

PRODUCT DATA SHEET

Sika® Permacor®-2315 EG Rapid

2-pack EP-MIO intermediate coat

Made in Germany

DESCRIPTION

Sika® Permacor®-2315 EG Rapid is a 2-pack coating based on epoxy resin.
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

USES

Sika® Permacor®-2315 EG Rapid may only be used by experienced professionals.

Mechanically resistant intermediate coat for atmospherically exposed steel, galvanized steel, sprayed zinc, stainless steel and aluminium surfaces.
In combination with 2-pack primers and topcoats Sika® Permacor®-2315 EG Rapid offers a mechanically resistant coating system for long-life corrosion protection.

CHARACTERISTICS / ADVANTAGES

- Dry film thickness up to 150 µm per layer
- Applicable directly on galvanized steel, thermal sprayed zinc, stainless steel and aluminium
- Applicable at low temperatures down to - 10°C
- Very fast overcoatable
- Corrosion protection up to corrosivity category C5 high

PRODUCT INFORMATION

Packaging	Sika® Permacor®-2315 EG Rapid	24 kg net.
	Sika® Thinner E+B	25 l and 5 l
Appearance and colour	Approx. RAL 7032, mat and approx. DB 702 In case of higher requirements for colour, top coats with Sika® Permacor®-2230 VHS or Sika® Permacor®-2330 are recommended.	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.6 kg/l	
Solid content	~55 % by volume	
	~76 % by weight	

TECHNICAL INFORMATION

Chemical resistance	The coating system is resistant to weathering.
Temperature resistance	Dry heat up to approx. + 120°C, short term up to + 150°C

SYSTEM INFORMATION

System	<p><u>Steel:</u> As intermediate coat suitable on the following primers: Sika® Permacor®-2204 VHS, Sika® Permacor®-2311 Rapid, Sika® Permacor®-2305 Rapid</p> <p>Suitable top coats e.g.: Sika® Permacor®-2230 VHS, Sika® Permacor®-2330</p> <p><u>Hot dip galvanized steel, stainless steel and aluminium:</u> 1 x Sika® Permacor®-2315 EG Rapid 1 x top coat (see above)</p>
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APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	100 : 20
Thinner	Sika® Thinner E+B If necessary max. 5 % 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	80 µm 150 µm
	Wet film thickness	150 µm 275 µm
	Consumption	~0.235 kg/m ² ~0.435 kg/m ²
	VOC	~55.9 g/m ² ~104.7 g/m ²
Material temperature	Min. + 10°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. - 10°C	
Pot Life	At + 10°C	~5 h
	At + 20°C	~3 h
	At + 30°C	~1 h
Drying stage 6	Dry film thickness 150 µm	(ISO 9117-5)
	+ 5°C after	22 h
	+ 10°C after	10 h
	+ 20°C after	5 h
Waiting time to overcoating	Min.:	
	+ 0°C after	40 h
	+ 5°C after	20 h
	+ 10°C after	10 h
	+ 15°C after	7 h
	+ 20°C after	4 h
	+ 25°C after	3 h
	+ 30°C after	2 h

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. Free from dirt, oil and grease, primed (see "System", page 2).

Hot dip galvanized steel, stainless steel, 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 and weathered 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.

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January 2022, Version 04.02
020602000210000004

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:

- To achieve the dry film thickness an additional application may be necessary

Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

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.