BUILDING TRUST

PRODUCT DATA SHEET

Sika® Permacor®-2706 EG

EPOXY-MIO-COATING

DESCRIPTION

Sika® Permacor®-2706 EG is a 2-pack coat based on epoxy resin containing micaceous iron oxide with high mechanical resistance and outstanding adhesion.

USES

Sika® Permacor®-2706 EG may only be used by experienced professionals.
Sika® Permacor®-2706 EG is used as primer for hot dip galvanized steel and **also as primer under Sika® Unitherm® and Sika® Pyroplast® fire protection systems**, as well as intermediate coating for atmospheric corrosion protection on steel.

CHARACTERISTICS / ADVANTAGES

- Coating with high mechanical resistance
- For primed steel, directly on hot dip galvanized steel, sprayed zinc, stainless steel and aluminium
- High content of micaceous iron oxide offers dense and highly resistant layers

APPROVALS / STANDARDS

- Tested and official approved primer for Sika® Unitherm® and Sika® Pyroplast® fire protection systems on steel.

PRODUCT INFORMATION

Packaging	Sika® Permacor®-2706 EG	24 kg and 3 kg net.
	Sika® Thinner E+B	25 l and 5 l
	SikaCor® Cleaner	160 l and 25 l
Appearance / Colour	Approx. RAL 7032, pebble grey Finish: Mat	
Shelf Life	2 years	
Storage Conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.4 kg/l	
Solid Content	~45 % by volume ~66 % by weight	

TECHNICAL INFORMATION

Chemical Resistance	Upon request
Thermal Resistance	Dry heat up to approx. + 120°C, short term up to + 150°C

SYSTEM INFORMATION

Systems

Steel:
Possible primers:
Sika® Permacor®-2305 Rapid
Sika® Permacor®-2311 Rapid
Sika® Permacor®-2204 VHS

Hot dip galvanized steel, sprayed zinc, stainless steel, aluminium:
1 x Sika® Permacor®-2706 EG

Possible topcoats:
Sika® Permacor®-2230 VHS
Sika® Permacor®-2330
Sika® Permacor®-2706
Sika® Permacor®-2707
and
Sika® Unitherm® or Sika® Pyroplast® fire protection systems for steel.

APPLICATION INFORMATION

Mixing Ratio

	Components A : B
By weight	100 : 20

Thinner

Sika® Thinner E+B
If necessary max. 2 % Sika® Thinner E+B may be added to adapt the viscosity.

Consumption

Theoretical material-consumption/ coverage without loss for medium dry film thickness of:

Dry film thickness	40 µm
Wet film thickness	90 µm
Consumption	~0.125 kg/m²
Coverage	~8.03 m²/kg

Product 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.

Surface Temperature

Min. + 10°C

Pot Life

At + 20°C	~8 h

Waiting Time / Overcoating

Waiting time at + 20°C

Min.:	after 8 h
Max.:	upon request

Drying Time

Dry film thickness of 40 µm

At + 20°C	after 16 h

Final drying time
Depending on film thickness and temperature full hardness is achieved within 1 week at + 20°C. Tests of the completed coating system should only be carried out after final curing.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Steel:
Blast-cleaning to Sa 2 ½ according to ISO 12944-4.
Free from dirt, oil and grease.

Hot dip galvanized steel, sprayed zinc:
Free of oil, grease and zinc salts.
In case of permanent exposure to submersion and condensation surfaces should be sweep blasted according to ISO 12944-4.

Stainless steel, aluminium:
Sweep-blasting according to ISO 12944-4 with non-metallic / non-ferrous abrasives.

For contaminated and weathered surfaces e.g. hot dip galvanized or primed areas we recommend to clean with SikaCor® Wash.

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

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. 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 or roller

Airless-spraying:
▪ Nozzle size ≥ 0.38 mm

CLEANING OF TOOLS

SikaCor® Cleaner

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 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.

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.

GISCODE: RE 3

This coding enables additional information and help with the creation of operating instructions (WINGIS online) to be obtained on the BG Bau service pages (www.gisbau.de).
Skin contact with epoxy resins can lead to allergies!
Avoid direct skin contact at all costs when handling epoxy resins!

For the selection of suitable protective equipment, we have made our information data sheets 7510 ‘General notes on occupational safety’ and 7511 ‘General notes for wearing protective gloves’ available at www.sika.de. In conjunction with this we also recommend the BG Bau service pages for information regarding the handling of epoxy resins (www.bgbau.de/gisbau/fachthemen/epoxi).

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®-2706 EG is < 500 g/l VOC for the ready to use product.

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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