

PRODUCT DATA SHEET

Sika® Permacor®-2204 VHS

Very High Solid EP-zinc-mio primer for steel

Made in Germany

DESCRIPTION

Sika® Permacor®-2204 VHS is a low solvent containing 2-pack primer based on a special EP-formulation.

Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04)

USES

Sika® Permacor®-2204 VHS may only be used by experienced professionals.

Mechanically resistant primer for atmospheric exposed steel surfaces - especially also for condensation exposure.

In combination with 2-pack top coats Sika® Permacor®-2204 VHS offers a mechanically resistant coating system for long-life corrosion protection with high weather resistance up to corrosivity category C5 high, acc. to ISO 12944-2.

CHARACTERISTICS / ADVANTAGES

- Thicknesses range from 80 µm to 200 µm per coat
- Excellent corrosion protection due to zincdust pigmentation
- Especially for workshop application

APPROVALS / CERTIFICATES

- Approved as 2-layer system with Sika® Permacor®-2230 VHS or SikaCor® EG-5 for corrosivity categories C4 high and C5 high.

PRODUCT INFORMATION

Packaging	Sika® Permacor®-2204 VHS	27.125 kg net.
	Sika® Thinner E+B	25 l and 5 l
	SikaCor® Cleaner	160 l and 25 l
Appearance and colour	Grey-reddish and grey	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~2.05 kg/l	
Solid content	~77 % by volume	
	~89 % by weight	

TECHNICAL INFORMATION

Chemical resistance	Resistant to weather, water, sewage, seawater, smoke, de-icing salts, acid and lye vapours, 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	<u>Steel:</u> 1 - 2 x Sika® Permacor®-2204 VHS <u>Hot dip galvanized surfaces, stainless steel and aluminium:</u> 1 x Sika® Permacor®-2204 VHS Suitable top coats: Sika® Permacor®-2215 EG VHS Sika® Permacor®-2230 VHS Sika® Permacor®-2330, SikaCor® EG-5
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APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	100 : 8.5
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 160 µm
	Wet film thickness	105 µm 210 µm
	Consumption	~0.210 kg/m ² ~0.420 kg/m ²
	VOC	~23.4 g/m ² ~46.9 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.	
Surface temperature	Min. 0°C	
Pot Life	At + 5°C	~5 h
	At + 10°C	~4 h
	At + 15°C	~3 h
	At + 20°C	~2 h
	At + 25°C	~75 min
Drying stage 6	<u>Dry film thickness 200 µm</u>	(ISO 9117-5)
	+ 5°C after	15 h
	+ 10°C after	12 h
	+ 20°C after	6 h

Waiting time to overcoating

Min.:

+ 5°C after	15 h
+ 10°C after	12 h
+ 15°C after	9 h
+ 20°C after	6 h
+ 25°C after	5 h
+ 30°C after	3 h

Max.: indoors 3 months, outdoors 4 weeks

Before overcoating ensure that the primed surface is dry and free from oil, grease and dirt (high pressure jetting can be recommended). In case of longer waiting times the surface must be grinded resp. sweep-blasted.

Drying time

Final drying time

At + 20°C and good ventilation the final hardness is achieved within 1 week. Tests of the completed coating system should only be carried out after final curing.

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.

Hot dip galvanized steel, stainless steel, aluminium:

Free from dirt, oil, grease and corrosion products. In case of condensation the surfaces must be slightly sweep blasted with a ferrite-free blasting abrasive.

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 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:

- Only suitable for small areas

Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°
- Diameter of hoses min. 10 mm (¾ inch)

CLEANING OF EQUIPMENT

SikaCor® 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.

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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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