

PRODUCT DATA SHEET

Sika® Permacor®-337 VHS

EP Very High Solid Flow Coat

Made in Germany

DESCRIPTION

Sika® Permacor®-337 VHS is a very high solid 2-pack coating based on epoxy resin.

USES

Sika® Permacor®-337 VHS may only be used by experienced professionals.

Sika® Permacor®-337 VHS is used as an internal lining for gas pipelines for conveyance of non-corrosive gas.

CHARACTERISTICS / ADVANTAGES

- Provides a very smooth and mechanically robust coating to improve gas flow rates
- Provides excellent corrosion protection during transportation and intermediate storage of the single pipes
- Easy application by airless-spray pipe lining equipment
- Designed especially for the use at coating sites which needs to comply with special VOC-limitations or national solvent reduction regulations
- VOC-content: approx. 190 g/l

APPROVALS / CERTIFICATES

- Approved and certified according to the standards API RP 5L2, ISO 15741 and EN 10301.

PRODUCT INFORMATION

Packaging	Component A:
	Sika® Permacor®-337 VHS redbrown 250 kg net.
	Component B:
	Sika® Permacor®-337 VHS 200 kg net.
	Other units on request.
Appearance and colour	Red Brown Finish: Gloss (approx. 80 units / 60°-angle acc. ISO 2813)
Shelf life	12 months (expiry date: see labelling)
Storage conditions	In originally sealed containers in a dry, frost-free, cool environment (max. + 30°C, short term + 40°C).
Density	~1.45 kg/l
Solid content	~78 % by volume ~87 % by weight

TECHNICAL INFORMATION

Temperature resistance Dry heat up to approx. + 120°C, short term up to approx. + 250°C

SYSTEM INFORMATION

System Steel:
1 x Sika® Permacor®-337 VHS

APPLICATION INFORMATION

Mixing ratio		Components A : B
	By weight	100 : 14 (tolerance: 100 : 13.5 - 14.5)
	By volume	100 : 21 (tolerance: 100 : 20 - 22)

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

Dry film thickness	60 µm
Wet film thickness	80 µm
Consumption	~0.112 kg/m ²
Coverage	~8.95 m ² /kg

Technically possible dry film thickness (DFT): 60 µm - 150 µm.

Material temperature Approx. + 40°C

Relative air humidity Max. 80 % (surface temperature ≥ 3K above the dew point).

Surface temperature Min. + 10°C (preferably: + 20°C to + 35°C)

Pot Life	At + 20°C	~90 min
	At + 40°C	~15 min

Pot life may vary depending on conditions of application.

Drying time		Dry to touch	(ASTM D 1640)	
	At + 20°C	~7 h		
	At + 40°C	~1.5 h		
	At + 60°C	~0.5 h		
			Dry to handle	(ASTM D 1640)
	At + 20°C	~12 h		
	At + 40°C	~3.5 h		
	At + 60°C	~1 h		
			Final drying time	(ISO 9117-3)
	At + 20°C	~24 h		
	At + 40°C	~5 h		
	At + 60°C	~2 h		
			Fully mechanically and chemically cured	
	At + 20°C	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 minimum preparation standard Sa 2 ½ acc. to ISO 8501-1.

Average surface profile $R_z = 25 - 60 \mu\text{m}$ (ISO 8503-4) or acc. to specification.

Ensure substrate is free from dirt, grease, oil and other contaminants detrimental to adhesion.

MIXING

Stir component A using a powered mixer. For manual mixing add component B subsequently at the specified mixing ratio. Stir thoroughly, including sides and bottom of the container, until a homogeneous mixture is achieved. If using plural feeded airless equipment (automatic dosage) a dosage control shall be installed to monitor correct mixing ratio.

APPLICATION

Airless spraying:

- Use a high ratio plural feeded airless pump
- Minimum pump ratio: 45 : 1
- Spray pressure min. 180 bar
- Spray Nozzle: 0.33 - 0.91 mm (0.015 - 0.036 inch)
- Spraying angle: $\geq 80^\circ$
- Material temperature: approx. $+ 40^\circ\text{C}$

Other spray parameters might be suitable depending on equipment. If possible do not thin Sika® Permacor®-337 VHS! Under special circumstances up to 3 % Sika Thinner E+B may be added.

Brushing or rolling:

Only suitable for small areas!

Clean and prepare damaged areas by sanding or light blasting of areas to be coated and ensure thorough removal of dust. Then overcoat as soon as possible (recommended temperature of material: $\geq + 20^\circ\text{C}$). Under special circumstances up to 3 % Sika Thinner E+B may be added.

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.

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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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