BUILDING TRUST

PRODUCT DATA SHEET

# SikaCor®-2460 VHS

VERY HIGH SOLIDS 2-PACK EPOXY PRIMER

Made in Germany

## DESCRIPTION

SikaCor®-2460 VHS is a very high solids, fast curing, 2-pack primer, based on a modern epoxy formulation. Low solvent content acc. to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

## USES

SikaCor®-2460 VHS may only be used by experienced professionals.

Used as primer for steel surfaces, e. g. steel towers (exterior and interior) and construction, particularly suitable for exposure to condensation.
In combination with 2-pack top coats SikaCor®-2460 VHS offers a mechanically resistant coating system for long-term corrosion protection in rural, urban, industrial and maritime climates.

## CHARACTERISTICS / ADVANTAGES

- Very high solids
- Fast curing, short overcoating time
- Excellent corrosion protection
- Especially for workshop application

## APPROVALS / CERTIFICATES

- Tested and approved according to ENERCON specification for coatings of steel towers.
- Tested according to ISO 12944-6, corrosivity categories C3 high, C4 high and C5 high in combination with top coats.

## PRODUCT INFORMATION

| | | |
|---|---|---|
| **Packaging** | SikaCor®-2460 VHS Comp. A | 250 kg and 25 kg net. |
| | SikaCor®-2460 VHS Comp. B | 160 kg and 4 kg net. |
| | SikaCor® ECO Cleaner | 190 l and 25 l |
| | Sika® Thinner E+B | 190 l, 25 l and 5 l |
| **Appearance and colour** | Redbrown, other colours upon request. | |
| **Shelf life** | 1 year | |
| **Storage conditions** | In originally sealed containers in a cool and dry environment. | |
| **Density** | ~1.5 kg/l | |
| **Solid content** | ~94 % by volume<br>~97 % by weight | |

## TECHNICAL INFORMATION

| | |
|---|---|
| **Chemical resistance** | Resistant against weathering, oils, grease and short term exposure to fuels and solvents. |
| **Temperature resistance** | Dry heat up to approx. + 100°C, short term up to approx. + 120°C. |

## SYSTEM INFORMATION

**System**

Steel:
1 x SikaCor®-2460 VHS
1 x top coat

Suitable top coats:
SikaCor®-2270 VHS, Sika® Permacor®-2230 VHS, Sika® Permacor®-2330, Sika® Permacor®-2230 VHS Rapid and SikaCor® EG-5

**Mixing ratio**

| | Components A : B |
|---|---|
| By weight | 100 : 16.1 |
| By volume | 3.7 : 1 |

**Thinner**

Sika® Thinner E+B
If necessary max. 2 % Sika® Thinner E+B may be added to adapt the viscosity.

**Consumption**

Theoretical material-consumption/VOC without loss for medium dry film thickness:

| Dry film thickness | 100 µm | 160 µm | 220 µm |
|---|---|---|---|
| Wet film thickness | 106 µm | 170 µm | 234 µm |
| Consumption | ~0.160 kg/m² | ~0.255 kg/m² | ~0.351 kg/m² |
| VOC | ~4.8 g/m² | ~7.7 g/m² | ~10.5 g/m² |

VOC-content ~45 g/l (ISO 11890-1)

**Material temperature**

Min. + 20°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.

**Surface temperature**

Min. + 10°C

**Pot Life**

| | |
|---|---|
| At + 20°C | ~60 min |
| At + 30°C | ~20 min |

**Drying stage 6**

| | Dry film thickness 200 µm |
|---|---|
| At + 20°C | 4 h |
| At + 30°C | 3 h |

(ISO9117-5)

Higher film thicknesses will result in longer drying times.

**Waiting time to overcoating**

**Min.:** Until drying stage 6 is achieved.
**Max.:** indoors 3 months / outdoors 4 weeks
In case of longer waiting times thoroughly grinding or sweep-blasting is necessary.
Before overcoating ensure that the primed surface is dry and free from oil, grease and dirt.
Temporary storage and the transport of coated parts shall be carried out using appropriate methods. Securing belts or chains shall not be in direct contact with the coated surface and suitable secondary packing shall be employed. Do not use shrink-wrap or any other type of packaging like plastic film.

| | |
|---|---|
| **Drying time** | **Final drying time**<br>At + 20°C and good ventilation the final hardness is achieved within 5 - 7 days. |

## BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION

Steel:
Blast-cleaning to Sa 2 ½ according to ISO 12944-4 (ISO 8501-1). Free from dirt, oil and grease.
Surface profile „medium (G)" according to ISO 8503-2, roughness Rz ≥ 50 µm.

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

### MIXING

2-component spraying equipment:
Stir component A very thoroughly using a mechanical mixer (start slowly, then increase up to approx. 300 rpm) and fill the material into the tanks of the plural component spraying equipment or put the suction hoses into the material container. During application stir component A mechanically at intervals. If using plural feeded airless equipment (automatic dosage) a dosage control shall be installed to monitor correct mixing ratio. 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 will be achieved by airless spray application. Adding solvents reduces the sag resistance and the dry film thickness. 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:
- Only suitable for small areas

Airless-Spraying:
- High performance plural feeded spray equipment
- Pressure min. 200 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°
- Due to the short pot life we recommend to use plural component spray equipment
- Information about suitable equipment upon request

### CLEANING OF EQUIPMENT

SikaCor® ECO Cleaner or Sika® Thinner E+B

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

## 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.

**Sika Deutschland GmbH**
Industrial Coatings
Rieter Tal
D-71665 Vaihingen / Enz
Phone: +49 (0)7042 109-0
industrial-coatings@de.sika.com
www.sika.de