

PRODUCT DATA SHEET

SikaCor®-2440 MFN

Epoxy primer and intermediate coat

DESCRIPTION

SikaCor®-2440 MFN is a high solid 2-pack primer and intermediate coat based on epoxy resin.
Low solvent content acc. to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

SikaCor®-2440 MFN may only be used by experienced professionals.

Mechanically resistant and fast curing primer and intermediate coat for atmospheric exposed steel surfaces, e.g. steel towers, machine parts and constructions for wind turbines.

In combination with 2-pack primers and topcoats SikaCor®-2440 MFN offers a mechanical resistant coating system for long life corrosion protection with high weather resistance for rural, urban, industry and maritime climates.

PRODUCT INFORMATION

Packaging	SikaCor®-2440 MFN Comp. A	280 kg and 30 kg net.
	SikaCor®-2440 MFN Comp. B	170 kg and 2.5 kg net.
	Sika® Thinner E+B	190 l, 25 l and 5 l
Appearance and colour	Approx. RAL 9001 Other colours upon request.	
Shelf life	1 year	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.55 kg/l	(ISO 2811-1)
Solid content	~75 % by volume ~86 % by weight	(ISO 3233-3)

CHARACTERISTICS / ADVANTAGES

- Outstanding corrosion protection
- Dry film thickness up to 200 µm per layer
- Very fast curing, short overcoating time
- Especially suitable for work-shop application

APPROVALS / CERTIFICATES

- Test reports according to ISO 12944-6, corrosivity categories C3 high and C4 high are available.

TECHNICAL INFORMATION

Chemical resistance	Weathering, oils, grease and short term exposure to fuels and solvents.
Temperature resistance	Dry heat up to approx. + 120°C Short term up to + 150°C

SYSTEM INFORMATION

System	Steel: 1 x SikaCor®-2440 MFN 1 x SikaCor® EG-5 Suitable top coats: Sika® Permacor®-2230 VHS, Sika® Permacor®-2330, SikaCor® EG-5
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APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	100 : 8.33
	By volume	6.8 : 1
Thinner	Sika® Thinner E+B If necessary max. 3 % 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	80 µm 160 µm
	Wet film thickness	107 µm 213 µm
	Consumption	~0.165 kg/m ² ~0.331 kg/m ²
	VOC	~23.1 g/m ² ~46.3 g/m ²
Material 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.	
Surface temperature	Min. + 5°C	
Pot Life	At + 20°C	~1 h
Drying stage 6	Dry film thickness 160 µm (ISO 9117-5)	
	+ 10°C after	10 h
	+ 20°C after	4.5 h
	+ 30°C after	3 h
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. 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 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 2½ 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 and weathered surfaces e. g. primed areas we recommend to clean with SikaCor® Wash.

MIXING

Stir component A very thoroughly using a mechanical 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 that the selected application method will provide the requested results.

CLEANING OF EQUIPMENT

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.

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