

## PRODUCT DATA SHEET

# Sika® Permacor®-2107 HS

Hot spray epoxy coating, 100 % volume solids

Made in Germany

### DESCRIPTION

Sika® Permacor®-2107 HS is a 2-pack epoxy coating with 100 % volume solids and applied with 2-pack hot-spray equipment.

The coating has high physical strength, with good abrasion and impact resistance.

Solvent free according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

### USES

Sika® Permacor®-2107 HS may only be used by experienced professionals.

Sika® Permacor®-2107 HS is ideally suited for the corrosion protection of external surfaces of buried steel tanks and pipes.

### CHARACTERISTICS / ADVANTAGES

- Excellent resistance to water, sewage and the spillage of a wide range of chemicals, flammable and non-flammable liquids
- Resistant to root damage and microbial degrade
- Resistant to biogas and natural gases - consequently no softening of the coating when buried
- Very good adhesion to steel surfaces
- Particularly economic to use, owing to its single-coat application
- Excellent long term service record

### APPROVALS / CERTIFICATES

- Approved for the external lining of buried LPG-pressure tanks, in accordance with EN 12542 (respectively former DIN 4681-3)
- Certified for the external lining of underground steel storage tanks, in accordance with KIWA Evaluation Guideline BRL-K 768

### PRODUCT INFORMATION

<b>Packaging</b>	Component A:	
	Sika® Permacor®-2107 HS	250 kg and 25 kg
	Component B:	
	Sika® Permacor®-2100 HS	250 kg and 25 kg
<b>Appearance and colour</b>	Grey, approx. RAL 7009 (component A: black / component B: yellow)	
<b>Shelf life</b>	2 years	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.	
<b>Density</b>	~1.6 kg/l	
<b>Solid content</b>	~100 % by volume	
	~100 % by weight	

## TECHNICAL INFORMATION

Mechanical resistance	Pull-off-test for adhesion	>15 MPa	(acc. to ISO 4624)
	Buchholz hardness	~ 100	(acc. to ISO 2815)
Chemical resistance	Depending on chemical exposure resp. upon request.		
Temperature resistance	Dry heat up to approx. + 120°C Buried components approx. + 80°C		

## SYSTEM INFORMATION

System	Steel: 1 x 1000 µm Sika® Permacor®-2107 HS
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## APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	100 : 50 (2 : 1)
	By volume	100 : 55 (1.8 : 1)
Consumption	Theoretical material-consumption/coverage without loss for medium dry film thickness of:	
	Dry film thickness	1000 µm
	Wet film thickness	1000 µm
	Consumption	1.6 kg/m <sup>2</sup>
	Coverage	0.63 m <sup>2</sup> /kg
Material temperature	At least + 10°C	
Relative air humidity	Max 80 %, surface temperature shall be at least 3 K above dew point. When conditions approach these critical limits, the use of heating and dehumidification equipment is essential.	
Surface temperature	At least + 10°C	
Pot Life	At + 20°C	~20 min
	At + 80°C	~2 min
Waiting time to overcoating	<b>Waiting time at + 20°C</b> Max. 4h In case of longer waiting times the surface must be activated by sweep blasting.	
	<b>Overcoating</b> With itself. For other products please refer to Sika.	
Drying time	<b>Drying time at + 20°C</b>	
	Touch dry	After 3 h
	Walkable and moveable	After 16 h
	<b>Final drying time at + 20°C</b> Full mechanical and chemical resistance after 7 days.	
Porosity test	With a suitable high-voltage tester, e.g. Fischer-POROSCOPE® HV20 with flat electrode (rubber tongue). Test voltage 15 volt/µm.	

## 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:

Remove all weld spatter, then grind welds and joints in accordance with EN 14879-1.

Blast cleaning to Sa 2 ½ according to ISO 12944-4.

Free from dirt, oil and grease.

Average roughness depth  $R_z \geq 50 \mu\text{m}$ .

### MIXING

Application exclusively with 2-pack-hot-spray airless equipment.

Stir both components separately prior to application.

**Do not thin Sika® Permacor®-2107 HS!**

### APPLICATION

#### Hot spraying

- Undiluted
- Use special airless hot-spray equipment
- Temperature at nozzle: + 65°C to + 70°C

#### Repair

- Undiluted
- Suitable only for the repair of small areas

Clean and prepare damaged areas by sanding or sweep blasting of areas to be coated and ensure thorough removal of dust. As soon as possible the cold mixed material should be applied by trowel.

### CLEANING OF EQUIPMENT

Sika® Cleaner HS

## 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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#### **PRODUCT DATA SHEET**

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