

PRODUCT DATA SHEET

Sika® Permacor®-138 A

Conductive total solid epoxy coating, 100% volume solids

DESCRIPTION

Sika® Permacor®-138 A is a 2-pack epoxy coating for steel surfaces with 100 % volume solids. 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®-138 A may only be used by experienced professionals.

Sika® Permacor®-138 A is ideally suited as internal lining of tanks, containers, silos, secondary containment structures and pipelines.

CHARACTERISTICS / ADVANTAGES

- High chemical resistance to 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

APPROVALS / CERTIFICATES

- Approved by the building authorities of German DIBt for the internal lining of steel tanks designed for the storage of flammable liquids.
- Monitored by 'KIWA NL' according to 'BRL-K 779' as certified internal lining of steel tanks designed for the storage of flammable liquids.

PRODUCT INFORMATION

Packaging	Sika® Permacor®-138 A	11.8 kg net.
	SikaCor® Cleaner	160 l and 25 l
Appearance / Colour	Blackgrey (approx. RAL 7021)	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.3 kg/l	
Solid content	~100 % by volume ~100 % by weight	

TECHNICAL INFORMATION

Chemical resistance	Upon request
Temperature resistance	Dry heat up to approx. + 100°C
Electrical resistance	≤ 1 x 10 ⁸ Ω

SYSTEMS

Systems	<u>Steel:</u> 1 x Sika® Permacor®-138 A (min. 500 µm) (technical film thickness range: min. 300 µm up to max. 1000 µm, NDFT depends on stored chemicals)
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APPLICATION INFORMATION

Mixing ratio		Components A : B
	<u>By weight</u>	<u>100 : 31</u>
	<u>By volume</u>	<u>100 : 39</u>
Consumption	Theoretical material-consumption / coverage without loss for medium dry film thickness:	
	<u>Dry film thickness</u>	<u>500 µm</u>
	<u>Wet film thickness</u>	<u>500 µm</u>
	<u>Consumption</u>	<u>~0.650 kg/m²</u>
	<u>Coverage</u>	<u>~1.5 m²/kg</u>
Ambient air temperature	Min. + 8°C	
Relative air humidity	Max. 80 %, surface temperature shall be at least 3 K above dew point.	
Surface temperature	Min. + 8°C	
Pot Life	<u>At + 20°C</u>	<u>~20 min</u>
	<u>At + 30°C</u>	<u>~10 min</u>
Waiting time to overcoating	Overcoating with itself within 2 days (+ 20°C), e.g. overlappings when application work is section by section. In case of longer waiting times the surface must be activated by sweep-blasting.	
Drying time	Drying Time at + 20°C:	
	<u>Touch dry</u>	<u>After 4 h</u>
	<u>Walkable</u>	<u>After 12 h</u>
	<u>Full mechanical and chemical resistance</u>	<u>After ~7 days</u>
	Final drying time: See drying time For curing procedure there is no need of air ventilation.	
Porosity test	Due to electrical conductivity of the coating, this may only be assessed visually.	

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.

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 Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

DIRECTIVE 2004/42/CE LIMITATION OF EMISSIONS OF VOC

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / j type Sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sika® Permacor®-138 A is < 500 g/l VOC for the ready to use product.

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 $R_z \geq 50$ microns.

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

By brush and roller:

- Suitable only for the repair of small areas or to pre-coat edges

Airless-spraying:

- High pressure airless equipment (capacity ≥ 18 l/min)
- Pump directly (without connected suction hose)
- Pressure min. 200 bar
- Hose: max. 20 m length, $\frac{3}{8}$ inch resp. 10 mm internal diameter, directly before gun approx. 2 m hose, $\frac{1}{4}$ inch
- Nozzle size ≥ 0.48 mm
- Spraying angle: 40° - 80°

Temperature of equipment and material min. + 20°C.
At lower temperatures insulation of the hose and the use of an inline heater is recommended; particularly when long hoses are used.

Repair works:

Clean and prepare damaged areas by sanding or sweep blasting of areas to be coated and ensure thorough removal of dust. Then overcoat as soon as possible.

Do not thin Sika® Permacor®-138 A!

CLEANING OF EQUIPMENT

SikaCor® Cleaner

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.

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 re-

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serves 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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