

# PRODUCT DATA SHEET

## Sika® Permacor®-337-96 S

EP Flow Coat

Made in Germany

### DESCRIPTION

Sika® Permacor®-337-96 S is a 2-pack coating based on epoxy resin.

### USES

Sika® Permacor®-337-96 S may only be used by experienced professionals.

Sika® Permacor®-337-96 S 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

### APPROVALS / CERTIFICATES

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

### PRODUCT INFORMATION

<b>Packaging</b>	Component A: Sika® Permacor®-337-96 S redbrown	18 kg net.
	Component B: Sika® Permacor®-337-96	2.7 kg net.
	Other units on request.	
<b>Appearance and colour</b>	Redbrown Finish: Glossy (approx. 60 units / 60°-angle acc. ISO 2813)	
<b>Shelf life</b>	24 months (expiry date: see labelling)	
<b>Storage conditions</b>	In originally sealed containers in a dry, frost-free, cool environment (max. +30 °C, short term +40 °C).	
<b>Density</b>	~1.42 kg/l	
<b>Solid content</b>	~61 % by volume ~76 % by weight	

### TECHNICAL INFORMATION

<b>Temperature resistance</b>	Dry heat up to approx. + 120°C, short term up to approx. + 300°C
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## SYSTEM INFORMATION

System	<u>Steel:</u> 1 x Sika® Permacor®-337-96 S
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## APPLICATION INFORMATION

Mixing ratio	Components A : B		
	By weight 100 : 15 (tolerance: 100 : 14 - 16)		
	By volume 100 : 24 (tolerance: 100 : 23 - 25)		
Consumption	Theoretical material-consumption / coverage without loss for medium dry film thickness:		
	Dry film thickness	80 µm	
	Wet film thickness	130 µm	
	Consumption	~0.186 kg/m <sup>2</sup>	
	Coverage	~5.38 m <sup>2</sup> /kg	
Material temperature	Min. + 20°C		
Relative air humidity	Max. 80 % (surface temperature ≥ 3K above the dewpoint)		
Surface temperature	Min. + 10°C		
Pot Life	At + 20°C	~8 h	
	At + 30°C	~3 h	
	Pot life may vary depending on conditions of application. Mixture should be stirred once per hour to avoid demixing and settling of the fillers.		
Drying time	Drying/Curing Time at + 20°C surface temperature:		
	Dust-free	after ~45 min	(ASTM D 1640)
	Dry to touch	after ~3.5 h	
	Dry to handle	after ~12 h	
	Fully mechanically and chemically cured	after ~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 single or plural feeded airless pump
- Minimum pump ratio: Min. 45 : 1
- Spray pressure in gun min: Min. 180 bar
- Spray nozzle: 0.33 - 0.91 mm (0.015 - 0.036 inch)
- Spraying angle:  $\geq 80^\circ$
- Material temperature:  $\geq + 20^\circ\text{C}$   
(other spray parameters might be suitable depending on equipment)

If possible do not thin Sika® Permacor®-337-96 S!  
Under special circumstances up to 5 % 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. Under special circumstances up to 5 % 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.

## 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

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### **PRODUCT DATA SHEET**

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Data Sheet for the product concerned, copies of which will be supplied on request.

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