

PRODUCT DATA SHEET

Sika® Permacor®-3326 EG H

VERY HIGH SOLID EPOXY COATING FOR CONCRETE

DESCRIPTION

Sika® Permacor®-3326 EG H is a low solvent containing 2-pack epoxy protective coating for concrete structures, subjected to chemical attack. The coating has high physical strength, with good abrasion and impact resistance. Suitable to use in hot and tropical climatic conditions.

USES

Sika® Permacor®-3326 EG H may only be used by experienced professionals.

Sika® Permacor®-3326 EG H is ideally suited for the corrosion protection of concrete surfaces exposed to various media. The principal use of Sika® Permacor®-3326 EG H is the internal lining of sludge digesters, composting vessels, and process water, waste water, and chemical storage tanks, as well as cooling water pipelines and biogas plants.

FEATURES

- High chemical resistance to water, aggressive effluents and waste water and a wide range of chemicals, particularly salt solutions and to acids occurring in biological processes
- High diffusion resistance
- Very good adhesion to mineral surfaces
- Reliable application due to the ability to check for pores in the coating

CERTIFICATES AND TEST REPORTS

- Chemical resistance against biogenous sulfuric acid (cat. XWW4/XBSK) acc. DIN 19573 and DIN EN 13529.
- Coating based on epoxy resin for concrete protection according to EN 1504-2, DoP, with CE-mark.

PRODUCT INFORMATION

Packaging	Part A + B	16 kg set
Appearance and colour	Pebble grey approx. RAL 7032 and green approx. DB 601	
Shelf life	24 months if stored properly in original packaging	
Storage conditions	The packaging must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5°C and +30°C. Protected from direct sunlight.	
Density	~1.9 kg/l	

TECHNICAL INFORMATION

Chemical resistance	Contact Sika® Technical Services for specific information.
Temperature resistance	Dry heat up to approx. +100°C

APPLICATION INFORMATION

Mixing ratio	Components A : B	
	By weight	100 : 23
	By volume	100 : 26
Thinner	Sika® Thinner E+B If necessary, max. 5% Sika® Thinner E+B may be added to adjust the viscosity.	
Consumption	Theoretical material-consumption/coverage without loss for medium dry film thickness of:	
	Dry film thickness	250 µm
	Wet film thickness	330 µm
	Consumption	0.633 kg/m ²
	Coverage	1.58 m ² /kg
Material temperature	Min. +10°C	
Relative air humidity	Max. 85 %	
	Max. 80 % in containers	
Dew point	Beware of condensation! The substrate must be at least 3°C above dew point to reduce the risk of condensation or blooming on the floor finish. Note: Low temperatures and high humidity conditions increase the probability of blooming.	
Substrate moisture content	Max. 4% (CM-measurment)	
Pot Life	At + 20°C	~90 min
	At + 30°C	~45 min
Waiting time to overcoating	Waiting time at + 20°C, for overcoating with itself:	
	Minimum:	12 hours
	Maximum:	48 hours
	In case of longer waiting times the surface must be activated by sweep blasting.	
Drying time	Drying time at + 20°C	
	Touch dry:	After ~4 hours
	Walkable:	After ~12 hours
	Final drying time	
	Full mechanical and chemical resistance after 7 days at + 20°C.	

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.

FURTHER DOCUMENTATION

- **Method Statement of Sika® Permacor®-3326 EG H**
- **Substrate Quality & Preparation**

Please refer to Sika Method Statement: "EVALUATION AND PREPARATION OF SURFACES FOR FLOORING SYSTEMS"

- **Application Instructions**

Please refer to Sika Method Statement: "MIXING & APPLICATION OF FLOORING SYSTEMS"

IMPORTANT CONSIDERATIONS

- For exposure to corrosive atmospheric conditions, it is recommended to overcoat with Sika® Permacor®-2230 VHS or Sika® Permacor®-2330.
 - Do not apply Sika® Permacor®-3326 EG H on substrates with rising moisture.
 - Freshly applied Sika® Permacor®-3326 EG H should be protected from damp, condensation and water for at least 24 hours.
 - Apply on a falling temperature. If applied during rising temperatures "pin holing" may occur from rising air.
- Construction joints require pre-treatment. Treat as follows:
- Static Cracks: prefill and level with Sikadur® or Sika-floor® epoxy resin
 - Dynamic cracks: to be assessed and if necessary ap-

ply a strip coat of elastomeric material or design as a movement joint

- The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The concrete surface areas to be coated must meet recognised building standards, i.e. be solid, load-bearing and free from contaminants detrimental to adhesion. Pull-off adhesion strength in accordance with DIN 1048 should be > 1.5 N/mm² on average with the lowest reading no less than 1.0 N/mm². For areas subject to heavy mechanical loading, the average value should be > 2.0 N/mm² and the lowest reading no less than 1.5 N/mm². Apply suitable compatible undercoats and observe recommended overcoating intervals.

MIXING

Stir component A and B very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add stirred 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.

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By brush or roller:

- Dry film thickness of approx. 150 µm per layer is achievable
- Possibly an additional layer may become necessary to achieve the total dry film thickness

Airless-spraying:

- Efficient airless equipment
- Pressure min. 180 bar
- Remove sieves
- Nozzle size ≥ 0.38 mm (≥ 0.015 inch)
- Spraying angle approx. 50°
- Diameter of hoses min. 10 mm (3/8 inch), hose at spray gun approx. 2 m, min. 6 mm (1/4 inch)
- Temperature of material min. + 15°C

CLEANING OF EQUIPMENT

Sika® Permacor®-3326 EG H is a chemical resistant rigid coating product providing good wet scrub resistance. It can be cleaned by washing with soft brushes or high-pressure water jetting, using water with or without mild alkaline detergents.

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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- Sika Construction Chemicals for Manufacturing LLC
- Master Builders Solutions LLC

All products are supplied under a management system certified to conform to the requirements of the quality, environmental and occupational health & safety standards ISO 9001, ISO 14001 and ISO 45001.



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