Storage Conditions</b>	The product must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +35 °C. Protect from frost	
<b>Density</b>	Part A	~2.37 kg/litre
	Part B	~0.96 kg/litre
	Part A+B mixed	~2.20 kg/litre
All density values at +27 °C		
<b>Solid content by weight</b>	~76 %	

#### TECHNICAL INFORMATION

<b>Thermal Resistance</b>	Permanent exposure of dry heat upto +50 °C (No simultaneous chemical and mechanical exposure)
---------------------------	---

## SYSTEM INFORMATION

<b>Systems</b>	As a primer coat with additional top coat (exposed situation)	1 x Friazinc R
	As a primer + top coat of Friazinc R (covered situation)	2 x Friazinc R

## APPLICATION INFORMATION

<b>Mixing Ratio</b>	Part A : Part B = 94 : 6 (by weight)		
<b>Consumption</b>	~0.150–0.250 kg/m <sup>2</sup> These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level and wastage etc.		
<b>Ambient Air Temperature</b>	+8 °C min. / +35 °C max.		
<b>Relative Air Humidity</b>	75 % max.		
<b>Substrate Temperature</b>	+8 °C min. / +35 °C max.		
<b>Substrate Moisture Content</b>	< 4 % Test method: Sika® Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).		
<b>Pot Life</b>	~2 hours at +30 °C (test weight 2 kgs)		
<b>Curing Time</b>	<b>Temperature</b>	<b>Tack free time</b>	<b>Full cure</b>
	+10 °C	~8 hours	~10 days
	+20 °C	~4 hours	~7 days
	+30 °C	~2 hours	~7 days
<b>Waiting Time / Overcoating</b>	Before applying Friazinc R on Friazinc R		
	<b>Temperature</b>	<b>Overcoating time</b>	
	+10 °C	~4 hours	
	+20 °C	~2 hours	
	+30 °C	~1 hour	
	Before applying top coat on Friazinc R		
	<b>Temperature</b>	<b>Overcoating time</b>	
	+10 °C	~8 hours	
	+20 °C	~4 hours	
	+30 °C	~2 hours	
<b>Drying Time</b>	~20 minutes (tack free) at +30 °C		

## APPLICATION INSTRUCTIONS

### EQUIPMENT

Friazinc R must be thoroughly mixed using a low speed electric stirrer (300–400 rpm) or similar suitable equipment.

### SUBSTRATE PREPARATION

The substrate must be clean, dry and free of all contaminants such as rust, dirt, oil, grease, coatings and surface treatments, etc.

If in doubt apply on a test area first.

Steel must be Blast cleaned to Sa 2.5 according to EN ISO 12944, Part 4. Alternatively, use a rust remover such as Sika® Rustoff-100 and use waterjet to make

steel rust free.

### MIXING

Friazinc 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.

### APPLICATION

The surface to be coated should be prepared well before mixing of the two components of the Friazinc 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

Clean all the tools with Sika® Colma Cleaner immediately after use. Hardened 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.

### Sika India Pvt. Ltd.

620, Diamond Harbour Road  
Commercial Complex II  
Kolkata - 700 034  
Tel : +91 33 24472448  
Fax : +91 33 23978688  
Mail : info.india@in.sika.com



### Product Data Sheet

Friazinc R

May 2020, Version 01.01  
020602000020000015