

PRODUCT DATA SHEET

Sika® Permacor®-2330

2-PACK AY-PUR TOP COAT

PRODUCT DESCRIPTION

Sika® Permacor®-2330 is a 2-pack acrylic polyurethane top coat.

USES

Sika® Permacor®-2330 may only be used by experienced professionals.

Sika® Permacor®-2330 is used as mechanical resistant topcoat for atmospherically exposed steel surfaces - also for condensation - particularly for machinery, paper mills, engines, rollercoasters and commercial vehicles.

In combination with 2-pack primers and intermediate coats of the SikaCor® and Sika® Permacor® range Sika® Permacor®-2330 offers a mechanical resistant coating system for long-life corrosion protection with high weather resistance up to corrosivity category C5-I resp. C5-M, 'high', acc. ISO 12944-5.

CHARACTERISTICS / ADVANTAGES

- Very high weather resistance and gloss- and colour retention
- Applicable also at low temperatures down to 0°C

APPROVALS / STANDARDS

- Approved according to German standard 'TL/TP-KOR-Stahlbauten', page 87 and page 97.
- Tested according to NORSOK Standard M-501, rev. 6, system no. 1.

PRODUCT INFORMATION

Packaging	Sika® Permacor®-2330	28.75 kg and 11.5 kg net.
	Sika® Thinner P	25 l and 5 l
Appearance / Colour	RAL- and NCS-colour shades, glossy Others upon request.	
Shelf Life	2 years	
Storage Conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.3 kg/l	
Solid Content	~56 % by volume	
	~69 % by weight	

TECHNICAL INFORMATION

Chemical Resistance	Weathering, water, sewage, seawater, smoke, de-icing salts, acid and lye vapours, oils, grease and short term exposure to fuels and solvents.
Thermal Resistance	Dry heat up to approx. + 120°C, short term up to + 150°C Damp heat up to approx. + 50°C

SYSTEM INFORMATION

Systems	Suitable as topcoat on primers and intermediate coats of Sika® Permacor® Systems 2000, 2200 and 2300. <u>Steel:</u> 1 x Sika® Permacor®-2204 VHS 1 x Sika® Permacor®-2330 or 1 x Sika® Permacor®-2311 Rapid 1 x Sika® Permacor®-2215 VHS 1 x Sika® Permacor®-2330 Also possible as alternative top coat in SikaCor® EG-System and SikaCor® EG-System Rapid. <u>Galvanized surfaces, stainless steel and aluminium:</u> 1x SikaCor® EG-1 1x Sika® Permacor®-2330
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APPLICATION INFORMATION

Mixing Ratio	Components A : B		
	By weight	100 : 15	
	By volume	5.1 : 1	
Thinner	Sika® Thinner P If necessary max. 5 % Sika® Thinner P may be added to adapt the viscosity.		
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:		
	Dry film thickness	50 µm	80 µm
	Wet film thickness	90 µm	145 µm
	Consumption	~0,115 kg/m ²	~0,185 kg/m ²
	VOC	~36,0 g/m ²	~57.6 g/m ²
Product Temperature	Min. + 5°C		
Relative Air Humidity	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point. The surface must be dry and free from ice.		
Surface Temperature	Min. 0°C		
Pot Life	At + 10°C	~8 h	
	At + 20°C	~6 h	
	At + 30°C	~3 h	
Drying Stage 6	Drying stage 6 and waiting time between coats:		
		Dry film thickness 80 µm	(ISO 9117-5)
	0°C after	48 h	
	+ 5°C after	24 h	
	+ 10°C after	18 h	
	+ 15°C after	10 h	
	+ 20°C after	8 h	
	+ 25°C after	6 h	
	+ 30°C after	4 h	

Drying time

Final drying time

The full hardness is achieved within approx. 7 days at + 20°C. Tests of the completed coating system should only be carried out after final curing.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Steel:

Blast cleaning to Sa 2 ½ according to ISO 12944, part 4. Free from dirt, oil and grease.

Galvanized steel, stainless steel and aluminium:

Free from dirt, oil, grease and corrosion products. In case of exposure to permanent condensation the surfaces must be slightly sweep blasted with a ferrite-free blasting abrasive.

For contaminated surfaces e.g. galvanized or primed areas we recommend to clean with SikaCor® Wash.

MIXING

Stir component A very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush or roller

Airless-Spraying:

- Pressure min. 150 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

CLEANING OF TOOLS

Sika® Thinner P

VALUE BASE

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 performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

ECOLOGY, HEALTH AND SAFETY

GISCODE: PU 50

This coding enables additional information and help with the creation of operating instructions (WINGIS online) to be obtained on the BG Bau service pages (www.gisbau.de).

Information on the safe handling of chemical products, as well as the essential physical, safety-related, toxicological and ecological data can be found in the current safety data sheets. Observe all relevant regulations, e.g. the hazardous substances act. Further notes and information data sheets on product safety and disposal can be found on the Internet at www.sika.de.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

For the product category IIA / j, Type Sb, the maximum permissible content of VOC according to the EU-Directive 2004/42/CE is 500 g/l (limit 2010).

The maximum content of Sika® Permacor®-2330 remains below 500 g/l VOC.

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.

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