

Material preparation

The material is delivered in casks. Add the hardener constituent to the base constituent and stir in carefully, preferably with a mechanical agitator, not forgetting cask base and sides. Only add as much material as can be processed within the potlife.

Instructions for use

Base surface and air temperature at least +10°C. Relative humidity max. 80%: The temperature of the surface to be coated must be 3°C above its dew point. Low temperatures delay hardening and impair processability. The base surface temperature must be above the minimum hardening temperature for complete hardening. High humidity and falling below the dew point can lead to condensation forming on the base surface or coating surface. This can cause problematic adhesion and intermediate adhesion flaws. The object conditions must be met during the processing and hardening time. We recommend the use of heating or drying units when changing these thresholds.

Do not apply thicker layers, or carry out any overhead work, until about 15-20 minutes after mixing. Apply the compound only when it no longer runs or drips off the spatula.

Mixing

A (compound) : B (hardener) **1000 : 28**
(1000 g **SIConit** : 28 ml hardener)

Mixture ratio weight / capacity

The mixture ratios specified should be observed as closely as possible. Increasing or decreasing the hardener amount does not bring about quicker or slower reaction times – but rather an incomplete hardening of the moulding material.

**approx. 210 ml in measuring cup =
approx. 500 g**

**= 500g SIConit + 14 ml hardener
= 250g SIConit + 7 ml hardener
etc.**

Important !

Measure the hardener to the precise quantity with the dispenser supplied and always use a clean vessel for mixing otherwise quality discrepancies may result.

The following formula should be used to calculate the amount required to cover a specified surface

$$2.4 \times \text{surface area (m}^2\text{)} \times \text{average thickness (mm)} \\ = \text{amount (kg)}$$

Packaging

The material is delivered in two packaging in 1.0 kg, 4.0 kg, and 25 kg. Delivered black-grey in colour and hardener constituent yellowish.

Layer build-up and material requirement

SIConit may be applied with a minimum layer thickness of 1.5mm. The minimum temperature when applying is 10 °C. Work the compound firmly into the surface with a plastic, metal or wooden tool, wetting the whole surface area. After application of the compound, it may be smoothed in several ways. If necessary, **SIConit** may be finished with a fast-wearing grinding disc after hardening. Other machine finishing is only possible with diamond or Carborundum tools.

Potlife in minutes

	16°C	25 °C	32 °C	43 °C
1.0 kg	75	50	35	25
5.0 kg	67	38	25	17

This table defines the practical hardening times starting from the beginning of mixing.

Hardening time

	15 °C	25° C	30° C
Non-adhesive:	8 hrs.	5 hrs.	3 hrs.
Full load, chemically resistant	36 hrs.	24 hrs.	20 hrs.

Workover intervals / further layering

SIConit may be overlaid with the same compound or other compound systems after hardening and at a temperature of between +10 and +30°C. Provided that the surfaces are clean, dry and free of oil and fat. It is imperative to abrade the coating. The surface resin layer must be removed.

Cleaning

Use commercial cleaning agents (acetone, xylene, alcohol, methylethylketon) to clean tools immediately after use. After the compound has hardened it can only be removed by grinding.

Store at a temperature of between 10 and 32°C, variations during transportation are acceptable. Some mixing of resin and filler may result during storage. Stir well before application. Storage life for unopened containers is two years.

Safety precautions

Prior to using any product, read the relevant material safety data sheet or the safety regulations pertaining to your area. Comply with all relevant safety regulations when using in enclosed areas.

Technical information was collated through laboratory trials and provides general guidelines only. SICcast GmbH & Co. KG gives no direct or indirect guarantees at all, including the saleability and suitability for particular applications and use. Any guarantees are limited to the replacing of the product. Preliminary testing is recommended.

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