

## PRODUCT DATA SHEET

# Sika® Permacor®-1705

Solvent containing 1-pack zinc-phosphate primer for steel

### DESCRIPTION

Sika® Permacor®-1705 is a solvent-borne 1-pack primer based on alkyd resin.

### USES

Sika® Permacor®-1705 may only be used by experienced professionals.

Sika® Permacor®-1705 is used as an anti-corrosive primer for atmospheric exposed steel surfaces.

### CHARACTERISTICS / ADVANTAGES

- Fast drying, universally applicable as primer with a great range of dry film thicknesses

### APPROVALS / STANDARDS

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

### PRODUCT INFORMATION

<b>Packaging</b>	Sika® Permacor®-1705	25 kg net, 3 l
	Sika® Thinner S	25 l, 10 l and 3 l
<b>Appearance / Colour</b>	Red brown approx. RAL 8012	
<b>Shelf Life</b>	2 years	
<b>Storage Conditions</b>	In originally sealed containers in a cool and dry environment.	
<b>Density</b>	~1.4 kg/l	
<b>Solid Content</b>	~49 % by volume ~67 % by weight	

### TECHNICAL INFORMATION

<b>Chemical Resistance</b>	Resistant to weathering.
<b>Thermal Resistance</b>	Dry heat up to + 80°C

## SYSTEM INFORMATION

<b>Systems</b>	<u>Primer for steel:</u> 1 x Sika® Permacor®-1705  <u>Suitable top coatings:</u> Versatile overcoatable with 1-pack top coats and with Sika® Unitherm® and Sika® Pyroplast® systems for steel.
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## APPLICATION INFORMATION

<b>Thinner</b>	Sika® Thinner S If necessary max. 3 % Sika® Thinner S may be added to adapt the viscosity.												
<b>Consumption</b>	Theoretical material-consumption/VOC without loss for medium dry film thickness: <table><tr><td>Dry film thickness</td><td>40 µm</td><td>80 µm</td></tr><tr><td>Wet film thickness</td><td>85 µm</td><td>165 µm</td></tr><tr><td>Consumption</td><td>~0.114 kg/m<sup>2</sup></td><td>~0.229 kg/m<sup>2</sup></td></tr><tr><td>VOC</td><td>~37.7 g/m<sup>2</sup></td><td>~75.6 g/m<sup>2</sup></td></tr></table>	Dry film thickness	40 µm	80 µm	Wet film thickness	85 µm	165 µm	Consumption	~0.114 kg/m <sup>2</sup>	~0.229 kg/m <sup>2</sup>	VOC	~37.7 g/m <sup>2</sup>	~75.6 g/m <sup>2</sup>
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<b>Product Temperature</b>	Min. + 5°C												
<b>Relative Air Humidity</b>	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.												
<b>Surface temperature</b>	Min. + 5°C												
<b>Waiting Time / Overcoating</b>	At + 20°C <u>Min. 16 h</u>												
<b>Drying Time</b>	<b>Drying time at + 20°C</b> Loadable after <u>~16 h</u>  <b>Final drying time</b> Depending on film thickness and temperature full hardness is achieved within 1 week.												

## 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 / i type Sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sika® Permacor®-1705 is < 500 g/l VOC for the ready to use product.

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION

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

### MIXING

Sika® Permacor®-1705 is supplied ready for use. Stir thoroughly prior to application.

## 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 and roller

#### Conventional high pressure spraying:

- Nozzle size 1.3 - 2.0 mm
- Pressure 4 - 6 bar

#### Airless-spraying:

- Pressure min. 150 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40° - 80°

## CLEANING OF TOOLS

Sika® Thinner S

## 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.

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### **Product Data Sheet**

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