BUILDING TRUST

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 very high, acc. ISO 12944-2.

CHARACTERISTICS / ADVANTAGES

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

APPROVALS / STANDARDS

- Approved according to German standard 'TL/TP-KOR-Stahlbauten, Blatt 87 and Blatt 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 An exposure to high temperatures can lead to color changes.

SYSTEM INFORMATION

Systems

Suitable as topcoat on primers and intermediate coats of Sika® Permacor® Systems 2000, 2200 and 2300.

Steel

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.

Hot dip galvanized steel, stainless steel and aluminium

1x SikaCor® EG-1
1x Sika® Permacor®-2330

APPLICATION INFORMATION

Mixing Ratio

	Components A : B
By weight	100 : 15
By volume	5.1 : 1*

* The volumetric mixing ratio may vary depending on the colour shade. Please refer to Sika if needed.

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/m²	~0.185 kg/m²
VOC	~36 g/m²	~58 g/m²

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
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

(ISO 9117-5)

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 12944-4.
Free from dirt, oil and grease.

Hot dip 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

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

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

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / j type Sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sika® Permacor®-2330 is < 500 g/l VOC for the ready to use product.

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 recommenda-

tions. 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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