

PRODUCT DATA SHEET

Sika® Permacor®-2807 HS A

CONDUCTIVE HOT SPRAY EPOXY COATING, 100 % VOLUME SOLIDS

DESCRIPTION

Sika® Permacor®-2807 HS A is a 2-pack epoxy coating with 100 % volume solids.
Application with 2-pack hot-spray equipment.
The coating shows 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®-2807 HS A may only be used by experienced professionals.
Sika® Permacor®-2807 HS A is ideally suited for the corrosion protection of steel, stainless steel and aluminium in direct contact with various media.
The principal use of Sika® Permacor®-2807 HS A is the internal lining of tanks, containers, silos, secondary containment structures, waste water treatment facilities and pipelines.
Sika® Permacor®-2807 HS A is also particularly suitable for the coating of old and highly eroded and pitted steel tanks - without extra laminate reinforcement.

CHARACTERISTICS / ADVANTAGES

- High chemical resistance to water, aggressive effluents, flammable and non-flammable liquids, as well as a wide range of chemicals
- Approved also for biofuels containing hydrocarbon fuels
- Conductive
- High diffusion resistance
- Very good adhesion to steel, stainless steel and aluminium
- Economical, one-coat application
- Traceable references and track record for a service life of more than 20 years

APPROVALS / STANDARDS

- Approved by the building authorities of German DIBt for the internal lining of steel tanks designed for the storage of flammable liquids.
- Certified in compliance with KIWA-Directive BRL-K779 for the internal lining of steel tanks designed for the storage of flammable liquids.

PRODUCT INFORMATION

Packaging	Component A: Sika® Permacor®-2807 HS A	25 kg net.
	Component B: Sika® Permacor®-2800 HS A	25 kg net.
Appearance / Colour	Grey approx. RAL 7024 (component A: light grey / component B: dark grey) Finish: Glossy	
Shelf Life	2 years	
Storage Conditions	In originally sealed containers in a cool and dry environment.	

Density	~1.5 kg/l
Solid Content	~100 % by volume ~100 % by weight

TECHNICAL INFORMATION

Mechanical Resistance	Buchholz hardness acc. ISO 2815: ~ 100
Abrasion Resistance	In accordance with ASTM D 4060 (Taber Abraser): 235 mg/100 U (load: 500 g; disc S 33)
Chemical Resistance	Upon request
Thermal Resistance	Dry heat up to approx. + 100°C
Electrical Resistance	$\leq 1 \times 10^8 \Omega$

SYSTEM INFORMATION

Systems	<u>Steel (coating for flammable liquids):</u> 1 x Sika® Permacor®-2807 HS A (min. 500 µm up to max. 1800 µm)
	<u>Steel, stainless steel and aluminium:</u> 1 x Sika® Permacor®-2807 HS A (min. 500 µm up to max. 2500 µm)

APPLICATION INFORMATION

Mixing Ratio	Components A : B	
	By weight	100 : 50 (2 : 1)
	By volume	100 : 66 (1.5 : 1)

Consumption	Theoretical material-consumption/ coverage without loss for medium dry film thickness of:		
	Dry film thickness	500 µm	1000 µm
	Wet film thickness	500 µm	1000 µm
	Consumption	~0.75 kg/m ²	~1.5 kg/m ²
	Coverage	~1.33 m ² /kg	~0.67 m ² /kg

Ambient Air 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	~30 min
	At + 60°C	~5 min

Waiting Time / Overcoating	Waiting time at + 20°C Max. 4 h In case of longer waiting times the surface must be activated by sweep blasting.
	Overcoating With itself. For other products please refer to Sika.

Drying Time

Drying time at + 20°C

Touch dry	after ~6 h
Walkable	after ~12 h

Mechanical and chemical resistance

at + 23°C	after ~ 2 days
at + 12°C	after ~ 5 days
at + 7°C	after ~ 7 days

Containers or pipes can be sealed immediately after the coating has been applied. The coating hardens without the need for ventilation!

Porosity Test

Due to the electrical conductivity of the coating, this may only be assessed visually.

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 Rz ≥ 50 µm.

Stainless steel and aluminium:

Sweep blast in accordance with ISO 12944-4.

Only non-metallic abrasives should be used.

Average roughness depth Rz ≥ 50 µm.

Ensure substrate is free from contaminants detrimental to adhesion.

MIXING

Application exclusively with 2-pack-hot-spray airless equipment. Stir both components separately prior to application.

Do not add any thinner.

APPLICATION

Hot spraying:

- Undiluted
- Use special airless hot-spray equipment
- Nozzle size ≥ 0.53 mm (0.021 inch)
- Spraying angle: e.g. 50°
- 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 TOOLS

Sika® Cleaner HS

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.

LOCAL RESTRICTIONS

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

ECOLOGY

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

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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