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Spray Application Guidelines for Sikalastic-500 - Silicone Coating

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TO WHOM IT MAY CONCERN,

This guide provides application tips for spraying Sikalastic-500, a single component, moisture-cured silicone elastomeric coating. Airless spray equipment is an effective method of application especially on large areas and irregular or vertical surfaces. Gas powered spray equipment can also be used (consult with equipment manufacturer for recommendations). Air-atomized application is not recommended.

This guide is in addition to the instructions and limitations outlined in the Sikalastic-500 Product Data Sheet (PDS) and all Sikalastic-500 level primers' PDSs available at usa.sika.com/en/construction/liquid-applied-roofing.html. Always consult the most current version of the PDS before starting work. Beyond this guide and PDSs, it is strongly encouraged to keep up-to-date with NRCA and Roofing Industry standard practices.

TEMPERATURE CONDITIONS

Store product according to the PDS. At temperatures above 80°F (27°C), reduce the application rate on vertical or irregular surfaces to prevent sags or runs. Do not apply at temperatures above 100°F (38°C).

SPRAY EQUIPMENT RECOMMENDATIONS:

Read and follow the equipment manufacturer's instructions and recommendations on safety, application and maintenance. Based on tip size, raise pressure to remove fingers in spray pattern. Tip and pump sizes will change depending on temperature and pattern concerns.

A high-pressure airless paint pump capable of producing a minimum of 4500 psi at the spray gun should be used. The pump should have a minimum of 3 gallons per minute output and be fed by a 5:1 transfer pump. Always use components rated for pump pressure. Hoses should have a maximum length of 200 feet, a minimum inside diameter of 1/2", a 3/8" whip may be used at the spray gun. The spray gun should be high pressure (5000 psi) with reverse-a-clean spray tip, having a minimum orifice of .029 in.

For application above 75 °F use:

1. **16U280 – GH 5040 ES System.** Includes: GH 5040ES with Bare Electric Start, 250 ft of 1/2 in Hose, 10 ft x 3/8 in Whip Hose, Gun Swivel, Heavy-Duty Gun, 30 in Tip Extension, 180° Tip Swivel, RAC X 519, 531 Tips and all fittings.

For application below 75 F, especially approaching 50 F, a larger hose of at least 3/4 in feed line to main pump, the Graco XTR-7 Sprayguns and pressurized lines capable of 7250 psi and using a higher CFM of air to run the main pump and feed drum pump is recommended. In this scenario, use:

1. **16U783 – GH 933 Big 250 System.** Includes: GH 933, 200 ft of 3/4 in Hose, 50 ft of 1/2 in Hose, 10 ft x 3/8 in Whip Hose, XTR™-7 Gun, 18 in Tip Extension, 180° Tip Swivel, XHD™ 519, 531 Tips and all fittings

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2. **16U784 – GH 933ES Big 250 System.** Includes: GH 933ES with Electric Start, 200 ft of 3/4 in Hose, 50 ft of 1/2 in Hose, 10 ft x 3/8 in Whip Hose, XTR-7 Gun, 18 in Tip Extension, 180° Tip Swivel, XHD 519, 531 Tips and all fittings

SUGGESTED SPRAYING TECHNIQUE

- Hold the spray gun perpendicular to the surface at a distance of 18" to 24" (46 cm to 62 cm) from the roof. While triggering the spray gun, move it at a rate to produce the desired coating wet mil thickness without thin spots or "holidays".
- Spray technique should include a "half lap" technique where each spray pass is overlapped 50% for uniform coverage. Check applied film thickness using a wet mil gauge.
- Using the 2,700-3,000 psi fluid pressure will provide a uniform spray pattern without fingering.
- Allow a minimum of 24 hours cure time between coats for cure and solvent evaporation.
- Spray across roof, back-roll as needed to ensure uniform coverage, then back-spray across the same area to complete application.

SPRAYING PRECAUTIONS

- Rope off the area within 150' (46 m) of spray area.
- Seal off ventilation intakes within the affected area.
- Use windbreaks, where necessary, to confine spray mist and avoid damage to nearby surfaces due to overspray or drift.
- Keep spectators and personnel away from spray area.
- Spray pressure may need to be increased with a decrease in temperature or increase in building height.

CLEAN UP

- Clean airless spray equipment based on Pump Manufacturers' recommended solvent/cleaning solution(s) and procedures. Some pumps may have gaskets that are not solvent resistant.
- Do not leave product in airless spray system for more than one (1) hour. Under certain conditions, it is possible Sikalastic-500 will gel or harden inside the equipment.
- Follow Pump Manufacturers' recommendations for long-term storage.

PERSONAL PROTECTION EQUIPMENT (PPE)

Always consult product Safety Data Sheets (SDSs) before beginning work. Follow industry and OSHA recommendations for PPE when using Sikalastic-500 in conjunction with an airless sprayer.

Sincerely,



Daniel Munt