

PRODUCT DATA SHEET

Sika® Permacor®-2330 CN

2-component Acrylic PUR topcoat

DESCRIPTION

Sika® Permacor®-2330 CN is a 2-component, high-gloss acrylic polyurethane coating with excellent outdoor weatherability, optimum gloss and color retentions. It forms a hard and tough film resistant to abrasion and impact.

USES

Sika® Permacor®-2330 CN may only be used by experienced professionals.

- Sika® Permacor®-2330 CN is used as mechanical resistant topcoat for atmospheric exposed steel surfaces, particularly for heavy plant and machinery, paper mills, engines, roller-coasters and commercial vehicles.
- Sika® Permacor®-2330 CN offers in combination with 2-component primers and intermediate coats, a mechanical resistant coating system for long life corrosion protection with high weather resistance up to corrosively categories C5 and CX acc. to ISO 12944.

CHARACTERISTICS / ADVANTAGES

- High weather, gloss, and colour shade retention
- On the rigid surfaces of non-ferrous metal, concrete, asbestos-cement board, plank, polymeric ester.
- As advanced decorative topcoat on the machinery and machine tool etc.
- Applicable also at low temperatures down to 0°C.

APPROVALS / STANDARDS

Complies with the technical indicators specified in HG/T 2454-2014 (2017) Type II Topical Topcoat Class 2

PRODUCT INFORMATION

Chemical Base	Acrylic Polyurethane	
Packaging	Part A	20.0 kg
	Part B	4.0 kg
	Part A+B	24.0 kg/set
	Sika Thinner P CN	17.0 kg
Appearance / Colour	RAL- colour shades, glossy Others upon request.	
Shelf Life	2 years	
Storage Conditions	In originally sealed containers in a cool and dry environment.	
Density	approx.1.25kg/L	
Solid Content by Weight	approx.69%	

Chemical Resistance	Resistant against atmospheric exposure
Thermal Resistance	Dry heat up to + 140°C, Damp heat up to approx. + 50°C In case of higher temperatures please consult Sika.

APPLICATION INFORMATION

Mixing Ratio	5 : 1 by weight															
Consumption	Theoretical material-consumption without loss for medium dry film thickness: <table border="1"> <tr> <td>Dry film thickness</td> <td>50 µm</td> <td>80 µm</td> </tr> <tr> <td>Wet film thickness</td> <td>91 µm</td> <td>145 µm</td> </tr> <tr> <td>Consumption</td> <td>approx. 0.114 kg/m²</td> <td>approx. 0.182kg/m²</td> </tr> </table>	Dry film thickness	50 µm	80 µm	Wet film thickness	91 µm	145 µm	Consumption	approx. 0.114 kg/m ²	approx. 0.182kg/m ²						
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Product Temperature	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.															
Pot Life	<table border="1"> <tr> <td>At + 10°C</td> <td>approx. 3.0 hours</td> </tr> <tr> <td>At + 20°C</td> <td>approx. 2.0 hours</td> </tr> <tr> <td>At + 30°C</td> <td>approx. 1.5 hours</td> </tr> </table>	At + 10°C	approx. 3.0 hours	At + 20°C	approx. 2.0 hours	At + 30°C	approx. 1.5 hours									
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Waiting Time / Overcoating	<p>DFT=50um</p> <table border="1"> <thead> <tr> <th>Surface temperature</th> <th>Min.</th> <th>Max.</th> </tr> </thead> <tbody> <tr> <td>+ 0°C</td> <td>3 days</td> <td>6 months</td> </tr> <tr> <td>+ 10°C</td> <td>32 hours</td> <td>6 months</td> </tr> <tr> <td>+ 20°C</td> <td>16 hours</td> <td>3 months</td> </tr> <tr> <td>+ 30°C</td> <td>12 hours</td> <td>2 months</td> </tr> </tbody> </table> <p>Note:</p> <ul style="list-style-type: none"> ▪ Recoat interval refers to surfaces exposed to periodical immersion, heavy condensation, great variation in temperature, chemical attack during service life of the coating system. Under other conditions no maximum re-coat interval. ▪ A completely clean surface is mandatory to ensure intercoat adhesion, especially at long re-coat intervals. ▪ Any dirt, oil and grease has to be removed with suitable cleaner followed by high pressure fresh water cleaning, salts to be removed by fresh water hosing. ▪ If the maximum re-coat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. ▪ In case of re-coating with other paint materials maximum will be 1-3 days (+20°C) depending on type. 	Surface temperature	Min.	Max.	+ 0°C	3 days	6 months	+ 10°C	32 hours	6 months	+ 20°C	16 hours	3 months	+ 30°C	12 hours	2 months
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Drying Time	Depending on film thickness and temperature full hardness is achieved within 7 days at 20°C. Tests of the completed coating system should only be carried out after final curing.															

Drying Stage 6

DFT=50um

<u>Surface temperature</u>	<u>Touch dry (approx.)</u>	<u>Fully cured (R.H 70%)</u>
+ 0°C	36 hours	32 days
+ 10°C	16 hours	14 days
+ 20°C	8 hours	7 days
+ 30°C	6 hours	5 days

SYSTEM INFORMATION

Systems

Steel:

Used as top coat on 2-pack primer and intermediate coats of the SikaCor® and Sika® Permacor® product range.

Hot dip galvanized steel, stainless steel and aluminium:

1 x SikaCor® EG-1 or Sika Permacor® 2315 CN

1 x Sika® Permacor®-2330 CN

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

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

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

MIXING

Stir component A very thoroughly using an electric stirrer. Add component B and mix both components very thoroughly (including sides and bottom of the container).

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 and by brush. 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 and roller:

Conventional high pressure spraying:

- Nozzle size 1.5 - 2.5 mm
- Pressure 3 - 5 bar
- Oil and water trap is compulsory

Airless-spraying:

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CLEANING OF TOOLS

Sika Thinner P CN

Spraying equipment must be rinsed with Sika Thinner P CN before using Sika® Permacor®-2330 CN

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

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. It may be necessary to adapt the above disclaimer to specific local laws and regulations. Any changes to this disclaimer may only be implemented with permission of Sika® Corporate Legal in Baar.

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