

10,250 hrs

No cracking or delamination of film
No more than 3% rusting on plane

(ASTM B 117)

APPLICATION INFORMATION

Coverage 70 - 100 ft² (6.5 - 9.3 m²) per unit; approximately 3 mils dry film thickness (DFT) per coat
(Coverage rates do not include allowance for surface profile or material waste.)

Layer Thickness	1 coat application	Minimum	Maximum
	Wet film	3.5 mils (90 µm)	5.5 mils (140 µm)
Dry film	2.5 mils (65 µm)	4.0 mils (100 µm)	

Ambient Air Temperature 45° - 120 °F (7° - 49° C)

Relative Air Humidity Minimum 20% / Maximum 90%

Substrate Temperature 45° - 120 °F (7° - 49° C)
Steel temperature should be at least 5° F (3° C) above the measured dew point temperature.

Pot Life

- 24 hours at 77° F (25° C) and 50% R.H.

This is a moisture cure product. Presence of moisture after opening and during use will shorten application time. When feasible, keep containers of material covered during use.

Waiting / Recoat Times	50% Relative Humidity	Overcoating
	75° F (24° C)	1.5 hrs
70° F (21° C)	2 hrs	
65° F (18° C)	3hrs	
60° F (15° C)	4 hrs	
55° F (13° C)	5 hrs	

- When recoating Sika® Armatec®-10 ZR with itself, the minimum recoat time is 2 hours at 70°F (21°C).
- Do not leave the primed surfaces uncovered for longer than 3 days before applying cementitious repair materials or concrete.
- Sika® Armatec®-10 ZR can stay exposed for a year. It must be scarified or recoat before applying cementitious repair materials or concrete.

* Tack Free times will vary with surface temperature, humidity and film thickness. Allow Sika® Armatec®-10 ZR to dry for a minimum of 1.5 hours (or Tack Free to the touch) before the repair mortar or concrete is applied.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

- Rust, scale, mortar, concrete, dust and other loose and deleterious material which reduces bond or contributes to corrosion shall be removed by blast cleaning or other means of mechanical abrasion and reinforcement.
- Steel surfaces should be fully exposed with all corrosion mechanically removed.
- Mask off and protect surrounding concrete surfaces. Apply Sika® Armatec®-10 ZR only to mechanically prepared rebar.
- Refer to International Concrete Repair Institute (ICRI) Technical Guideline #310.1R, the "Guideline for Surface Preparation for the Repair of Deteriorated Concrete

Resulting from Reinforcing Steel Corrosion" for further information.

MIXING

- Sika® Armatec®-10 ZR must be stirred or shaken thoroughly before application.



APPLICATION

- Use a 3/8" (10 mm) nap roller or a round brush.
- Apply one coat (5 mils wet film thickness) onto a dry, rust-free surface.
- Take special care to properly coat the underside of the totally exposed, mechanically prepared steel.
- Allow Sika® Armatec®-10 ZR to dry for a minimum of 1.5 hours (or Tack Free to the touch) before the repair mortar or concrete is applied.
- Pour or place cementitious repair mortar or concrete within 7 days maximum.
- Sika® Armatec®-10 ZR can also be spray applied with either air spray or airless spray equipment, Contact Technical Services for additional information.

CURING TREATMENT

- Sika® Armatec®-10 ZR must be protected against contamination until installation of the cementitious repair mortar or concrete.

CLEANING OF TOOLS

- Clean all tools and application equipment with approved solvent (e.g. Acetone, MEK or Xylene) immediately after use, before Sika® Armatec®-10 ZR dries.

LIMITATIONS

- Avoid application when strong winds prevail, and/or while raining or snowing.
- Do not add water.
- Apply only to dry, mechanically prepared, rust-free steel reinforcement substrates.
- Mask off and protect surrounding concrete surfaces.

BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

OTHER RESTRICTIONS

See Legal Disclaimer.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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Product Data Sheet

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