BUILDING TRUST
CONSTRUIRE LA CONFIANCE

PRODUCT DATA SHEET

Sikagard® CorPro-470

HIGH PERFORMANCE, POLYAMIDE EPOXY PRIMER FOR METAL

PRODUCT DESCRIPTION

Sikagard® CorPro-470 is a high performance, two component, solvent based, polyamide epoxy primer designed to provide increased adhesion and corrosion resistance properties over properly prepared ferrous and galvanized metal substrates.

WHERE TO USE

Sikagard® CorPro-470 may only be used by experienced professionals.

- Provides additional protection for metal substrates subject to severe environments.
- Suitable for interior and exterior applications.
- High performance epoxy primer for metal substrates used in combination with compatible Sikafloor® and Sikagard® epoxy and polyurethane coatings.

CHARACTERISTICS / ADVANTAGES

- Excellent adhesion on prepared ferrous and galvanized metal substrates.
- Extended pot life allows application by brush, roller or spray.
- Easy to apply and repair if damaged.
- Supplied ready to use, no additional thinning is required for most applications.

PRODUCT INFORMATION

CSC MasterFormat®	**09 96 00 | HIGH-PERFORMANCE COATINGS**	
Packaging	3.78 L (1 US gal.)	
Appearance / Colour	Grey, low gloss	
Shelf Life	2 years in original unopened packaging.	
Storage Conditions	Store dry between 5 °C to 32 °C (41 °F to 89 °F) Precondition material for at least 24 hours between 18 °C to 30 °C (65 °F to 86 °F) before using.	
Solid content	**Volume**	~61 %
	Weight	~75 %
	VOC content	~337 g/L

APPLICATION INFORMATION

Mixing Ratio	A: B = 4:1 by volume
Consumption	~12 m²/L (~490 ft²/US gal.) per coat (3.3 mil w.f.t. / 2 mil d.f.t.) Typically one (1) coat is required, though on higher absorbency substrates a second coat may be required. Actual coverage rates and material consumption will depend upon porosity and profile of substrates. Test areas are recommended to establish correct coverage rates.
Ambient Air Temperature	Minimum 10 °C (50 °F) Maximum 30 °C (86 °F). Ambient Air Relative Humidity: Maximum 85 % (during application & cure). **NOTE:** Application attempted at low ambient air or substrate temperatures and/or under high humidity conditions, will result in a decrease in product workability and slower cure rates.
Dew Point	Beware of condensation! The substrate must be at least 3 °C (5 °F) above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or “blushing” on the finish. Be aware that the substrate temperature may be lower than the ambient air temperature.
Substrate Temperature	Minimum 10 °C (50 °F) Maximum 30 °C (86 °F).
Pot Life	23 °C (73 °F) ~8 hours 250 g (8.8 oz)
Curing Time	**Tack free** at 23 °C (73 °F) ~4 hours to ~5 hours **Overcoat time** at 23 °C (73 °F) ~8 hours to ~48 hours **Full cure** at 23 °C (73 °F) ~7 days Drying times will vary according to air and substrate temperature and relative humidity. Protect from dampness, condensation and water contact during the initial 24 hour cure period.

BASIS OF PRODUCT DATA

Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.
Properties tested at 23 °C (73 °F) and 50 % R.H. unless stated otherwise.

LIMITATIONS

- Prior to application, measure and confirm Substrate Moisture Content, Ambient Relative Humidity, Ambient and Surface Temperature and Dew Point. During installation, confirm and record above values at least once every three (3) hours, or more frequently whenever conditions change (e.g. Ambient Temperature rise / fall, Relative Humidity increase / decrease, etc.)
- Direct-fired gas or kerosene heaters produce byproducts that can have adverse effects on the curing primer. To avoid this occurrence, heaters must be exhausted to the exterior of the building to avoid defects such as amine blush, whitening, loss of adhesion or other surface deficiencies.
- Apply product to dry, clean, properly cured and prepared surfaces in areas where dust is no longer generated by construction activities, such that airborne particles will not reduce bond of coating or adhere to the surface, affecting the quality of subsequently applied finishes.
- When over-coating existing coatings, compatibility and adhesion testing is required and existing coating must be acknowledged as determining the adhesion and performance of all subsequently applied materials.
- This product is not designed nor intended for negative side waterproofing.
- Improper mixing procedure or incorrect mixing ratio may result in moisture sensitivity, whitening, slow cure, soft spots, and other defects.
- Not designed to function as an aesthetic treatment or final coating; must be overcoated with a finish.

ENVIRONMENT, HEALTH & SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Common Steel: All steel to be coated must be dry, clean and stable before applying the coating. Remove all existing treatments such as coatings, sealers, wax, and contaminants i.e. dirt, dust, grease, oils, and foreign matter, which will interfere with the adhesion of Sikagard® CorPro-470. Prepare steel substrates by appropriate mechanical means, such as abrasive blast-cleaning in order to achieve clean white metal profile equivalent to SSPC-SP10, Near White Metal, 2 to 4 mil anchor profile and apply primer immediately, before oxidation of the steel occurs.

Galvanized Metal: Is a difficult substrate to achieve satisfactory adhesion. The surface is very smooth with no anchor pattern making proper surface preparation very important to minimize adhesion problems. Passivation treatments must be removed. Prepare galvanized metal substrates to MPI standard 5.3 Galvanized Metal using either a brush off blast (SSPC-SP 7 brush off blast cleaning standard) or by cleaning and etching solution (MPI #25 Etching Cleaner) following the manufacturer's instruction to create a fine anchor pattern.

MIXING

Mixing Ratio A:B = 4:1 by volume
Do not hand mix Sikagard® CorPro-470 resin materials: mechanical mix only.
Pre-stir each component separately to ensure that all soft settling is dispersed, solids are evenly distributed throughout and components are consistent within themselves.
Empty component B in the correct mix ratio to component A. Mix the combined components for at least three (3) minutes, using a low-speed drill (300 - 450 rpm) to minimize entrapping air. Use an Exomixer® or Jiffy type mixing paddle (recommended model) suited to the volume of the mixing container. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once, to ensure complete mixing.
When completely mixed, allow a 20 minute to 30 minute induction time and then remix before application. Failure to do so will result in unsatisfactory performance.
Sikagard® CorPro-470 should be uniform in colour and consistency before application.
Do not obtain more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

APPLICATION

Sikagard® CorPro-470 can be applied by brush, roller or spray equipment, whichever is the most suitable to the surfaces to be coated or site conditions and limitations. For spray applications, contact spray equipment specialists to determine suitable equipment and for application advice (thinning maybe required) contact Sika Canada. If thinning is necessary, proceed only after recommended induction time has passed.
Sikagard® CorPro-470 must be applied in a workman-like manner using skilled and trade qualified applicators. The film thicknesses stated must be produced and complete coverage achieved.
If time between coats (primer to primer or primer to finish coats) exceeds 48 hours at 23 °C (73 °F), abrade surface to create a fine anchor pattern, then wipe clean with a solvent-dampened cloth to remove all traces of loose materials and dust.

CLEAN UP

Clean tools and brushes with Sika® Epoxy Cleaner. Once hardened, product can only be removed mechanically.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

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