

# **CONSTRUCTION PRODUCT CATALOG** FULL RANGE SOLUTIONS



**BUILDING TRUST** 

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Sika Primer MB Sika Level-01 Primer	A270 A280
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Sikadur 31, SBA Normal Set	C380
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Sikadur 23 Lo-Mod Gel	B270
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Sikadur 43 Patch-Pak	usa.sika.com
Light Traffic	
Sikagard 62	A450
Sikadur Balcony System	C450
Sikagard Duochem 7500	C460
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Sikagard WDE Primer	C480
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SikaGrout Aid	usa.sika.com

D20

#### **E** - Total Corrosion Management

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Sika Ebonex	usa.sika.com

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Sikalastic EP Primer	F290
Sika Reactivation Primer	F300
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Sarnatherm ISO Insulation (25 psi)	usa.sil
Sarnatherm Tapered ISO Insulation (20 psi)	usa.sil
Sarnatherm Tapered ISO Insulation (25 psi)	usa.sil

Sarnatherm XPS Insulation

Dens Deck Roof Board

Securock Gypsum Fiber Roof Board

Securock Cement Roof Board

Sarnafastener #12	usa.sika.com
Sarnafastener #14	usa.sika.com
Sarnafastener CD10	usa.sika.com
Sarnaplate	usa.sika.com
Vapor Barriers and Primers	
Sarnavap Self-Adhered Vapor/Air Barrier	usa.sika.com
Sarnavap Self-Adhered Primer	usa.sika.com
Sarnavap Self-Adhered Primer WB	usa.sika.com
Sarnavap Self-Adhered Primer VC	usa.sika.com
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Sarnapaver	usa.sika.com
Sika Drainage Mats	usa.sika.com
Edge Grip Fascia	usa.sika.com
Edge Grip Extruded Fascia	usa.sika.com
Wall Grip Coping	usa.sika.com

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usa.sika.com

Adhesives and Fasteners Sarnacol OM Board Adhesive

#### **G** - Building Envelope

Wall Grip Coping Plus

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SikaMultiSeal 515	usa.sika.com

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### **A - Concrete Repair and Protection Systems**

Sika Armatet 110 EpoCemA10Sikagard 75 EpoCemusa.sika.comBonding AgentsSikaTop Seal 107A260Sika Armatet 110 EpoCemA10Sikadur 32 Hi-ModA20Sikadur 32 Hi-Mod LPLA30Sikafloor 81 Epocemusa.sika.comSikadur 32 Hi-Mod LPLA40Sika Primer MBA270Sikadur 32 Hi-Mod LPLA40Sika Primer MBA270Sika Liquid WeldA40Sika Primer MBA270Sikatagard Sika KarabaSikaLevel-D2 EZ PrimerA300Sika MonoTop 615usa.sika.comSikaLevel-D2 EZ PrimerA300SikaRepair 223A60SikaLevel-315A320SikaRepair 233A60SikaLevel-315A320SikaRepair 233A60SikaLevel-315A320SikaRepair 233A60SikaLevel-315A330SikaRepair SHAA70SikaLevel-315A330SikaTop 122 PLUSA100Sika FerroGard 903A340SikaTop 122 PLUSA100Sika FerroGard 903A340SikaTop 123 PLUSA100Sikagard 70NWA360Ouckeet MotrasSikagard 70SLA380SikaQuick 1000A120Sikagard 70SLA380SikaQuick Smooth FinishA150Sikagard 550W CA ElastocolorA400SikaQuick Smooth FinishA150Sikagard 550W CA ElastocolorA400SikaQuick Smooth FinishA150Sikagard 570A440Sikagard 570Sikagard 670WA440Sikagard 670WA440Sikagard 671usa.sika.com </th <th>Steel Reinforcement Primers</th> <th></th> <th>Protective Leveling Mortars/S</th> <th>Surface Fillers</th>	Steel Reinforcement Primers		Protective Leveling Mortars/S	Surface Fillers
SikaTop Seal 107A260Bonding AgentsA10Sika Armatec 110 EpoCemA10Sikadur 32 Hi-ModA20Self Leveling Mortars and PrimersSikadur 32 Hi-Mod LPLA30Sikafloor 81 Epocemusa.sika.comSikatur 32 Hi-Mod LPLA30Sikafloor 81 Epocemusa.sika.comSikatur 32 Hi-Mod LPLA40Sika Primer MBA270Sikatur 32 Hi-Mod LPLA40Sika Primer MBA270Sikatur 32 Hi-Mod LPLA40Sikaturet-Ol PrimerA280Sikatur 32 Hi-Mod Sika Primer MBA270Sikaturet-Ol PrimerA290Hand AppliedSikat.comSikaturet-Istikaturet-Is			-	
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### Sika<sup>®</sup> Armatec<sup>®</sup> 110 EpoCem Bonding Agent and Reinforcement Protection

Description	Sika® Armatec® 110 EpoCem is a 3-component, solvent-free, moisture-tolerant, epoxy-modified, cementitious product specifically formulated as a bonding agent and anti-corrosion coating.
Where to Use	<ul> <li>As an anti-corrosion coating for reinforcing steel in concrete restoration.</li> <li>As added protection to reinforcing steel in areas of thin concrete cover.</li> <li>As a bonding agent for repairs to concrete and steel.</li> <li>As a bonding agent for placing fresh, plastic concrete to existing hardened concrete.</li> </ul>
Advantages	<ul> <li>Excellent adhesion to concrete and steel.</li> <li>Acts as an effective barrier against penetration of water and chlorides.</li> <li>Long open time - up to 16 hours.</li> <li>Not a vapor barrier.</li> <li>Can be used exterior on-grade.</li> <li>Contains corrosion inhibitors.</li> <li>Excellent bonding bridge for cement or epoxy based repair mortars.</li> <li>High strength, unaffected by moisture when cured.</li> <li>Spray, brush or roller application.</li> <li>Non-flammable, solvent free.</li> </ul>
Coverage	<ul> <li>Bonding agent: minimum (theoretical) on smooth, even substrate 80 ft.<sup>2</sup>/gal. (=20 mils thickness). Coverage will vary depending on substrate profile and porosity.</li> <li>Reinforcement Protection: 40 ft.<sup>2</sup>/gal. (=20 mils thickness) (2 coat application).</li> </ul>
Packaging	<ul> <li>3.5 gal. unit. (47.6 fl. oz. Comp. A + 122.1 fl. oz. Comp. B + 46.82 lb. Comp. C) Comp. A + B in carton, Comp. C in multi-wall bag.</li> <li>1.65 gal. unit. (22.7 fl. oz. A + 57.6 fl. oz. B + 4 bags @ 5.5 lb.) Factory-proportioned units in a pail.</li> </ul>
	Typical Data (Material and curing conditions @ 73°F and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life 1 year in original, unopened packaging.
	StorageStore dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using. If components A and B are frozen, discard. Protect Component C from humidity.
	Color Concrete gray
	Density (Mixed) 125 lb./ft. <sup>3</sup> (2.0 kg.)
	Pot Life Approximately 90 minutes
	Compressive Strength (ASTM C-109)         3 days         4500 psi         (31.0 MPa)           7 days         6500 psi         (44.8 MPa)           28 days         8500 psi         (58.6 MPa)
	Flexural Strength (ASTM C-348) 28 days 1250 psi (8.6 MPa)
	Splitting Tensile Strength (ASTM C-496) 28 days 600 psi (4.1 MPa)
	Important Data for Sika Armatec 110 as a Corrosion Protective Coating
	WaterWater Permeability at 10 bar (145 psi) $8.92 \times 10^{-15}$ ft./sec.Control $7.32 \times 10^{-10}$ ft./sec.Water vapor diffusion coefficient $\mu$ H <sub>2</sub> O110
	<b>Carbon Dioxide</b> Carbon dioxide diffusion coefficient $\mu$ CO <sub>2</sub> 14000
	TEST DATA: Time-to-Corrosion Study

- Sika® Armatec® 110 more than tripled the time to corrosion
- Reduced corrosion rate by over 40%



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	24 hr. Open Time 2600 psi (17.9 MPa)
	Bond of Steel Reinforcement to Concrete (Pullout Test):Sika® Armatec® 110 Coated625 psi(4.3 MPa)Epoxy Coated508 psi(3.5 MPa)Plain Reinforcement573 psi(3.95 MPa)
How to Use	
Surface Preparation	<b>Cementitious substrates:</b> Should be cleaned and prepared to achieve a laitance and contaminant-free surface prepared in accordance with the requirements specified by the overlay or repair material by blast cleaning or equivalent mechanical means. Substrate must be saturated surface dry (SSD) with no standing water.
	Steel: Should be cleaned and prepared thoroughly by blast cleaning.
Mixing	Shake contents of both Component 'A' and Component 'B'. Empty entire contents of both Component 'A' an Component 'B' into a clean, dry mixing pail. Mix thoroughly for 30 seconds with a Sika paddle on a low spee (400-600 rpm) drill. Slowly add the entire contents of Component 'C' while continuing to mix for 3 minutes unt blend is uniform and free of lumps. Mix only that quantity that can be applied within its pot life.
Application	As a bonding agent - Apply by stiff-bristle brush or broom. Spray apply with Goldblatt Pattern Pistol or equal equipment. For best results, work the bonding slurry well into the substrate to ensure complete coverage of a surface irregularities. Apply the freshly mixed patching mortar or concrete wet on wet, or up to the maximum recommended open time, onto the bonding slurry. Maximum recommended open time between application of Armatec® 110 and patching mortar or concrete: 80°-95°F (26°-35°C) 6 hours 65°-79°F (18°-26°C) 12 hours 50°-64°F (10°-17°C) 16 hours 40°-49°F (4°-9°C) wet-on-wet For corrosion protection only - Apply by stiff-bristle brush or spray at 80 ft. <sup>2</sup> /gal. (20 mils). Take special car to properly coat the underside of the totally exposed steel. Allow coating to dry 2-3 hours at 73°F, then apple a second coat at the same coverage. Allow to dry again before the repair mortar or concrete is applied. Pour or place repair within 7 days.
Limitations	<ul> <li>Substrate and ambient temperature: Minimum 40°F (5°C).</li> <li>Maximum 95°F (35°C).</li> <li>Minimum thickness: As a bonding agent 20 mils.</li> <li>For reinforcement protection 40 mils.</li> <li>(2 coats, 20 mils each).</li> <li>Not recommended for use with expansive grouts.</li> <li>Use of semi-dry mortars onto Sika® Armatec® 110 EpoCem must be applied "wet on wet".</li> <li>When used in overhead applications with hand placed patching mortars, use "wet on wet" for maximum mortar built thickness.</li> <li>Substrate profile as specified by the overlay or repair material is still required.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> </ul>
INS SHE PAF TO REP KEEP KEEP For fu	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN TRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT EET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUP NT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONL UITHER INFORMATION and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to th I Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.
Prior Data : ment for ee produ SIKA the cu Buyer EXPR SHAL THE U	to each use of any Sika product, the user must always read and follow the warnings and instructional 703-527-3887. to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depar at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructio ach Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to ucr use. warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties o urrent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risk. r's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIE ESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIK L. NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FO JSE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHER: CONTINUE OF THIS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR B
CALL	UNG 201-933-8800. our website at usa.sika.com 1-800-933-SIKA NATIONWIDE
Regi	onal Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.         Sika Corporation         201 Polito Avenue         Pointe Claire         Sika Carporation         Sika Comporation         Sika Comporation         Other Sika Canada Inc.         601 Delmar Avenue         Pointe Claire         Carretera Libre Celaya Km. 8.5         Sika Comportial Balvanera

Important Data for Sika® Armatec® 110 as a Bonding Agent

2800 psi

14 days moist cure, plastic concrete to hardened concrete:

(19.3 MPa)

Bond Strength (ASTM C882)

Wet on Wet

*Jika*®

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Lyndhurst, NJ 07071 Phone: 800-933-7452

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#### Product Data Sheet Edition 10.1.2014 Sikadur® 32, Hi-Mod

### Sikadur<sup>®</sup> 32, Hi-Mod

#### High-modulus, high-strength, epoxy bonding/grouting adhesive

-				
Description	Sikadur <sup>®</sup> 32, Hi-Mod, is a multi-purpose, 2-component, 100% solids, moisture-tolerant structural epoxy adhesive. It conforms to the current ASTM C-881, Types I, II, and V, Grade-2, Class C and AASHTO M-235 specifications.			
Where to Use	<ul> <li>Bond fresh, plastic concrete to hardened concrete and steel.</li> <li>Grout horizontal cracks in structural concrete and wood by gravity feed.</li> <li>Machinery and 'robotic' base-plate grout.</li> <li>Structural adhesive for concrete, masonry, metal, wood, etc.</li> </ul>			
Advantages	<ul> <li>High-strength bonding/grouting adhesive.</li> <li>Tolerant to moisture before, during and after cure.</li> <li>Excellent adhesion to most structural materials.</li> <li>Convenient easy-to-mix ratio A:B = 1:1 by volume.</li> <li>Easy-to-use for bonding/grouting applications.</li> <li>Fast initial set; rapid gain to ultimate strengths.</li> <li>USDA-certified for use in food plants.</li> </ul>			
Coverage	<ul> <li>Bonding Adhesive - 1 gal. covers approximately 80 ft.<sup>2</sup> on smooth surface.</li> <li>Base Plate Grout - 1 gal. mixed with 1.5 parts oven-dried aggregate by loose volume yields approximately 420 cu. in. of grout.</li> <li>Anchoring grout - 1 gal. yields 231 cu. in. of grout.</li> </ul>			
Packaging	1, 2 and 4 gal. units.			
Typical Data (Material and curing conditions @ 73°F {23°C} and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.				
	Shelf Life         2 years in original, unopened containers.			
Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°- before using.				
	Color Concrete gray			
	Mixing RatioComponent 'A': Component 'B' = 1:1 by volume.			
	Viscosity Approximately 3,000 cps.			
	Pot Life Approximately 30 minutes. (60 gram mass). Approximately 22 minutes. (350 gram mass, 8 oz.)			
	Contact Time         40°F (4°C)*: 12 hrs.         73°F (23°C)*: 3-4.5 hrs.         90°F (32°C)*: 1.5-2 hrs			
	Compressive Modulus, psi 7 day 2.1 X 10 <sup>5</sup> psi (1,449 MPa)			
	Tensile Properties (ASTM D-638)7 dayTensile Strength6,900 psi (48 MPa)Elongation at Break1.9%14 dayModulus of Elasticity5.4 X 10 <sup>5</sup> psi (3,726 MPa)			
	Flexural Properties (ASTM D-790)14 dayFlexural Strength (Modulus of Rupture)7,000 psi (48.3 MPa)Tangent Modulus of Elasticity in Bending6.9 X 10 <sup>5</sup> psi (4,800 MPa)			
	Shear Strength (ASTM D-732) 14 day Shear Strength 6,200 psi (43 MPa)			
	Water Absorption (ASTM D-570)7 day (24 hour immersion)0.21%			
	Heat Deflection Temperature (ASTM D-648)7 day[fiber stress loading 264 psi (1.8 MPa)]122°F (50°C)			
	Bond Strength (ASTM C-882):       Plastic Concrete to Hardened Concrete       1,700 psi (11.7 MPa)         2 day (moist cure)       Plastic Concrete to Hardened Concrete       2,000 psi (13.8 MPa)         Hardened Concrete to Steel       1,900 psi (13.1 MPa)			
	14 day (moist cure)Plastic Concrete to Hardened Concrete2,200 psi (15.1 MPa)Plastic Concrete to Steel2,000 psi (13.8 MPa)Hardened Concrete to Hardened Concrete2,000 psi (13.8 MPa)			



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		i (MDa)			
	Compressive Strength, psi	40°F* (4°C) -	<b>73°F* (23°C)</b> 140 (1.0)	<b>90°F* (32°C)</b> 1,700 (11.7)	
	16 hour 1 day 3 day 7 day	30.0 (0.2) 5,300 (36.6) 9,600 (66.2)	4,800 (33.1) 5,700 (39.3) 11,300 (77.9) 11,800 (81.4)	7,300 (50.3) 7,300 (50.3) 10,400(71.7) 10,400(71.7)	
	14 day 28 day *Material cured and tested at the temp	11,900 (82.1) 12,600 (86.9)	12,200 (84.1) 12,200 (84.1)	10,400(71.7) 10,500(72.4)	
How to Use					
Surface Preparation	<b>n</b> Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, grease, curing compounds, impregnations, waxes and any other contaminants.				
	Preparation Work: Concrete - open textured surface by blasto Steel - Should be cleaned and	cleaning or other equiv	alent mechanical means		
Mixing	<b>Pre-mix each component.</b> Propail. Mix thoroughly for 3 minut color. Mix only that quantity that	tes with Sika paddle o	n low-speed (400-600 rp		
Application	To bond fresh concrete to hardened concrete - Apply by brush, roller, broom or spray. Place fresh concret while Sikadur <sup>®</sup> 32, Hi-Mod, is still tacky. If coating becomes glossy and loses tackiness, remove any surface contaminants then recoat with additional Sikadur <sup>®</sup> 32 Hi-Mod, and proceed.				
	<b>To grout baseplates -</b> Add up to 1 1/2 parts of oven-dried aggregate to 1 part of mixed Sikadur® 32 by volume. Place grout under baseplate. Avoid contact with the underside of the plate. A 1/4 to 3/2 10 mm) space should remain between the top of the grout and the bottom of the plate.				
	Maximum thickness of grout pe to touch before applying addition neat Sikadur® 32 Hi-Mod. Pour the underside of the bearing pla	er lift is 1.5 in. (38 mm) onal layer. The remaini a sufficient quantity of	If multiple lifts are neede ng 1/4 to 3/8 in. (6 to 10 r	d, allow preceding layer to comm) space should be filled w	
	To gravity feed cracks - Pour n Seal underside of slab prior to t			lacement until completely fille	
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>For spray applications, consult Technical Service at 800-933-7452.</li> <li>Use only oven-dry aggregate.</li> <li>Material is a vapor barrier after cure.</li> </ul>				
	<ul> <li>For applications on exterior, on-grade substrates, consult Technical Services at 800-933-7452.</li> <li>Do not apply over wet, glistening surface.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>				

Compressive Properties (ASTM D-695)

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KEEP CONTAINER TIGHTLY CLOSED, KEEP OUT OF REACH OF CHILDREN, NOT FOR INTERNAL CONSUMPTION, FOR INDUSTRIAL USE ONLY, FOR PROFESSIONAL USE ONLY.

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

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### Sikadur<sup>®</sup> 32, Hi-Mod LPL

High-modulus, high-strength, extended pot life, epoxy bonding/grouting adhesive

scription					
	Sikadur <sup>®</sup> 32, Hi-Mod LPL adhesive. Sikadur <sup>®</sup> 32, H 32, Hi-Mod LPL conforms specifications.	Hi-Mod LPL offers a lo	ng pot life and contac	ct time even at 100°F (3	88°C). Sikadu
ere to Use	<ul> <li>Hot weather concrete p</li> <li>Bond fresh, plastic cor</li> <li>Grout horizontal cracks</li> <li>Machinery and basepla</li> <li>Structural adhesive for</li> </ul>	acrete to hardened con s in structural concrete ate grout.	crete and steel. and wood by gravity t	feed.	
/antages	<ul> <li>Extended pot life and d</li> <li>High-strength bonding,</li> <li>Tolerant of moisture be</li> <li>Excellent adhesion to a</li> <li>Convenient easy-to-mi</li> <li>Easy-to-use for bonding</li> </ul>	/grouting adhesive. efore, during, and after most structural materia ix ratio A:B = 1:1 by vol	cure. Is. Iume.		
verage	Bonding Adhesive - 1 g Base Plate Grout - 1 gal 420 in. <sup>3</sup> of grout.				approximatel
kaging	1 and 4 gal. units.				
		ED UPON STATISTICAL VAR	NATIONS DEPENDING UPO	AND 50% R.H.) IN MIXING METHODS AND EQU FIONS AND CURING CONDITIC	
	Shelf Life	2 years in original, un	opened containers.		
	Storage Conditions	Store dry at 40°-95°F using.	(4°-35°C). Condition	material to 65°-75°F (18°	°-24°C) before
		donig.			
	Color	Dark gray.			
	Mixing Ratio	Dark gray. Component 'A' : Comp	· · · · · ·	lume.	
	Mixing Ratio Viscosity (Mixed)	Dark gray. Component 'A' : Comp Approximately 2,800 c	cps.		
	Mixing Ratio	Dark gray. Component 'A' : Comp	cps. utes @ 73°F (23°C).	(8 fl. oz. volume)	
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F * <b>°F (23°C)</b> 10-14	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr.	90°F (32°C) 2-2.5 hr. 1.5-2 hr.
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 73 terial Temperature 10	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F * <b>°F (23°C)</b> 10-14	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5-6 hr. 5,800 psi (40.0 MPa 5 %	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Tensile Properties (AS Flexural Properties (A 14 day Flexura	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 73 terial Temperature 10 STM D-638) 14 day	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F <b>(23°C)</b> 10-14 <b>(0°F (38°C)</b> 6-8 he Tensile Strength Elongation at Breal Modulus of Elasticit Rupture) 9,	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5-6 hr. 5,800 psi (40.0 MPa 5 %	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Tensile Properties (AS Flexural Properties (A 14 day Flexura	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 10 STM D-638) 14 day	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F <b>°F (23°C)</b> 10-14 <b>10°F (38°C)</b> 6-8 hi Tensile Strength Elongation at Breal Modulus of Elastici Rupture) 9, in Bending 7.	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5,800 psi (40.0 MPa 5 % ty 4.9 x 10 <sup>5</sup> psi (3,381 100 psi (62.8 MPa) 3 X 10 <sup>5</sup> psi (5,037 MPa)	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Tensile Properties (AS Flexural Properties (A 14 day Flexura Tangen	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 10 STM D-638) 14 day (STM D-790) al Strength (Modulus of the Modulus of Elasticity M D-732) 14 day	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F <b>1°F (23°C)</b> 10-14 <b>10°F (38°C)</b> 6-8 hi Tensile Strength Elongation at Breal Modulus of Elastici Rupture) 9, in Bending 7. Shear Strength 6	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5,800 psi (40.0 MPa 5 % ty 4.9 x 10 <sup>5</sup> psi (3,381 100 psi (62.8 MPa) 3 X 10 <sup>5</sup> psi (5,037 MPa)	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Tensile Properties (AS Flexural Properties (A 14 day Flexura Tangen Shear Strength (ASTM	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 10 STM D-638) 14 day (STM D-790) al Strength (Modulus of at Modulus of Elasticity M D-732) 14 day (STM D-570) 7 day	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F <b>6°F (23°C)</b> 10-14 <b>10°F (38°C)</b> 6-8 hi Tensile Strength Elongation at Break Modulus of Elasticit Rupture) 9, in Bending 7. Shear Strength 6 (4 hours) 0	(8 fl. oz. volume) . (8 fl. oz. volume) (4°C) 73°F (23°C) . hr. 6-7 hr. . 5-6 hr. 5,800 psi (40.0 MPa . 5 % ty 4.9 x 10 <sup>5</sup> psi (3,381 100 psi (62.8 MPa) 3 X 10 <sup>5</sup> psi (5,037 MPa) ,400 psi (44.1 MPa)	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Ma Tensile Properties (AS Flexural Properties (AS 14 day Flexura Tangen Shear Strength (ASTN Water Absorption (AS Deflection Temperatu	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 73 terial Temperature 10 STM D-638) 14 day STM D-638) 14 day AD-732) 14 day TM D-570) 7 day re (ASTM D-648)	cps. utes @ 73°F (23°C). utes @ 100°F (38°C). 40°F <b>6°F (23°C)</b> 10-14 <b>10°F (38°C)</b> 6-8 hi Tensile Strength Elongation at Break Modulus of Elasticit Rupture) 9, in Bending 7. Shear Strength 6 (4 hours) 0	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5,800 psi (40.0 MPa 5 % ty 4.9 x 10 <sup>5</sup> psi (3,381 100 psi (62.8 MPa) 3 X 10 <sup>5</sup> psi (5,037 MPa) ,400 psi (44.1 MPa) 15% 8°F (42°C)	2-2.5 hr. 1.5-2 hr. a)
	Mixing Ratio Viscosity (Mixed) Pot Life Contact Time: Su Ma Tensile Properties (AS Flexural Properties (AS 14 day Flexura Tangen Shear Strength (ASTM Water Absorption (AS	Dark gray. Component 'A' : Comp Approximately 2,800 of Approximately 90 min Approximately 90 min Approximately 60 min bstrate Temperature terial Temperature 10 STM D-638) 14 day STM D-638) 14 day a Strength (Modulus of th Modulus of Elasticity M D-732) 14 day STM D-570) 7 day re (ASTM D-648) (f I C-882) e) Plastic concre	cps.         utes @ 73°F (23°C).         utes @ 100°F (38°C).         40°F         ''F (23°C)         10-14         10°F (38°C)         6-8 hr         Tensile Strength         Elongation at Break         Modulus of Elasticit         ''Rupture)       9,         in Bending       7.         Shear Strength       6         (4 hours)       0         14 day       10         ''iber stress loading = 2	(8 fl. oz. volume) (8 fl. oz. volume) (4°C) 73°F (23°C) hr. 6-7 hr. 5,800 psi (40.0 MPa 5 % ty 4.9 x 10 <sup>5</sup> psi (3,381 100 psi (62.8 MPa) 3 X 10 <sup>5</sup> psi (5,037 MPa) ,400 psi (44.1 MPa) .15% 8°F (42°C) 264 psi {1.8 MPa})	2-2.5 hr. 1.5-2 hr. a) MPa) 15.2 MPa)

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	Compressive Properties (ASTM D-6 Compressive Strength, psi (MPa) 1 day	95) 40°F* (4°C)* -	73°F* (23°C)*
	3 day 7 day 14 day	2,500 (17.2) 8,300 (57.2)	10,700 (73.8) 11,000 (75.9) 12,000 (82.3)
	28 day Compressive Modulus	10,000 (68.9) <b>28 day</b> 2.6 x 10	13,000 (89.7) <sup>5</sup> psi (1,794 MPa)
	* Material cured and tested at the temperatures inc	licated.	
How to Use			
Surface Preparatio	grease, curing compounds, impregnatio <b>Preparation Work: Concrete</b> - Should open textured surface by blast cleaning	ns, waxes and any other be cleaned and prepared or equivalent mechanica	d to achieve a laitance and contaminant fro
Mixing		Sika paddle on low-spee	Component 'A' and Component 'B' into cle d (400-600 rpm) drill until blend is a unifo
Application		ky. If coating becomes glo	n, roller, broom, or spray. Place fresh concre ssy and loses tackiness, remove any surfa 2L and proceed.
	To grout base plates - Add 1 1/2 parts by volume. Place grout under baseplate mm) space should remain between the grout per lift is 1.5 in. (38 mm) If multiple additional layer. The remaining 1/4 to 3/ LPL. Pour a sufficient quantity of neat e bearing plate.	of oven-dried aggregate e. Avoid contact with the top of the grout and the lifts are needed, allow pro 8-in. (6-10 mm) space sl poxy to allow the level to	e to 1 part of mixed Sikadur® 32, Hi-Mod L underside of the plate. A 1/4- to 3/8-in. (6- be bottom of the plate. Maximum thickness eceding layer to cool to touch before apply hould be filled with neat Sikadur® 32, Hi-M rise slightly higher than the underside of
	To gravity feed cracks - Pour neat mate Seal underside of slab prior to filling if c		ck. Continue placement until completely fill
Limitations	<ul> <li>Minimum substrate and ambient tem</li> <li>For spray applications, consult Techr</li> <li>Use only oven-dry aggregate.</li> <li>Material is a vapor barrier after cure.</li> <li>For applications on exterior, on-grade</li> <li>Not an aesthetic product. Color may</li> </ul>	nical Service.	
li S P	RIOR TO EACH USE OF ANY SIKA PRODUCT ISTRUCTIONS ON THE PRODUCT'S MOST CI HEET WHICH ARE AVAILABLE ONLINE AT HT ARTMENT AT 800.933.7452 NOTHING CONTAIN O READ AND FOLLOW THE WARNINGS AND I	JRRENT PRODUCT DATA TP://USA.SIKA.COM/ OR I IED IN ANY SIKA MATERIA	SHEET, PRODUCT LABEL AND SAFETY DA BY CALLING SIKA'S TECHNICAL SERVICE I ALS RELIEVES THE USER OF THE OBLIGATI
R	ENT PRODUCT DATA SHEET, PRODUCT LABE	L AND SAFETY DATA SHI	EET PRIOR TO PRODUCT USE.
Fo	EP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILD r further information and advice regarding transporta ual Safety Data Sheets containing physical, ecological	tion, handling, storage and dis , toxicological and other safety	sposal of chemical products, users should refer to related data. Read the current actual Safety Data Sh
be Pri Da me for	fore using the product. In case of emérgency, call CHE or to each use of any Sika product, the user must alway ta Sheet, product label and Safety Data Sheet which ar nt at 800-933-7452. Nothing contained in any Sika mate each Sika product as set forth in the current Product oduct use.	MTREC at 1-800-424-9300, Internet rs read and follow the warnings e available online at http://usa. rials relieves the user of the ob	ernational 703-527-3887. and instructions on the product's most current Proc sika.com/ or by calling Sika's Technical Service Dep oligation to read and follow the warnings and instruct
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	LLING 201-933-8800.		

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**Product Data Sheet** Edition 2.3.2016 Sika<sup>®</sup> Liquid Weld

### Sika<sup>°</sup> Liquid Weld

### Concrete and Plaster Bonding Agent

Tensile Bond Strength (ACI 503R):

Shear Bond Strength (ASTM C881):

Freeze-Thaw Stability:

Description	Superior, reemulsifiable, liquid bonding agent for concrete, cement mortars and stucco.	
Where to Use	<ul> <li>Bond new concrete to new or old concrete</li> <li>Interior or Exterior use</li> <li>Vertical or Horizontal</li> <li>Use on concrete, concrete block, cement board, hardiboard, plywood, brick, plaster, tile, gypsum, or stone</li> </ul>	
Advantages	<ul> <li>Reemulsifiable or rewettable</li> <li>Extended open time</li> <li>Increased bond strength</li> <li>High build bonding agent</li> <li>Improved repair durability</li> </ul>	
Coverage	Unit yields approx. 150 - 300 sq.ft. per ga	llon depending upon actual porosity of the prepared substrate.
Packaging	1 x 2 gallon can; box	
How to Use Mixing	Prior to installation, stir SikaQuick Liquid	Weld before use for consistent dispersion. Apply Undiluted.
Surface Preparation	be done by high pressure water blast, scal surface with a minimum CSP 3 surface pr	grease, and all bond-inhibiting materials from surface. Preparation work should obler, or other appropriate mechanical means to obtain an aggregate-fractured ofile or greater. Ensure there are no curing compounds or other contaminants ation. Substrate must be dry before application.
Application	Be sure repair is not less than 1/2 inch in depth. Apply Liquid Weld uniformly over the substrate using a stiff brush, broom, roller or spray to form a continuous film. Reapply Liquid Weld that are not covered entirely. Allow film to dry for approximately 1 hour prior to application of mortars, concrete or stucco. Dry time can be affected by temperature and humidity, check to make sure product is dry to the touch before topping. Extremely porous substrates may require 2 coats of Liquid Weld. Protect newly applied Liquid Weld from dust, dirt, debris and moisture.	
	Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL METHODS, TEST METHODS, ACTUAL SITE CONDIT	VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION
	Shelf Life:	1 year in original, unopened containers
	Storage Conditions:	Store in cool, frost-free conditions with temperatures between 50°F
		to 90°F (10°C to 32°C).
	Product Conditioning:	Condition product to between 50°F to 90°F (10°C to 32°C).
	Drying Time:	1 Hour
	Colors:	Light Blue
	Viscosity:	1000 срѕ

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800 psi (7 days)

150 psi (7 days) - substrate failure (5,000 psi concrete)

5 cycles freeze (-10 deg F and thaw). Freeze-thaw stable.

Limitations

- Not for use in wet environments, including exterior horizontal substrates, in or around swimming pools, showers, decks, below grade or retaining walls that may be subject to hydrostatic pressures, side walks, or parking ramps.
- Do not dilute
- Do not apply onto water soluble substrates
  - Do not apply on frozen or frost covered substrates.
- Low temperatures or high humidity will extend curing time.
- Do not allow stored product to freeze

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Product Data Sheet Edition 8.15.2014 SikaRepair® 222

### SikaRepair<sup>®</sup> 222

One-component, early strength gaining, cementitious patching material

Description	SikaRepair <sup>®</sup> 222 is a one-component, early strength gaining, cementitious, patching material for horizontal repair of concrete.
Where to Use	<ul> <li>On grade, above and below grade on concrete and mortar.</li> <li>As a repair material for spalled horizontal concrete surfaces, walkways, ramps, steps, etc.</li> </ul>
Advantages	<ul> <li>Easy-to-use; just add water.</li> <li>Not a vapor barrier.</li> <li>Suitable for exterior and interior applications.</li> <li>Not flammable.</li> <li>Easily applied to clean, sound substrate.</li> <li>High early strengths.</li> </ul>
Coverage	Approximately 0.42 cu. ft. Approximately 0.62 cu. ft. (222+32 lbs. of 3/8" pea gravel).
Packaging	50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails

**Typical Data** (*Material and curing conditions* @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf life	One year in original, unopened bags.
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.
Color	Concrete gray
Mixing Ratio	gallon to gallon of liquid per 50 lb. bag
Application Time	Approximately 30 minutes
Finishing Time	50-120 minutes

**Note:** All times start after adding Component 'B' to Component 'A' and are highly affected by temperature, relative humidity, substrate temperature, wind, sun, and other jobsite conditions.

Compressive Strength (ASTM C109)		With undiluted Latex R
1 day	>2,000 psi (12.4 MPa)	2,300 psi (15.9 MPa)
7 days	4,000 psi (27.6 MPa)	4,500 psi (31.0 MPa)
28 days	5,000 psi (34.5 MPa)	5,500 psi
Flexural Strength (ASTM	C293)	
28 days	750 psi (5.2 MPa)	1,200 psi (8.2 MPa)
Splitting Tensile Strengt	h (ASTM C496)	
28 days	450 psi (3.1 MPa)	700 psi (4.8 MPa)
Bond Strength *(ASTM C	882 modified)	
28 days	2,000 psi (13.8 MPa)	2,000 psi (13.8 MPa)
* Mortar scrubbed into substrate	I	



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How to Use	
Surface Preparation	Surface Preparation Remove all deteriorated concrete, dirt, oil grease and all bond inhibiting materials from surface. Preparation work should be done by high pressure water blast, scabbler, or other appropriate mechanical means to obtain an exposed aggregate surface with a minimum surface profile of ±1/8 inch. (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during application.
	Priming
	For priming of reinforcing steel use Sika® Armatec® 110 EpoCem (consult Technical Data Sheet). Concrete Substrate: Prime the prepared substrate with a brush or sprayed applied coat of Sika® Armatec® 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of SikaRepair® 222 can be applied prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	With water: Wet down all tools and mixer to be used. Add approximately 3/4 gallon of water to mixing vessel. Slowly add 1 bag of SikaRepair <sup>®</sup> 222 while continuing to mix. Mechanically mix with a low-speed drill (400-600 rpm) and Sika paddle or in an appropriate size mortar mixer. Add an additiona 1/8 gallon of water if needed. With Latex R: Pour 3/4 gallon of SikaLatex <sup>®</sup> R into the mixing container. Slowly add powder, mix and adjust as above.
	With diluted Latex R: SikaLatex <sup>®</sup> R may be diluted up to 5:1 (water: Sika Latex R) for projects requir- ing minimal polymer-modification. Pour 3/4 gallon of the mixture into the mixing container. Slowly add powder, mix and adjust as above. SikaRepair <sup>®</sup> 222 Concrete: For applications greater than 1 inch depth, add a 3/8 inch coarse aggregate. Aggregate must be non-reactive (reference ASTMC1260, C227 and C289), clean, well-graded, saturated surface dry (SSD), have low absorption and high density, and comply with ASTM C33 size number 8 per Table 2. Addition rate must not exceed 32 lbs. of aggregate, bag of SikaRepair <sup>®</sup> 222 (32 lbs. of 3/8 in. aggregate is approximately 2.5 to 3.0 gal. by loose volume of aggregate). Water may be varied to achieve the desired consistency. Do not over water.
Application	The prepared mortar must be scrubbed into the substrate, filling all pores and voids. Force material against edge of repair, working toward center. After filling repair, consolidate, then screed. Allow mortar to set to desired stiffness, then finish. Mixing, placing and finishing should not exceed 45 minutes maximum.
Tooling & Finishing	Curing As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a water based, compatible curing compound. Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coatings. Moist curing should commence immediately after finishing. Protect freshly applied mortar from direct sunlight, wind, rain and frost.
Limitations	<ul> <li>Application thickness: (with water and diluted Latex R) Min. Max. inches one lift Neat 1/4 inch (6 mm) 1 inch (25 mm) Extended 1 inch (25 mm) 4 inches (100 mm)</li> <li>Application thickness: (with undiluted Latex R) Min. Max. inches one lift Neat 1/8 in (3 mm) 1 inch (25 mm) Extended 1 inch (25 mm) 4 inches (100 mm)</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>Addition of coarse aggregates may result in variations of the physical properties of the mortar.</li> <li>Use only potable water.</li> <li>Not intended for use as an overlay material.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> </ul>
INST SHEI PART TO R	R TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION EAD AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- F PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
For fur actual	NTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY. ther information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet
before Prior to Data SI ment a	using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Produc neet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructior h Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to
the cur Buyer's EXPRE SHALL THE US SALE	arrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties or rent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks s sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES SS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR E OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY 62 201-933-8800.
R Visit o	ur website at usa.sika.com 1-800-933-SIKA NATIONWIDE
Kegiol Si 20 Ly Pr	nal Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.         ka Corporation       Sika Canada Inc.         1/ Polito Avenue       601 Delmar Avenue         nohurst, NJ 07071       Pointe Claire         Quebec H9R 4A9       Phone: 514-697-2610         Fax: 514-694-2792       Phone: 52 442 2385800         Fax: 52 442 2250537       Sika Repair, and SikaLatex are registered trademarks. Printee in Canada.

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Product Data Sheet Edition 7.14.2014 SikaRepair 223

#### **SikaRepair**<sup>®</sup> **223** One component, early strength gaining, cementitious patching material

Description       SikaRepair 223 is a one-component, early strength gaining, cementitious, patching material for vertical and overhead repair of concrete.         Where to Use       • On grade, above, and below grade on concrete and mortar.         • As a repair material for vertical and overhead concrete surfaces.         Advantages       • Easy-to-use.         • Juitable for exterior and interior applications.         • Easily applied to clean, sound substrate.         • Increased freeze/thaw resistance.         • Not a vapor barrier.         • Not a vapor barrier.         • Not a fammable         Coverage       Approximately 0.41 cu. ft.         Packaging       SikaRepair 223 - 50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails         Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         Results ware upfere bases upfere bases upfere bases upfore basins.         SikaRepair 223 - 50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails         Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         Results ware upfere bases upfere bases upfore basins.         Siter day at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color       Concrete gray         Mixing Ratio       gallon of 1 gallon of liquid per 50 lb. bag         Application Time       Approximately 15 min. after				
<ul> <li>As a repair material for vertical and overhead concrete surfaces.</li> <li>Advantages</li> <li>Easy-to-use.</li> <li>Suitable for exterior and interior applications.</li> <li>Easily applied to clean, sound substrate.</li> <li>High early strengths.</li> <li>Increased abrasion resistance.</li> <li>Not a vapor barrier.</li> <li>Not a vapor barrier.</li> <li>Not fammable</li> <li>Coverage</li> <li>Approximately 0.41 cu. ft.</li> <li>Packaging</li> <li>Sika-Repair 223 - 50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails</li> <li>Typical Data (<i>Material and curing conditions @ 73°F (23°C) and 50% R.H.</i>)</li> <li>RESULTS MAY DIFER PASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND CURING CONDITIONS.</li> <li>Shelf Life</li> <li>One year in original, unopened bags.</li> <li>Storage Conditions</li> <li>Storage Conditions</li> <li>Storage Conditions</li> <li>Storage Conditions</li> <li>Goror Concrete gray</li> <li>Mixing Ratio</li> <li>gallon of 1 gallon of liquid per 50 lb. bag</li> <li>Application Time</li> <li>Application Time</li> <li>Application Time</li> <li>Application Time</li> <li>Stor (20 to 60 min after combining powder to Latex or Latex R. Application time is dependent on temperature and relative humidity.</li> <li>Finishing Time</li> <li>20 to 60 min after combining powder and liquid: depends on temperature relative humidity.</li> <li>Filexural Strength (ASTM C-382)</li> <li>gadays</li> <li>Stor (ASTM C-382)</li> <li>Stor (ASTM C-382)</li> <li>Soli (8.2 MPa)</li> <li>Splitting Tensile Strength (ASTM C-486)</li> <li>28 days</li> <li>Stor (3.8 MPa)</li> <li>Compressive Strength (ASTM C-496)</li> <li>28 days</li> <li>Stor (3.8 MPa)</li> <li>Apolo psi (22.8 MPa)</li> <li>Autor prior (3.8 MPa)</li> <li>Autor prior (3.8 MPa)</li> <li>Autor prior (3.8 MPa)</li> <li>Compres</li></ul>	Description			itious, patching material for verti-
<ul> <li>Suitable for exterior and interior applications.</li> <li>Easily applied to clean, sound substrate.</li> <li>High early strengths.</li> <li>Increased abrasion resistance.</li> <li>Not a vapor barrier.</li> <li>Not a vapor barrier.</li> <li>Not flammable</li> </ul> Coverage Approximately 0.41 cu. ft. Packaging SikaRepair 223 - 50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEFENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, SCTULA ISTE CONDITIONS. SAND CURING CONDITIONS. Shelf Life One year in original, unopened bags. Storage Conditions Store dry at 40°-96°F (4°-35°C). Condition material to 65°-75°F before using. Color Concrete gray Mixing Ratio gallon of 1 gallon of liquid per 50 lb. bag Application Time Approximately 15 min. after adding powder to Latex or Latex R. Application Time 20 to 60 min after combining powder and relative humidity. Finishing Time 20 to 60 min after combining powder and relative humidity. Finishing Tensile Strength (ASTM C-293) 28 days 550 pisi (5.9 MPa) Splitting Tensile Strength (ASTM C-496) 28 days 1,800 psi (12.4 MPa) Compressive Strength (ASTM C-496) 2 days 550 psi (3.8 MPa) Compressive Strength (ASTM C-496) 2 days 550 psi (20.7 MPa) 7 days 6,000 psi (41.4 MPa) Adolo psi (42.8 MPa) Adolo psi (42.8 MPa) Adolo psi (42.8 MPa) Coup si (42.8 MPa) Cou	Where to Use			
Packaging       SikaRepair 223 - 50 lb. multi-wall bag. SikaLatex R - 1 gal. plastic jug; 4/carton, 5 gal. pails         Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       One year in original, unopened bags.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color       Concrete gray         Mixing Ratio       gallon to 1 gallon of liquid per 50 lb. bag         Application Time       Approximately 15 min. after adding powder to Latex or Latex R. Application time is dependent on temperature and relative humidity.         Finishing Time       20 to 60 min after combining powder and liquid: depends on temperature, relative humidity, and type of finish desired         Flexural Strength (ASTM C-293)       with undiluted Latex R         28 days       550 psi (5.9 MPa)         Splitting Tensile Strength (ASTM C-496)       2,000 psi (4.8 MPa)         20 opsi (4.8 MPa)       2,000 psi (13.8 MPa)         Compressive Strength (ASTM C-109)       >4,000 psi (22.8 MPa)         2,000 psi (42.8 MPa)       >4,000 psi (42.8 MPa)	Advantages	<ul> <li>Easy-to-use.</li> <li>Suitable for exterior and interior applications.</li> <li>Easily applied to clean, sound substrate.</li> <li>High early strengths.</li> <li>Increased abrasion resistance.</li> <li>Increased freeze/thaw resistance.</li> <li>Not a vapor barrier.</li> </ul>		
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		1 day 7 day	>3,500 psi (20.7 MPa) 6,000 psi (41.4 MPa)	6,200 psi (42.8 MPa)

\*Mortar scrubbed into substrate



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Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibiting materials from surface. Be sure repair area is not less than 1/4 inch in depth. Preparation work should be done by scabbler or other appropriate mechanical means to obtain an exposed aggregate surface with a minimum surface profile of $\pm 1/8$ inch (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during application.
For priming of reinforcing steel use Sika Armatec 110 EpoCem (consult Technical Data Sheet).
<b>Concrete Substrate:</b> Prime the prepared substrate with a brush or sprayed applied coat of Sika Armatec 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of Sika Repair 223 can be applied prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
<b>With water:</b> Wet down all tools and mixer to be used. Add approximately 3/4 gallon of water to mixing vessel. Slowly add 1 bag of SikaRepair 223 while continuing to mix. Mechanically mix with a low-speed drill (400-600 rpm) and Sika paddle. 1/4 gallon of water may be added to achieve desired consistency. Do not over water. Maintain a mix temperature of 65°-75°F for maximum performance by using hot or cold water as needed.
With Latex R: Pour 3/4 gallon of SikaLatex R into the mixing container. Slowly add powder while continuing to mix mechanically as above. Add remaining SikaLatex R (up to 1/4 gallon) to adjust the desired consistency.
note: SikaLatex R must be protected from freezing. If frozen, discard.
With diluted Latex R: Sika Latex R may be diluted up to 5:1 (water:Sika Latex R) for projects requiring minimal polymer-modification. Pour 3/4 gallon of the mixture into the mixing container. Slowly add powder and mix as above. Add remaining diluted SikaLatex R (up to 1/4 gallon) to adjust the desired consistency.
At the time of application, surfaces should be saturated surface dry (SSD) with no standing water. Mortar must be scrubbed into the substrate, filling all pores and voids. Force material against edge of repair, working toward center. After filling repair, consolidate, then screed. Material may be applied in multiple lifts. The thickness of each lift not to be less than 1/2 inch minimum. Where multiple lifts are required score top surface of each lift to produce a roughened surface for next lift. Allow preceding lift to reach final set, 30 minutes minimum before applying fresh material. Saturate surface of the lift with clean water. Scrub fresh mortar into preceding lift. Allow mortar to set to desired stiffness, then finish with wood or sponge float for a smooth surface, or texture as required. For repairs greater than 1 inch in depth, the use of SikaRepair 222 extended with coarse aggregate, and appropriate formwork is also recommended.
<b>Important:</b> Maximum bond is achieved with application of a scrub coat on properly prepared, saturated surface dry (SSD) substrate.
<b>g</b> As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a water based compatible curing compound. Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coatings. Moist curing should commence immediately after finishing. Protect freshly applied mortar from direct sunlight, wind, rain and frost.
<ul> <li>Application thickness: (with water and diluted Latex R) Minimum ¼ inch (6 mm). Maximum in one lift 1.5 inch (38 mm).</li> <li>Application thickness: (with undiluted Latex R) Minimum ¼ inch (3 mm). Maximum in one lift 1.5 inch (38 mm).</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>Use only potable water.</li> <li>Do not use solvent-based curing compound.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>





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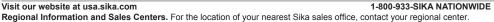
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Product Data Sheet Edition 7.15.2014 SikaRepair SHA

### **SikaRepair<sup>®</sup> SHA** Fast-setting, one component, cementitious repair mortar with superior high build properties

Description	SikaRepair SHA is a fast-setting, one-component, cementitious ready to use repair mortar. The incorporation of low density aggregates allows high build applications on vertical and overhead surfaces. SikaLatex R or SikaLatex may be used instead of water for a two component, polymer-modified repair mortar.		
Where to Use	<ul> <li>Fast repairs to overhead and vertical concrete and mortar surfaces on grade, above and below grade.</li> <li>As a repair material for building facades, parking structures, industrial plants, bridges, etc.</li> </ul>		
Advantages	<ul> <li>As a repair material for building facades, parking structures, industrial plants, bridges, etc.</li> <li>Minimal time required between lifts.</li> <li>Fast finishing time</li> <li>Time/labor-saving material; application up to 3 inches on vertical surfaces in one layer.</li> <li>Easy to use; just add water.</li> <li>High bond strength ensures excellent adhesion.</li> <li>Good, early and ultimate strength.</li> <li>Increased freeze/thaw durability and resistance to deicing salts.</li> <li>Easy to clean.</li> <li>Suitable for exterior and interior applications.</li> <li>Not a vapor barrier.</li> </ul>		
Coverage	0.55 cu. ft./bag		
Packaging	Sika Repair SHA: 25 lb. bag, 60/pallet; 50 lb. (22.7 kg.) multi-wall bag. SikaLatex (R): 1 gal. plastic jug; 4/carton, 5 gal. pails.		
	<b>Typical Data</b> (Material and curing conditions @ 73°F (23C) and 50% R.H.)		
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.		
	Shelf Life One year in original, unopened bags.		
	<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.		
	Color Concrete gray.		
	Mixing Ratio1 50 lb. bag SikaRepair SHA + 3/4 gal. to 1 gal. of liquid		
	Density (Wet mix) 106 lbs./cu. ft. (1.70 kg./l)		
	Application Time Approximately 10-15 minutes.		
	Finishing Time         20-30 minutes		
	Time Between Lifts Less than 1 hour		
	Compressive Strength (ASTM C-109)         with Latex R           1 day         2,000 psi (13.8MPa)         2,500 psi (17.2 MPa)           7 days         3,000 psi (20.7 MPa)         3,500 psi (24.1 MPa)           28 days         4,500 psi (31.0 MPa)         5,000 psi (34.5 MPa)		
	Strength (ASTM C-293)           28 days         800 psi (5.5 MPa)         1,100 psi (9.7 MPa)		
	Bond Strength * (ASTM C-882 modified		
	<b>28 days</b> 1,000 psi (6.8 MPa) 1, 800 psi (12.4 MPa) *Mortar scrubbed into substrate		
How to Use			
Substrate	Concrete, mortar, and masonry products.		



Construct

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Surface Preparation -	<ul> <li>Concrete/Mortar: Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibiting materials from surface. Preparation work should be done by high pressure water blast, scabbler or other appropriate mechanical means to obtain an exposed aggregate surface profile of ±1/16-in. (CSP-5). After preparation, substrate strength should be verified prior to patch placement. Substrate should be saturated surface dry (SSD) with no standing water during application.</li> <li>Reinforcing Steel: Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high pressure washed with clean water after mechanical cleaning. For priming of reinforcing steel use Sika Armatec 110 EpoCem (consult Technical Data Sheet).</li> <li>Concrete Substrate: Prime the prepared substrate with a brush or sprayed applied coat of Sika Armatec 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of Sika Repair SHA can be applied prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.</li> </ul>
Mixing	<ul> <li>With water: Pour 3/4 of one gallon of water into the mixing container. Add powder while mixing continuously. Mix mechanically with a low-speed drill (400-600 rpm) and mixing paddle or in an appropriate mortar mixer. Add more water to obtain desired consistency of the mortar. Do not exceed one gallon per bag. Mix to uniform consistency, maximum 3 minutes. Manual mixing can be tolerated only for less than a full unit. Thorough mixing and proper proportioning is necessary.</li> <li>With Latex R: Pour 3/4 gallon of Sika Latex R into the mixing container. Slowly add powder and mix as above.</li> <li>With diluted Latex R: Sika Latex R may be diluted up to 5:1 (water: Sika Latex R) for projects requiring minimal polymer-modification. Pour 3/4 gallon of the mixture into the mixing container. Slowly add powder and mix as above.</li> </ul>
	Note: SikaLatex R must be protected from freezing. If frozen, discard.
Application	The mixed SikaRepair SHA must be worked well into the primed substrate, filling all pores and voids. Compact well. Force material against edge of repair working towards the center. Thoroughly compact the mortar around exposed reinforcement. After filling repair, consolidate, then screed. Finish with steel, wood, plastic floats, or damp sponges, depending on the desired surface texture. Where multiple lifts are required, score top surface on each lift to produce a roughened substrate for next lift. Allow preceding lift to harden before applying fresh material. Saturate surface of the lift with clean water. If previous layers are over 48 hours old, mechanically prepare the substrate and dampen.
Tooling and Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a water based* compatible curing compound. Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coat- ings. Moist curing should commence immediately after finishing. Protect freshly applied mortar from direct sunlight, wind, rain and frost. * Pretesting of curing compound is recommended.
Limitations	<ul> <li>Application thickness: Minimum: With water: 1/4 inch (6 mm). With Latex R: 1/8" (3 mm). Maximum in one lift: 3 inches (75 mm) vertical, 1.5 inches (38 mm) overhead.</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>Do not use solvent based curing compounds. As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>

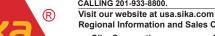
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Product Data Sheet Edition 7.15.2014 SikaRepair SHB

### SikaRepair<sup>®</sup> SHB

One component, cementitious repair mortar with superior high build properties that may be hand applied or wet-sprayed

Description	SikaRepair SHB is a one-component, cementitious ready to use repair mortar. It is a multi-purpose mor- tar which can be applied by trowel or low pressure wet spray process. The incorporation of low density aggregates allows high build applications on vertical and overhead surfaces. SikaLatex R or SikaLatex may be used instead of water for a two component, polymer-modified repair mortar.
Where to Use	<ul> <li>Fast repairs to overhead and vertical concrete on mortar surfaces on grade, above and below grade.</li> <li>As a repair material for building facades, parking structures, industrial plants, bridges, etc.</li> </ul>
Advantages	<ul> <li>Time/labor-saving material; application up to 3 inches on vertical surfaces in one layer.</li> <li>Application by hand or low pressure wet spray method.</li> <li>Easy to use; just add water.</li> <li>High bond strength ensures excellent adhesion.</li> <li>Good, early and ultimate strength.</li> <li>Increased freeze/thaw durability and resistance to deicing salts.</li> <li>Easy to clean.</li> <li>Suitable for exterior and interior applications.</li> <li>Not a vapor barrier.</li> </ul>
Coverage	0.55 cu. ft./bag
Packaging	Sika Repair SHB: 25 lb. bag, 60/pallet, 50 lb. (22.7 kg.) multi-wall bag.
	SikaLatex (R): 1 gal. plastic jug; 4/carton, 5 gal. pails.

#### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,
TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	One year in original, unopene	ed bags.	
•	Store dry at 40°-95°F (4°-35°0 before using.	C). Condition material to 65°-75°F	
Color	Concrete gray		
Mixing Ratio	1 50 lb. bag SikaRepair SHB	+ 3/4 to 1 gallon of liquid	
Density (Wet mix)	106 lbs./cu. ft. (1.70 kg./l.)		
Working Time	Approximately 30 minutes.		
Finishing Time	(Initial Set) 2-3 hours		
Compressive Strength 1 day 28 da	2,500 psi (17.2N	, , , , , , , , , , , , , , , , , , , ,	
Flexural Strength (AST 28 da	,	Pa) 1,400 psi (9.7 MPa)	
Bond Strength * (ASTM 28 da		/IPa) 1, 800 psi (12.4 MPa)	
*Mortar scrubbed into substrate			



Construction

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How to Use Substrate	Concrete, mortar, and masonry products.
Surface Preparation	<b>Concrete/Mortar:</b> Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibiting materials from surface. Preparation work should be done by high pressure water blast, scabbler or other appropriate mechanical means to obtain an exposed aggregate surface profile of $\pm 1/16$ -in. (CSP5) Substrate should be saturated surface dry (SSD) with no standing water during application. <b>Reinforcing Steel:</b> Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high pressure washed with clean water after mechanical cleaning.
Priming	For priming of reinforcing steel use Sika Armatec 110 EpoCem (consult Technical Data Sheet).
	<b>Concrete Substrate:</b> Prime the prepared substrate with a brush or sprayed applied coat of Sika Ar matec 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of Sika Repair SHB can be applied prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	<ul> <li>With water: Pour 3/4 of one gallon of water into the mixing container. Add powder while mixing continue ously. Mix mechanically with a low-speed drill (400-600 rpm) and mixing paddle or in an appropriate mortar mixer. Adjust water to desired consistency of the mortar. Do not exceed one gallon per bag Mix to uniform consistency, maximum 3 minutes. Manual mixing can be tolerated only for less than a full unit. Thorough mixing and proper proportioning is necessary.</li> <li>With Latex R: Pour 3/4 gallon of Sika Latex R into the mixing container. Slowly add powder, mix and adjust as above.</li> <li>With diluted Latex R: Sika Latex R may be diluted up to 5:1 (water: Sika Latex R) for projects requiring minimal polymer modification. Pour 3/4 gallon of the mixture into the mixing container. Slowly add powder, mix and adjust as above.</li> <li>Note: SikaLatex R must be protected from freezing. If frozen, discard.</li> </ul>
Application	SikaRepair SHB can be applied either by hand or wet spray process equipment. The mixed SikaRepair SHB must be worked well into the primed substrate, filling all pores and voids. Compact well. Force material against edge of repair working towards the center. Thoroughly compact the mortar around exposed reinforcement. After fillin repair, consolidate, then screed. Finish with steel, wood, plastic floats, or damp sponges, dependi g on the desired surface texture. Where multiple lifts are required score top surface on each lift to produce a roughened substrate for next lift. Allow preceding lift to harden before applying fresh material. Saturate surface of the lift with clean water. If previous layers are over 48 hours old, mechanically prepare the substrate and dampen.
	<b>Application by machine:</b> Apply SikaRepair SHB mortar by low or high pressure wet spray. Shoo SikaRepair SHB perpendicular to the surface. This minimizes rebound, creates the smoothest pattern (reduces 'bumps') and properly encases the rebars. The velocity of the material is sufficient if, at a distance of 18 to 24 in., the material pattern flattens out on contact with the surface and the rebars are encased. After applying the material, allow it to stiffen for about 10 minutes before removing bump, areas with a trowel. Before applying the next layer, allow the material to reach initial set. This will take anywhere from 45 minutes to several hours, depending on mix consistency, mix and ambient temperature, wind conditions and humidity. Begin and finish a given patch on the same da .
Tooling and Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with we burlap and polyethylene, a fine mist of water or a water based* compatible curing compound. Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coat ings. Moist curing should commence immediately after finishing. Protect freshly applied mortar from direct sunlight, wind, rain and frost.
	* Pretesting of curing compound is recommended.
Limitations	<ul> <li>Application thickness: Minimum: With water: 1/4 inch (6 mm). With Latex R: 1/8 inch (3 mm). Maximum in one lift: 3 inches (75 mm) vertical. 1.5 inches (38 mm) overhead.</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>Do not use solvent based curing compounds.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>



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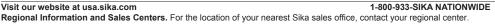
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Product Data Sheet Edition 7.15.2014 SikaTop 121 Plus

### SikaTop<sup>®</sup> 121 PLUS

## Two-component, polymer-modified, cementitious leveling/pore sealing mortar plus FerroGard 901 penetrating corrosion inhibitor

Description		corrosion inhibitor. Sika	veling and pore sealing mortar with the additiona Top 121 <i>PLUS</i> provides a smooth substrate, free gs.		
Where to Use	<ul> <li>As a leveling/pore sealing mortar prior to protective coatings.</li> <li>On horizontal, vertical and overhead surfaces, interior and exterior.</li> <li>On grade, above and below grade, on concrete and mortar substrates.</li> <li>Block filler.</li> <li>Minor repair for gouges and broken edges.</li> </ul>				
Advantages	<ul> <li>Excellent adhesion to concrete and mortar substrates.</li> <li>High flexural and compressive strengths</li> <li>Increased density - improved carbon dioxide resistance (carbonation) without adversely affecting water vapor transmission (not a vapor barrier).</li> <li>Increased freeze/thaw durability and resistance to deicing salts.</li> <li>Adds effective cover over rebars.</li> <li>Enhanced with FerroGard 901, a penetrating corrosion inhibitor - reduces corrosion even in the adjacent concrete.</li> <li>Compatible with coefficient of thermal expan ion of concrete - Passes ASTM C-884 (modified)</li> <li>Can be applied over Sika FerroGard 903, corrosion inhibiting impregnation.</li> <li>Not flammable</li> </ul>				
Coverage	0.4 cu. ft./unit; One unit covers approv ness	kimately 65 sq. ft. (6 m2	2) of smooth surface at 1/12 inch (2 mm) thick-		
Packaging	Component 'A' - 1 gal. plastic jug; 4/	carton. Component 'E	3' - 46.5 lb. multi-wall bag.		
	Typical Data (Material and curi	ng conditions @ 73°l	F (23°C) and 50% R.H.)		
	RESULTS MAY DIFFER BASED UPON STATIS		DING UPON MIXING METHODS AND EQUIPMENT,		
		original, unopened pag			
	Storage Conditions Store dry at		ondition material to 65°-75°F before using.		
	Color Concrete gr	ay when mixed.			
	Mixing Ratio Plant-proport	tioned kit. Mix entire u	nit.		
	Application Approximate	ely 45 min. after adding	Component 'B' to Component 'A'.		
	Time Application 1	ime is dependent on te	emperature and relative humidity.		
		<ul> <li>after combining comp d type of finish desired</li> </ul>	ponents; depends on temperature, relative		
	Flexural Strength (ASTM C-293)	<b>28 days</b> 2,000 p	si (13.8 MPa)		
	Splitting Tensile strength (ASTM (	, <b>.</b>	750 psi (5.2 MPa)		
	Bond Strength* (ASTM C-882 mod	•	2,000 psi (13.8 MPa)		
	Bond Strength Pull-Out Test (ACI failure	503R-30 modified	28 days 350 psi (2.4 MPa) substrate		
	Compressive         Strength (ASTM C-1           1 day         1,250 psi (8.6 MPa)           7 days         5,000 psi (34.5 MPa           28 days         6,000 psi (41.4 MPa	)			
	Permeability (AASHTO T-277)	28 days Approxima	tely 500 Coulombs		
	Corrosion Testing for FerroGard 9 Cracked Beam Corrosion Test Reduced corrosion rates 63% ver * Mortar scrubbed into substrate.	s:	s. ASTM G109 modified after 400 days		
ka®	INSTRUCTIONS ON THE PRODUCT'S MO WHICH ARE AVAILABLE ONLINE AT HTT AT 800-933-7452. NOTHING CONTAINED	ST CURRENT PRODUCT DA P://USA.SIKA.COM/ OR B D IN ANY SIKA MATERIAL RUCTION FOR EACH SIKA	ALWAYS READ AND FOLLOW THE WARNINGS AND TA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET Y CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT S RELIEVES THE USER OF THE OBLIGATION TO READ PRODUCT AS SET FORTH IN THE CURRENT PRODUCT O PRODUCT USE.		

How to Use	
Substrate	Concrete, mortar, and masonry products.
Surface Preparation	Remove all deteriorated concrete, dirt, oil, grease and all bond-inhibiting materials from the surface. Surface should be open-pore and textured (CSP-4). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during application.
Priming	For priming of reinforcing steel use Sika Armatec 110 EpoCem (consult Technical Data Sheet).
	<b>Concrete Substrate:</b> Prime the prepared substrate with a brush or sprayed applied coat of Sika Armatec 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of SikaTop 121 Plus can be applied prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	Pour approximately 4/5 of Component A into mixing container. Add Component B while continuing to mix. Mechanically mix with a low-speed drill (400-600 rpm) and paddle or appropriate-size mortar mixer. Mix to uniform consistency, maximum 3 minutes. Add remaining Component A to mix if a more loose consistency is desired. Manual mixing can be tolerated only for less than a full unit.
Application	SikaTop 121 PLUS can be applied by trowel, notched trowel, stiff bristle, or low pressure hopper gun. Work the material well into the prepared substrate, filling all pores and voids. As soon as the mortar layer starts to set, a uniform surface texture can be obtained by rubbing the surface with a fine sponge or a plastic trowel. Do not overwork SikaTop 121 PLUS during finishing and avoid the use of additional wate .
Tooling and Finishing	As per ACI recommendations for portland cement concrete, curing is required. Protect the freshly applied mortar against direct sunlight, wind, frost and rain. Curing compounds adversely affect the adhesion of protective coatings. Therefore, do not use a water based curing compound, if the leveling mortar is going to be over coated.
Limitations	<ul> <li>Application thickness: Minimum 1/12 inch (2 mm); Maximum 1/6 inch (4 mm)</li> <li>Minimum ambient and surface temperatures, 45°F (7°C) and rising at time of application.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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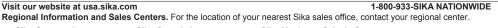
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Mexicana S.A. de C.v. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





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Product Data Sheet Edition 4.10.2015 SikaTop<sup>®</sup> 122 PLUS TESTED PER ICRI GUIDELINE FOR INORGANIC REPAIR MATERIAL DATA SHEET PROTOCOL GUIDELINE NO. 320.3R

#### **SikaTop® 122 PLUS** Two-component, polymer-modified, cementitious, trowel-grade mortar plus Sika FerroGard® 901 penetrating corrosion inhibitor

				penetidung		
Description	ał		for horizontal			st-setting, trowel-grade mortar. It is ditional benefit of Sika FerroGard®
Where to Use	<b>0</b>	n grade, above and below grad	e on concret	e and mortar.		
		n horizontal surfaces.		turne inductiel electe cuelle		- turnels down normal floods at
		s a structural repair material for   o level concrete surfaces.	parking struc	tures, industrial plants, walky	vays, bridge	s, tunnels, dams, ramps, floods, etc
		s an overlay system for topping	/resurfacing	concrete.		
Advantages	∎ E	xtremely low shrinkage proven	by four indu	ustry standard test method	ls.	
	■ H	ligh compressive and flexural st				
		ligh abrasion resistance. hcreased freeze/thaw durability a	and resistand	e to deicing salts		
		compatible with coefficient of the			TM C-884.	
			bon dioxide r	resistance (carbonation) with	out adverse	ly affecting water vapor transmis-
		ion (not a vapor barrier). ika FerroGard® 901, a penetrati	na corrosion	inhibitor - reduces corrosion	even in the	adiacent concrete.
	■ U	SDA certifiable for the food indu	ustry.			
	■ A	NSI/NSF Standard 61 potable v	vater complia	ant.		
Coverage	0.5	51 cu. ft./ unit mortar; 0.75 cu. ft	/unit concret	te; (mixed mortar + 42 lbs. 3	/8 pea grave	el)
Packaging	Co	omponent 'A' - 1-gal. plastic jug	j; 4/carton. <b>C</b>	component 'B' - 61.5-lb. mu	lti-wall bag.	
		RESULTS MAY DIFFER BASE	ED UPON STAT		DING UPON ME CONDITIO	IIXING METHODS AND EQUIPMENT, NS AND CURING CONDITIONS.
		Storage Conditions	-	at 40°-95°F. Condition mater		o°E before using Protect
		eterage eteratione	,	nt 'A' from freezing. If frozen		
		Color	Concrete	gray when mixed.		
		Mixing Ratio	Plant-prop	ortioned kit, mix entire unit.		
		Application Time	Approxima	ately 30 minutes.		
		Finishing Time	50-120 mi	nutes		
				nponent 'B' to Component 'A nperature, wind, sun and oth		ghly affected by temperature, onditions.
		Density (wet mix)		ASTM C 138		136 lbs./ft <sup>3</sup> (2.18 kg./l)
		Flexural Strength		ASTM C 293	28 days	1,500 psi
		Split Tensile Bond Strongth		ASTM C 496	28 days	500 psi
		Bond Strength Compressive Strength		ASTM C 882 (modified) ASTM C 109	28 days	2,000 psi
		compressive otrength		Aormio 103	1 day	2,500 psi
					7 days	5,300 psi
		Christens		ACTM C 457	28 days	7,000 psi
		Shrinkage		ASTM C 157 (mod. ICPI 320 3P)		
		Specimen Size 1"x1"x1	1-1///	(mod. ICRI 320.3R)	28 days	<0.05%
		Specimen Size 3"x3"x1			28 days	<0.021%
		Ring Test (days)	1-1/4	ASTM C 1581	20 uays	>70 days
		Ring Test - Average Max	Strain	ASTM C 1581		-9 µstrain
		Ring Test - Average Stres		ASTM C 1581		0.49 psi/day
		Ring Test - Potential for C	Cracking	ASTM C 1581		Low
		Baenzinger Block			90 days	No cracking
		Freeze/Thaw Durability (3	300 cycles)	ASTM C 666		98%
		CI Permeability		ASTM C 1202		<500 Coulombs.
		Direct Bond Strength		ASTM C 1583		
					7 days	400 psi
					28 days	>300 psi
		Modulus of Elasticity		ASTM C 531		3.00x10 <sup>6</sup> psi
		Lateral Content Theory (astro)		10711 0 000		40.70
		Initial Set Time (min)		ASTM C 266		40-70





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How to Use Substrates	Concrete, mortar, and masonry pro	oducts.			
Surface Preparation	Remove all deteriorated concrete, dirt, oil, grease and all bond inhibiting materials from surface. Be sure repair area is not less than 1/8 inch in depth. Preparation work should be done by high pressure water blast, scabbler, or other appropriat mechanical means to obtain an exposed aggregate surface with a minimum surface profile of ±1/16 inch (CSP-5); ±1/8 inc (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water durin application.				
	Where corrosion has occurred due	e to the presence of chloric	y prepared by mechanical cleaning to remove all traces of rus les, the steel should be high-pressure washed with clean wate se Sika® Armatec® 110 EpoCem (Consult Product Data Sheet		
		neet). Alternately, a scrub	e with a brush or sprayed applied coat of Sika® Armatec® 11 coat of SikaTop® 122 PLUS can be applied prior to placement et scrub coat before it dries.		
Mixing	Mix mechanically with a low-spee	d drill (400- 600 rpm) and sistency is desired. Mix to	tainer. Add Component 'B' (powder) while mixing continuousl mixing paddle or mortar mixer. Add remaining Component ', a uniform consistency, maximum 3 minutes. Thorough mixin y.		
	For SikaTop® 122 PLUS concrete: Pour all of Component 'A' into mixing container. Add all of Component 'B' while mixing then introduce 3/8 inch coarse aggregate at desired quantity. Mix to uniform consistency, maximum 3 minutes. Addition rat is 42 lbs. per bag (approx. 3.0 to 3.5 gal. by loose volume). The aggregate must be non-reactive (reference ASTM C 1260 C 227 and C 289), clean, well-graded, saturated surface dry, have low absorption and high density, and comply with ASTT C 33 size number 8 per Table 2. Note: Variances in the quality of the aggregate will affect the physical properties of SikaTop 122 PLUS. The yield is increased to 0.75 cu. ft./unit with the addition of the aggregate (42 lbs.). Do not use limestone aggregate.				
Application	SikaTop <sup>®</sup> 122 PLUS must be scrubbed into the substrate, filling all pores and voids. Force material against edge of repa working toward center. After filling repair, consolidate, then screed. Allow mortar or concrete to set to desired stiffness, the finish with wood or sponge float for a smooth surface, or broom or burlap-drag for a rough finish.				
Tooling & Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethyler a fine mist of water or a water based* compatible curing compound (ASTM C 309 compliant). Curing compounds advers affect the adhesion of following layers of mortar, leveling mortar or protective coatings. Moist curing should commence i mediately after finishing. Protect newly applied material from direct sunlight, wind, rain and frost. *Pretesting of curing compound is recommended.				
Limitations	Application thickness: Neat Extended	<b>Min.</b> 1/8 inch (3 mm) 1 inch (25 mm)	Max. in one lift 1 inch (25 mm) 4 inches (100 mm)		
	<ul> <li>ICRI. For additional information, c</li> <li>For additional information on sub Concrete Repair.</li> <li>If aggressive means of substrate 503 Appendix A prior to the repain</li> <li>As with all cement based materia</li> </ul>	ay result in variations of the compound. nust be carefully considered contact Technical Service. strate preparation, refer to preparation is employed, r application. Is, avoid contact with alum	5 11		

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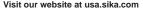
Corregidora, Querétaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Product Data Sheet Edition 4.10.2015 SikaTop® 123 PLUS TESTED PER ICRI GUIDELINE FOR INORGANIC REPAIR MATERIAL DATA SHEET PROTOCOL GUIDELINE NO. 320.3R

#### **SikaTop® 123 PLUS** Two-component, polymer-modified, cementitious, non-sag mortar plus Sika FerroGard® 901 penetrating corrosion inhibitor

Description	high	Top® 123 PLUS is a two-component, polymer-modified, Portland cement-based, fast-setting, non-sag mortar. It is a performance repair mortar for vertical and overhead surfaces and offers the additional benefit of Sika FerroGard® a penetrating corrosion inhibitor included in its formulation.					
Where to Use		grade, above and below grad					
		vertical and overhead surface					
		a structural repair material for			ways, bridg	es, tunnels,	dams and ramps.
		roved for repairs over cathoo	•				
Advantages		emely low shrinkage proven	•	stry standard test method	s.		
		n compressive and flexural st eased freeze/thaw durability	•	e to deicing salts			
		npatible with coefficient of the			FM C 884.		
	Increase	eased density - improved car	rbon dioxide r	esistance (carbonation) with	out adverse	ly affecting v	vater vapor transmis
		(not a vapor barrier).	004				4h
		anced with Sika FerroGard <sup>®</sup> DA certifiable for incidental fo		ating corrosion inhibitor - rec	luces corros	sion even in	the adjacent concre
		SI/NSF Standard 61 potable v		ed compliant.			
overage		cu. ft./ unit.					
ackaging	Com	ponent 'A' - 1-gal. plastic jug	a: 4/carton, C	omponent 'B' - 44-lb. multi-	wall bag.		
			3,				
		Typical Data (Material an	d curina cor	ditions @ 73°F (23°C) and	50% R H )		
				ISTICAL VARIATIONS DEPEND			ODS AND EQUIPMENT
		TEMPERATURE, APPLICATIO		TEST METHODS, ACTUAL SIT			
		Shelf Life	-	in original, unopened packag	-		
		Storage Conditions	,	at 40°-95°F. Condition mater		°F before us	sing. Protect
		Onlan		nt 'A' from freezing. If frozen,	discard.		
		Color		gray when mixed.			
		Mixing Ratio		ortioned kit, mix entire unit.			
		Application Time		ately 15 minutes.			
		Finishing Time	20-60 min				
			-	nponent 'B' to Component 'A			by temperature,
		Density (wet mix)	Substrate terr	perature, wind, sun and oth ASTM C 138	er job site o		<sup>3</sup> (2.2 kg./l)
		Flexural Strength		ASTM C 293	28 days	152 153./10	1,500 psi
		Split Tensile		ASTM C 496	28 days		900 psi
		Bond Strength		ASTM C 490 ASTM C 882 (modified)	28 days 28 days		
		Compressive Strength		ASTM C 109	20 uays		2,000 psi
		compressive strength		ASTMIC 105	1 day		3,000 psi
					7 days		4,000 psi
					28 days		6,000 psi
		Shrinkage		ASTM C 157			
				(mod. ICRI 320.3R)			
		Specimen Size 1x1x11-	·1/4"			28 days	0.05%
		Specimen Size 3x3x11-	-1/4"		28 days	0.038%	
		Ring Test (days)		ASTM C 1581		>70 days	
		Ring Test - Average Max	Strain	ASTM C 1581		-36 µstrair	ı
		Ring Test - Average Stres	ss Strain	ASTM C 1581		4.92 psi/da	ау
		Ring Test - Potential for	Cracking	ASTM C 1581		Low	
		Baenzinger Block			90 days	No crackir	ıg
		Freeze/Thaw Durability (	300 cycles)	ASTM C 666		98%	
		CI Permeability (coul)		ASTM C 1202		<500 Coul	ombs.
		Direct Bond Strength		ASTM C 1583	28 days	500 psi (s	ubstrate failure)
		Modulus of Elasticity		ASTM C 531		2.94 x 10 <sup>6</sup>	
		-				20-40	
		Initial Set Time (min)		ASTM C 266			
		Initial Set Time (min) Final Set Time (min)					
		Final Set Time (min)		ASTM C 266		<75	



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How to Use	
Substrates	Concrete, mortar, and masonry products.
Surface Preparation	Remove all deteriorated concrete, dirt, oil, grease and all bond inhibiting materials from surface. Be sure repair area is no less than 1/8 inch in depth. Preparation work should be done by high pressure water blast, scabbler, or other appropriate mechanical means to obtain an exposed aggregate surface with a minimum surface profile of ±1/16 inch (CSP-5). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during application.
	Reinforcing Steel: Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust Where corrosion has occurred due to the presence of chlorides, the steel should be high-pressure washed with clean wate after mechanical cleaning. For priming of reinforcing steel use Sika® Armatec® 110 EpoCem (consult Product Data Sheet)
	Priming Concrete Substrate: Prime the prepared substrate with a brush or sprayed applied coat of Sika® Armatec® 110 EpoCem (consult Product Data Sheet). Alternately, a scrub coat of SikaTop® 123 PLUS can be applied prior to placemen of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	Pour Component 'A' into mixing container. Add Component 'B' while mixing continuously. Mix mechanically with a low-speed drill (400 - 600 rpm) and mixing paddle or mortar mixer. Mix to a uniform consistency, maximum 3 minutes. Manual mixing can be tolerated only for less than a full unit. Thorough mixing and proper proportioning of the two components is necessary
Application	SikaTop <sup>®</sup> 123 PLUS must be scrubbed into the substrate, filling all pores and voids. Force material against edge of repair working toward center. After filling repair, consolidate, then screed. Material may be applied in multiple lifts. The thickness o each lift, not to be less than 1/8 inch minimum or more than 1.5 inches maximum. Where multiple lifts are required score top surface of each lift to produce a roughened surface for next lift. Allow preceding lift to reach initial set, 30 minutes minimum before applying fresh material. Saturate surface of the lift with clean water. Scrub fresh mortar into preceding lift. Allow morta or concrete to set to desired stiffness, then finish with wood or sponge float for a smooth surface.
Tooling & Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene a fine mist of water or a water based*, compatible curing compound (ASTM C 309 complaint). Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coatings. Moist curing should commence im mediately after finishing. If necessary protect newly applied material from direct sunlight, wind, rain and frost. *Pretesting of curing compound is recommended.
Limitations	<ul> <li>Application thickness: Minimum 1/8 inch (3 mm). Maximum in one lift - 1.5 in. (38 mm).</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>Do not use solvent-based curing compound.</li> <li>Size, shape and depth of repair must be carefully considered and consistent with practices recommended by ACI or ICRI For additional information, contact Technical Service.</li> <li>For additional information on substrate preparation, refer to ICRI Guideline No. 310.2R re: Polymer Overlays and Concrete Repair.</li> <li>If aggressive means of substrate preparation is employed, substrate strength should be tested in accordance with ACI 500 Appendix A prior to the repair application.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® 32, Hi-Mod.</li> </ul>

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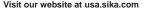
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Fracc. Industrial Balvanera Corregidora, Querétaro

Phone: 52 442 2385800 Fax: 52 442 2250537



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### SikaQuick<sup>®</sup> 1000 Rapid hardening repair mortar with extended working time

apid hardening, early strength gaining, cementitious, patching material
grade on concrete.
ete roadways, parking structures, bridges, dams and ramps.
norizontal repairs of concrete and mortar.
pplications when extended working time is required.
TM C-928.
early as 6 hrs. On site testing is recommended for verification. Please recommendations.
ehicle traffic in 6 hours (at 73°F).
strate.
g conditions @ 73°F (23°C) and 50% R.H.) (Water/powder = 0.10)
ISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
iginal, unopened bag.
t 40°-95°F (4°-35°C). For best results, condition material to
efore using.
ray.
tely 4.5 - 5 pints of liquid per 50 lb. bag. tely 30 minutes after adding powder to the water.
Mortar - ASTM C-109
1,250 psi (8.6 MPa)
4,000 psi (27.6 MPa)
5,000 psi (34.5 MPa)
7,000 psi (48.2 MPa) <b>8)</b>
700 psi (4.8 MPa)
900 psi (6.2 MPa)
1,000 psi (6.9 MPa)
<b>STM C-496)</b> 300 psi (2.0 MPa)
400 psi (2.7 MPa)
500 psi (3.4 MPa)
) modified
1750 psi (12.0 MPa) 2000 psi (13.8 MPa)
2500 psi (17.2 MPa)
a) 28 days 300 psi (substrate failure)
<b>6) 28 days</b> 0.06
<b>C-469) 28 days</b> 4.6 x 10 <sup>6</sup>
s (ASTM C-1202) 28 days < 1000
M C-666) 28 days 98%
C-672) 50 cycles 0.080
40-90
60-120
Vear at 1 hr. (ASTM C-779) 28 days 0.026
<sup>st.</sup> JCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AF

PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



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Coverage	Approximately 0.42 cu. ft. When extended with 25 lbs. of 3/8 in. gravel yield is approximately 0.58 cu. ft.
Packaging	50 lb. multi-wall bag.
How to Use	50 ib. mulu-wali bay.
Surface Preparation	Surface must be clean and sound. Remove all deteriorated concrete, dirt, oil, grease, and other bond-inhibiting materials from the area to be repaired. Be sure repair area is not less than 1/4 in. deep. Preparation work should be done by appropriate means. Obtain an exposed aggregate surface with a minimum surface profile of $\pm$ 1/8 in. (CSP-6) on clean, sound concrete. To ensure optimum repair results, the effectiveness of decontamination and preparation should be assessed by a pull-off test. Saw cutting of edges is preferred and a dovetail is recommended. Saturate surface to be repaired with clean water. Substrate should be saturated surface dry (SSD) prior to application.
Priming	For priming of reinforcing steel use Sika <sup>®</sup> Armatec <sup>®</sup> 110 EpoCem (consult Technical Data Sheet). Concrete Substrate: Prime the prepared substrate with a scrub coat of SikaQuick <sup>®</sup> 1000 prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	<ul> <li>Mechanically mix in an appropriately sized mortar mixer. Wet down all tools and mixer to be used.</li> <li>With water: Start with 4.5 pints of water added to the mixing vessel. Add 1 bag of SikaQuick<sup>®</sup> 1000 while continuing to mix. Add up to another 1/2 pint of water to achieve desired consistency. Do not over-water.</li> <li>With Latex R: Pour 4.5 pints of SikaLatex<sup>®</sup> R into the mixing container. Slowly add powder, mix and adjust as above.</li> <li>With diluted Latex R: SikaLatex<sup>®</sup> R may be diluted up to 5:1 (water: SikaLatex<sup>®</sup> R) for projects requiring minimal polymer modification. Pour 4.5 pints of the mixture into the mixing container. Slowly add powder, mix and adjust as above. For applications greater than 1 in. in depth, add 3/8 in. coarse aggregate. The aggregate must be non-reactive (reference ASTM C-1260, C-227 and C-289), clean, well graded, saturated surface dry, have low absorption and high density, and comply with ASTM C-33 size number 8 per Table 2.</li> <li>Note: Variances in aggregate may result in different strengths. The addition rate is 25 lbs. of aggregate per bag of SikaQuick<sup>®</sup>1000. (25 lbs. of 3/8 in. aggregate is approximately 2.0 gallons by loose volume of aggregate). Do not exceed a slump of 7 in. This may cause excessive bleeding and retardation and will reduce the strength and performance of the material.</li> </ul>
Application	The prepared mortar must be scrubbed into substrate. Be sure to fill all pores and voids. Force material against edge of repair, working toward center. After filling repair, screed off excess. Allow concrete to set to desired stiffness, then finish. If a smoother finish is desired, a magnesium float should be used. Mixing, placing, and finishing should not exceed 30 minutes maximum. To control setting times, cold water should be used in hot weather and hot water used in cold weather.
Tooling & Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a curing compound meeting ASTM C-309. Moist cure should commence immediately after finishing. If necessary, protect newly applied material from rain. To prevent from freezing, cover with insulating material.
Limitations	<ul> <li>Minimum ambient and surface temperatures 45°F and rising.</li> <li>Minimum application thickness 1/4 in. as a mortar and 1 in. extended with aggregate.</li> <li>Maximum application thickness 1 in. as a mortar and 6 in. extended with aggregate.</li> <li>Do not feather edge.</li> <li>Do not exceed 7 in. slump when extended.</li> <li>Use only potable water.</li> <li>Variations in aggregates may produce differences in strengths from the typical values stated in Sika's Technical Data.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> <li>Do not use Sika® Armatec® 110 EpoCem as a bonding agent with SikaQuick® 1000.</li> </ul>

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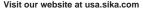
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> Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue

Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Product Data Sheet Edition 2.18.2015 SikaQuick® 2500

### **SikaQuick® 2500** Very rapid hardening, repair mortar

Description	SikaQuick <sup>®</sup> 2500 is a 1-component, very rapid hardening, early strength gaining, cementitious, patching material for concrete.
Where to Use	<ul> <li>Use on grade, above, and below grade on concrete.</li> <li>Highway overlays and repairs.</li> <li>Structural repair material for concrete roadways, parking structures, bridges, dams and ramps.</li> <li>Full depth patching repairs.</li> <li>Economical patching material for horizontal repairs of concrete and mortar.</li> </ul>
Advantages	<ul> <li>Very rapid hardening as defined by ASTM C-928.</li> <li>Epoxy coatings can be applied as early as 4 hrs. On site testing is recommended for verification. Please consult coatings manufacturer for recommendations.</li> <li>Freeze/thaw resistant.</li> <li>Easy to use, labor-saving material.</li> <li>Not gypsum-based.</li> <li>High early strength.</li> <li>Fast-setting.</li> <li>Open to foot traffic in 45 minutes; to vehicle traffic in 1 hour (at 73°F).</li> <li>Easily applied to clean, sound substrate.</li> <li>Not a vapor barrier.</li> </ul>
	<b>Typical Data</b> (Material and curing conditions @ 73° F (23° C) and 50% R.H.) (Water/powder = 0.12)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life         1 year in original, unopened bag.
	<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C). For best results, condition material to 65°- 75°F before using.
	Color Concrete gray.
	Mixing Ratio Approximately 5 - 5.5 pints of liquid per 50 lb. bag.
	Application Life Approximately 15 minutes after adding powder to the water.
	Compressive Strength, psi Mortar - ASTM C-109
	<b>1 hour</b> **2,500 psi (17.2 MPa)
	2 hours **4,000 psi (27.6 MPa)
	1 day **5,700 psi (39.3 MPa) 7 days 7,500 psi (51.7 MPa)
	<b>28 days</b> **8,500 psi (58.6 MPa)
	Flexural Strength, psi (ASTM C-78)
	<b>1 day</b> 800 psi (5.5 MPa)
	7 days 1,000 psi (6.9 MPa)
	28 days **1,100 psi (7.6 MPa)
	Splitting Tensile Strength, psi (ASTM C-496) 1 day 300 psi (2.0 MPa)
	<b>7 days</b> 500 psi (3.4 MPa)
	<b>28 days</b> 600 psi (4.1 MPa)
	Bond Strength, psi (ASTM C-882) modified
	1 day **1,800 psi (12.4 MPa) 7 days 2,500 psi (17.2 MPa)
	<b>28 days</b> **2,700 psi (17.2 lin a)
	Direct Tensile Bond, psi (ACI 503) 28 days 300 psi (substrate failure)
	Drying Shrinkage, % (ASTM C-596) 28 days **0.06
	Modulus of Elasticity, psi (ASTM C-469) 28 days 4.6 x 10 <sup>6</sup>
	Chloride Permeability, Coulombs (ASTM C-1202) 28 days < 500
	Freeze/Thaw Resistance, % (ASTM C-666) 28 days **98%
	Scaling Resistance, Ib./ft <sup>2</sup> (ASTM C-672) 50 cycles 0.080
	Initial Set, minutes (ASTM C-266) 12-24
	Final Set, minutes (ASTM C-266) 20-40
	Abrasion Resistance, inches of wear at 1 hr. (ASTM C-779) 28 days 0.026
R	*Independent certificates available upon request.



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Coverage	Approximately 0.43 cu. ft. When extended with 25-30 lbs. of 3/8 in. gravel yield is approximately 0.60 cu. ft.
Packaging	50-lb. multi-wall bag.
How to Use	
Surface Preparation	Surface must be clean and sound. Remove all deteriorated concrete, dirt, oil, grease, and other bond-inhibiting materials from the area to be repaired. Be sure repair area is not less than 1/4 in. deep. Preparation work should be done by appropriate means. Obtain an exposed aggregate surface with a minimum surface profile of $\pm$ 1/8 in. (CSP-6) on clean, sound concrete. To ensure optimum repair results, the effectiveness of decontamination and preparation should be assessed by a pull-off test. Saw cutting of edges is recommended. Saturate surface to be repaired with clean water. Substrate should be saturated surface dry (SSD) prior to application.
Priming	For priming of reinforcing steel use Sika <sup>®</sup> Armatec <sup>®</sup> 110 EpoCem (consult Technical Data Sheet). Concrete Substrate: Prime the prepared substrate with a scrub coat of SikaQuick 2500 prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it dries.
Mixing	Mechanically mix in an appropriately sized mortar mixer. Wet down all tools and mixer to be used.
	With water: Start with 5 pints of water added to the mixing vessel. Add 1 bag of SikaQuick <sup>®</sup> 2500 while continuing to mix. Add up to another 1/2 pint of water to achieve desired consistency. Do not over water.
	With Latex R: Pour 5 pints of SikaLatex® R into the mixing container. Slowly add powder, mix and adjust as above.
	With diluted Latex R: SikaLatex <sup>®</sup> R may be diluted up to 5:1 (water: SikaLatex <sup>®</sup> R) for projects requiring minimal polymer modification. Pour 5 pints of the mixture into the mixing container. Slowly add powder, mix and adjust as above. For applications greater than 1 in. in depth, add 3/8 in. coarse aggregate. The aggregate must be non-reactive (reference ASTM C-1260, C-227 and C-289), clean, well graded, saturated surface dry, have low absorption and high density, and comply with ASTM C-33 size number 8 per Table 2.
	<b>Note:</b> Variances in aggregate may result in different strengths. The addition rate is 25-30 lbs. of aggregate per bag of SikaQuick <sup>®</sup> 2500. (25-30 lbs. of 3/8 in. aggregate is approximately 2.0 - 2.4 gallons by loose volume of aggregate). Do not exceed a slump of 7 in. This may cause excessive bleeding and retardation and will reduce the strength and performance of the material.
Application	The prepared mortar must be scrubbed into substrate. Be sure to fill all pores and voids. Force material against edge of repair, working toward center. After filling repair, screed off excess. Allow concrete to set to desired stiffness, then finish. If a smoother finish is desired, a magnesium float should be used. Mixing, placing, and finishing should not exceed 15 minutes maximum. To control setting times, cold water should be used in hot weather and hot water used in cold weather.
Tooling & Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a curing compound meeting ASTM C-309. Moist cure should commence immediately after finishing. If necessary, protect newly applied material from rain. To prevent from freezing, cover with insulating material.
Limitations	<ul> <li>Minimum ambient and surface temperatures 45°F and rising.</li> <li>Minimum application thickness 1/4 in. as a mortar and 1 in. extended with aggregate.</li> <li>Maximum application thickness 1 in. as a mortar and 6 in. extended with aggregate.</li> <li>Do not feather edge.</li> <li>Do not exceed 7 in. slump when extended.</li> <li>Use only potable water.</li> <li>Variations in aggregates may produce differences in strengths from the typical values stated in Sika's Technical Data.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur<sup>®</sup> Hi-Mod 32.</li> <li>Do not use Sika<sup>®</sup> Armatec<sup>®</sup> 110 EpoCem as a bonding agent with SikaQuick<sup>®</sup> 2500.</li> <li>When extended : Minimum application is 1 inches, Max application 6 inches.</li> </ul>

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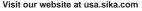
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452

Fax: 201-933-6225

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RESPONSIBLE CARE



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Product Data Sheet Edition 1.29.2015 SikaQuick® VOH

## SikaQuick<sup>®</sup> VOH

Fast Setting, one component, cementitious vertical and overhead repair mortar with superior high build properties

Description	SikaQuick <sup>®</sup> VOH is a fast overhead applications usir				to-use repair m	ortar for vertical and	
Where to Use					ures, industrial		
Advantages	<ul> <li>Minimal time required be</li> <li>Fast finishing time</li> <li>Time/labor-saving mater</li> <li>Easy to use; just add wa</li> <li>High bond strength ensu</li> <li>High early and ultimate</li> <li>Increased freeze/thaw de</li> <li>Suitable for exterior and</li> <li>Not a vapor barrier</li> <li>Overhead thickness up</li> <li>Fiber reinforced and pol</li> <li>Contains corrosion inhite</li> </ul>	rial; aj ater ures e strenç lurabil l interi to 2" lymer	oplication up excellent adhe oth lity and resist or applicatior	esion ance to deici		ces in one layer	
Coverage	~.44 cu. ft.						
Packaging	Storage Conditions:StoreProduct Conditioning:CondColor:ConcMixing Ratio:6 - 6.Density (Wet mix):~ 125Application Time:ApproFinishing Time:20-30Lift Height:Max:	CAL VA ODS, AG PINTS year in a dry at lition m crete gra 5 pints/ 5 lbs. / ( oximate 0 minute 3" final se	RIATIONS DEPEN CTUAL SITE CON VUNIT. original, unoper 40°-95°F (4°-35 aterial to 65°-75 ay. /unit cu. ft. ely 20 minutes. es Min: 1/8"	DING UPON MIXIN DITIONS AND CUI	RING CONDITIONS.		
	Compressive Strength, psi (ASTM C-10	09):	<b>3 hrs</b> >2000	<b>1 day</b> >3000	<b>7 days</b> >4500	<b>28 days</b> 5500	
	Flexural Strength, psi (ASTM C-293):			<b>1 day</b> 400	<b>7 days</b> 600	<b>28 days</b> 1000	
	Bond Strength*, psi (ASTM C-882 mod Modulus of Elasticity, psi (ASTM C-469	-		<b>1 day</b> 1000	<b>7 days</b> 1600 <b>7 days</b>	<b>28 days</b> 2000	
	Rapid Chloride Permeability (ASTM C1	202)		Low Range	>2.2 x 10^6 Low Range		
	Bond Strength, psi - Direct Tensile (IR Shrinkage (50% R.H.) (ASTM C-157; IC Initial Set, min. (ASTM C-266)			Substrate f <.05% 20-25 20.40	ailure >250		

Final Set, min. (ASTM C-266) \*Mortar scrubbed into substrate

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PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

30-40

How to Use Surface Preparation	<b>Concrete/Mortar:</b> Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibitin materials from surface. Preparation work should be done by high pressure water blast, scat bler or other appropriate mechanical means to obtain an exposed aggregate surface profil of +- 1/16 in. (CSP-5). After preparation, substrate strength should be verified prior to patc placement. Substrate should be saturated surface dry (SSD) with no standing water durin application. <b>Reinforcing Steel:</b> Steel reinforcement should be thoroughly prepared by mechanical cleanin to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides
Priming:	the steel should be high pressure washed with clean water after mechanical cleaning. <b>Reinforcement Steel:</b> For priming of reinforcement steel use Sika <sup>®</sup> Armatec <sup>®</sup> 110 EpoCer
Frinning.	(Consult Technical Data Sheet).
	<b>Concrete Substrate:</b> A scrub coat of SikaQuick <sup>®</sup> VOH should be applied prior to placement of mortar. The repair mortar has to be applied into the wet scrub coat before it dries. The us of Sika <sup>®</sup> Armatec <sup>®</sup> 110 EpoCem as a bonding agent for concrete is not recommended.
Mixing	Wet down all tools and mixer to be used. Mix mechanically with a low-speed drill (400 - 60 rpm) and mixing paddle or mortar mixer. Mix to a uniform consistency, maximum 3 minutes Manual mixing can be tolerated only for less than a full unit. Thorough mixing and proper proportioning of the powder and liquid is necessary. Inaccurate proportioning of the powder to liquid will result in a finished product that may not conform with stated properties.
	<b>With water:</b> Start mixing with 6 pints of water per 44 lb. bag. Adjust the water dosage b a maximum amount of +/- 1/2 pint, if necessary, to achieve the desired consistency. Do no over-water. Over-watering may result in difficulty handling and/or not meeting stated propert values.
	With Latex R: Start mixing with 6 pints of SikaLatex® R per 44 lb. bag. Adjust the SikaLatex® I dosage by a maximum amount of +/- 1/2 pint, if necessary, to achieve the desired consistency
Application	The mixed SikaQuick <sup>®</sup> VOH must be worked well into the prepared substrate, filling all pore and voids. Compact well. Force material against edge of repair working towards the center Thoroughly compact the mortar around exposed reinforcement. After filling repair, consolidate then screed. Finish with steel, magnesium, wood, plastic floats, or damp sponges, dependin on the desired surface texture. Where multiple lifts are required, score top surface on each li to produce a roughened substrate for next lift. Allow preceding lift to harden before applyin fresh material. Saturate surface of the lift with clean water. If previous layers are over 6 hour old, mechanically prepare the substrate and dampen.
Tooling and Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure wit wet burlap and polyethylene, a fine mist of water or a water based* compatible curing compound Curing compounds adversely affect the adhesion of following lifts of mortar, leveling mortar or protective coatings. Moist curing should commence immediately after finishing. Protect freshl applied mortar from direct sunlight, wind, rain and frost. * Pretesting of curing compound is recommended.
Removal	Cured product must be removed mechanically.
Over Painting	Acrylic waterbased systems - 4 hrs Epoxy/PU based systems - 6 hrs Compatibility and adhesion testing is always recommended.
Limitations	<ul> <li>Application thickness: Minimum: With water: 1/8 inch (3 mm). Maximum in one lift: 3 inches (75 mm) vertical, 2 inches (51 mm) overhead.</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>To control setting times, cold water should be used in hot weather and hot water used in cold weather.</li> <li>Do not use solvent based curing compounds. As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur<sup>®</sup> Hi-Mod 32.</li> <li>Remixing product after it begins to set is prohibited.</li> <li>Do not use Sika<sup>®</sup> Armatec<sup>®</sup> 110 EpoCem as a bonding agent with SikaQuick<sup>®</sup> VOH.</li> </ul>





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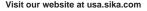
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

 Sika Corporation
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# SikaQuick<sup>®</sup> Smooth Finish

Light Weight Mortar for Concrete Reprofiling and Patching

Description		s a fast setting, one component, durable, sand free mortar for repairing and reprofiling vertical faces to acheive a smooth finish.			
Where to Use	<ul> <li>Tilt up panels</li> <li>Pre Cast Concrete</li> <li>Cast in Place Concrete</li> <li>Concrete Block</li> <li>Masonry</li> </ul>				
Advantages	<ul> <li>Minimal time required between lifts.</li> <li>Ultra smooth consistency; Easy to apply</li> <li>Fast finishing time, sanded and painted same day</li> <li>Time/labor-saving material; application up to 1/2" inch on vertical surfaces in one layer</li> <li>Easy to use; just add water</li> <li>High bond strength ensures excellent adhesion</li> <li>Suitable for interior and exterior applications</li> <li>Precast grey color</li> </ul>				
Coverage	50 lb bag yields approxima	tely 115 sq.ft. at 1/16"			
Packaging	50 lb (22.7 kg) bag				
	RESULTS MAY DIFFER BASED UP APPLICATION METHODS, TEST M Shelf Life Storage Conditions Product Conditioning Color Mixing Ratio Application Time Finishing Time Lift Height Time Between Lifts Compressive Strength (A	A and curing conditions @ 73°F (23°C) and 50% R.H.) ON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, ETHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened bags. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. Concrete gray 8.5-9.5 quarts/unit (up to 2:1 POWDER:WATER) Approximately 30 minutes. 1 hour Max: 1/2" After final set STM C-109), psi 24 hours 1000 psi 28 days >2000 psi ct Tensile (IRCI No. 210.3): Substrate failure >250			



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How to Use	
Surface Preparation	Concrete/Mortar: Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibiting materials from surface. After preparation, substrate strength should be verified prior to patch placement. Substrate should be dry or saturated surface dry (SSD) with no standing water during application.
Mixing	Wet down all tools and mixer to be used. Mix mechanically with a low-speed drill (400 - 600 rpm) and mixing paddle or by hand. Mix to a uniform consistency, maximum 3 minutes. Manual mixing can be tolerated only for less than a full unit. Thorough mixing and proper proportioning of the powder and liquid is necessary. Inaccurate proportioning of the powder to liquid will result in a finished product that may not conform with stated properties.
	Start mixing with 8 - 9 quarts of water per 50 lb. bag. DO NOT EXCEED 9 qts. Adjust the water dosage, if necessary, to achieve the desired consistency. DO NOT OVER WATER. Over-watering may result in difficulty handling and/or not meet- ing stated property values. Do not retemper. Clean bucket and mixing equipment in between batches.
Application	SikaQuick® Smooth Finish should be applied in one pass in thicknesses ranging from a true feather edge to 1/2" in depth. Typical working time of the product is 1 hour at 73 deg F. Working time will vary depending on application temperature. In high temperature work environments, cold water should be used to to increase working time. Over Paint: Can be overcoated same day.
Tooling and Finishing	Once material is in place, as the material hardens, use a trowel to shave or cut the excess material to the desired shape. Material can be sanded and painted the same day.
Limitations	<ul> <li>Not to be applied in lifts over 1/2". If multiple lifts are required, score top surface on each lift to produce a roughened substrate for next lift. Allow preceding lift to harden before applying fresh material. Saturate surface of the lift with clean water.</li> <li>Do not apply on gypsum substrates</li> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application.</li> <li>To control setting times, cold water should be used in hot weather and hot water used in cold weather.</li> <li>Do not use solvent based curing compounds. As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> <li>Remixing product after it begins to set is prohibited.</li> <li>Do not use Sika* Armatec* 110 EpoCem as a bonding agent with SikaQuick® Smooth Finish.</li> </ul>

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 8.7.14 Sikacrete<sup>®</sup> 321 FS

# Sikacrete® 321 FS

One-component, cementitious, pourable, rapid hardening concrete mix

Description	Sikacrete <sup>®</sup> 321 FS is a one-component, portland-cement concrete containing factory blender coarse aggregate designed for quick turnaround patching and overlay needs.
Where to Use	<ul> <li>As a structural repair material for bridges, parking facilities, industrial plants and walkways</li> <li>On horizontal, vertical and overhead surfaces (formed)</li> <li>On grade, above, and below grade on concrete</li> <li>Full depth repairs</li> <li>Filler for voids and cavities</li> </ul>
Advantages	<ul> <li>Complies with ASTM C-928 specifications for very rapid and rapid hardening mortars</li> <li>Very rapid setting structures can be opened to vehicular traffic in 2 hours</li> <li>Non-gypsum based with volume stability</li> <li>Compatible with coefficient of thermal expansion of concrete</li> <li>Increased resistance to deicing salts</li> <li>Easily applied to clean, sound substrate</li> <li>Not a vapor barrier</li> <li>Excellent resistance to freeze/thaw with outstanding durability</li> <li>Pre-packaged coarse aggregate: Eliminates need to extend material in the field; Eliminates the risk of reactive aggregate</li> <li>Formulated to compensate for shrinkage</li> </ul>
Coverage	Approximately 0.50 ft. <sup>3</sup> /unit. Actual yield on site may vary due to surface profile, waste, and other factors.
Packaging	65 lb. multi-wall bag; bulk bag available on request

### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life Storage Conditions	1 year in original, u Store dry at 40°-95° before using.		kaging. Condition material to 65°-75°F
Mixing Ratio	Mix with clean potal	ble water at i	rate of up to 5 pints per bag.
Application Time	Approximately 30 m Initial Slump 7-9"	ninutes	
	Slump at 15 minute	s >5-7"	
Initial Set	40-50 minutes		
Final Set	50-60 minutes		
Flexural Strength (AS	TM C-78)	28 days	700 psi (5.0 MPa)
Splitting Tensile Strength (ASTM C-496)		1 day 7 days	400 psi (2.8 MPa) 600 psi (4.1 MPa)
Bond Strength* (ASTM C-882 modified)		1 day 7 days	2,500 psi (17.2 MPa) 3,000 psi (20.7 MPa)
Direct Tensile Bond (A	ACI 503)	7 days 7 days	>250 psi
<b>Compressive Strengt</b>	h (ASTM C-39)	2 hour	2,500 psi (17.2 MPa)



					1 day 7 days 28 days	5,000 psi (4 6,000 psi (4 7,500 psi (4	34.5 MP 41.4 MP	a) a)
	Fi		actor (ASTM C-6	-	300 cycles	<0.06% >90%		
		hloride ion p	ermeability (AST	M C-1202)	28 days	<1,500	Coulor	nbs
How to Use								
Surface Prepar	surface pressu surface should	e. Be sure repa re water blast, e with a minimu be saturated s	all deteriorated con air area is not less t scabbler, or other a m surface profile of urface dry (SSD) wi	han 1 in. in de opropriate mecl ±1/8 in. (CSP-7 th no standing	pth. Preparat hanical mean 7). Saturate si water during	ion work shou s to obtain an urface with cle application.	ild be doi exposed an water.	ne by higl aggregate Substrate
	all trac	es of rust. Whe	eel reinforcement sh ere corrosion has o d with clean water a	ccurred due to	the presence		-	
Mixing	a unifo paddle	rm consistency	in mixing container. y, maximum 3 minut ate-size mortar mixe d slump.	es. Mechanicall	ly mix with a l	ow-speed drill	(400-600	) rpm) an
Application	is achi	eved. To accom	cations: Pre-wet sumplish this, material such as vibration of	should be scrub	bed into the	substrate or of		
Tooling & Finis	hing Finish	as desired						
	wet buing con coating direct	rlap and polyet npounds adver gs. Moist curing sunlight, wind, u	ecommendations for hylene, a fine mist of sely affect the adhe should commence rain and frost. For b ial set. A Hudson Sp	of water or a wa sion of followin mmediately aft est results, kee	ater based* c g layers of m er finishing. P ep surface mo	ompatible curi ortar, leveling rotect newly a sist with clean	ng compo mortar or pplied ma , cool pot	ound. Cu protectiv Iterial fro
			npound is recommende					
Removal	Cured	product can on	ly be removed mec	hanically.				
	■ Mini ■ Elev ■ Rate ■ Bon be u	mum ambient a vated temperatu e of strength ga ding agents like sed. If bonding	ss: Minimum 1 in. (2 and surface tempera ures will decrease w in will be reduced a Armatec <sup>®</sup> 110 and o agents are used, foll <sup>9</sup> 321 FS in service. A	atures 40°F (4°C orking time and t colder temper thers, which cur ow cure times fo	C) and rising d slump. atures. On si- re at a slower or the bonding	at time of appl te testing is re rate than 321 F agents used a	comment S, should	l not prior
	INSTRUCTIONS SHEET WHICH A PARTMENT AT 80 TO READ AND F RENT PRODUCT	ON THE PRODU RE AVAILABLE 00.933.7452 NOT OLLOW THE WA DATA SHEET, P	SIKA PRODUCT, THE ICT'S MOST CURREN ONLINE AT HTTP://U HING CONTAINED IN RNINGS AND INSTR RODUCT LABEL ANI	NT PRODUCT D/ SA.SIKA.COM/ ( ANY SIKA MATE UCTIONS FOR E SAFETY DATA	ATA SHEET, P OR BY CALLIN ERIALS RELIE EACH SIKA PR SHEET PRIOF	RODUCT LABE IG SIKA'S TEC VES THE USER ODUCT AS SE TO PRODUCT	EL AND SA HNICAL S OF THE ( FORTH ) USE.	AFETY DA ERVICE I DBLIGATI N THE CI
	For further informati	on and advice reg	arding transportation, ha hysical, ecological, toxico ergency, call CHEMTRE	andling, storage an	nd disposal of ch	emical products,	users sho	uld refer to
	Data Sheet, product ment at 800-933-7452	label and Safety Da	e user must always read ta Sheet which are availa d in any Sika materials re e current Product Data S	able online at http:// lieves the user of th	/usa.sika.com/ of he obligation to r	r by calling Sika's ead and follow the	Technical S	Service Dep
	the current Product I Buyer's sole remedy EXPRESS OR IMPLIE SHALL NOT BE LIAB THE USE OF THIS PR	Data Sheet if used a shall be limited to the ED SHALL APPLY IN LE UNDER ANY LE ODUCT IN A MANNE DUCTS ARE SUB	from date of installation s directed within shelf lif he purchase price or repl OCLUDING ANY WARRAI GAL THEORY FOR SPEC ER TO INFRINGE ON ANY IJECT SIKA'S TERMS A	e. User determines acement of product NTY OF MERCHAN IAL OR CONSEQUE PATENT OR ANY OT	suitability of pro t exclusive of lab TABILITY OR FIT ENTIAL DAMAGE THER INTELLECT OF SALE AVAII	duct for intended or or cost of labor. NESS FOR A PAR S. SIKA SHALL NO UAL PROPERTY I ABLE AT HTTP:	use and ass NO OTHER TICULAR P OT BE RESF RIGHTS HEL //USA.SIKA	WARRANT WARRANT URPOSE. S ONSIBLE F D BY OTHE COM/ OR
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3,000 psi (20.7 MPa)

3 hour

Product Data Sheet Edition 7.14.2014 Sikacrete 211

### Sikacrete<sup>®</sup> 211 One-component, cementitious,

## pumpable and pourable concrete mix

Description       Sikacrele 211 is a 1-component, portland-cement concrete containing factory blended coarse aggregate.         Where to Use <ul> <li>Full depth repairs.</li> <li>On grade, above, and below grade on concrete.</li> <li>On horizontal, vertical and overhead surfaces.</li> <li>As a structural repair material for parking facilities, industrial plants, walkways, bridges, turnels, dams and balconies.</li> <li>Filler for voids and cavities.</li> </ul> <li>Advantages</li> <li>Pre-packaged coarse aggregate: Eliminates need to extend material in the field; Eliminates the risk of reactive aggregate.</li> <li>High bond strength.</li> <li>Compatible with coefficient of thermal expansion of concrete.</li> <li>Increased resistance to deicing salts.</li> <li>Simple-to-use labor-saving system.</li> <li>Easily applied to clean, sound substrate.</li> <li>Not a vapor barrier.</li> <li>Not fammable</li> <li>Coverage</li> <li>Approximately 0.65 ft <sup>1</sup>/unit</li> <li>Packaging</li> <li>80 lb. multi-wall bag.</li> <li>Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>Results wav pieres Rassed upon stratsco.</li> <li>Storage Conditions</li> <li>Storage To using.</li> <li>Color</li> <li>Concrete gray when mixed.</li> <li>Mixing Ratio</li> <li>Mixing Ratio</li> <li>Mixing Ratio</li> <li>Mixing Ratio</li> <li>Application Time</li> <li>Initial Slump 5"-7"; Slump at 30 minutes &gt;4"</li> <li>Flexural Strength (ASTM C-78) 28 days</li> <li>Top is (15.0 MPa)</li> <li>Splitting Tensile Strength (ASTM C-496)</li> <li>Radays</li> <li>Application Time</li> <li>Init</li>						
<ul> <li>On grade, above, and below grade on concrete.</li> <li>On horizontal, vertical and overhead surfaces.</li> <li>As a structural repair material for parking facilities, industrial plants, walkways, bridges, trunnels, dams and balconies.</li> <li>Filler for voids and cavities.</li> <li>Advantages</li> <li>Pre-packaged coarse aggregate: Eliminates need to extend material in the field; Eliminates the risk of reactive aggregate.</li> <li>High bond strength.</li> <li>Compatible with coefficient of thermal expansion of concrete.</li> <li>Increased resistance to deiring salts.</li> <li>Simple-to-use labor-saving system.</li> <li>Easily mixed.</li> <li>Good freeze/thaw resistance.</li> <li>Easily mixed.</li> <li>Good freeze/thaw resistance.</li> <li>Easily mixed.</li> <li>Good freeze/thaw resistance.</li> <li>Not a vapor barrier.</li> <li>Not a vapor barrier.</li> <li>Not flammable</li> <li>Coverage</li> <li>Approximately 0.65 ft.<sup>3</sup>/unit</li> <li>Packaging</li> <li>Bo Ib. multi-wall bag.</li> </ul> Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) Resurts MY berse baset puen statistica. Variations between unon Mixing methods and curing conditions. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. Color Color Concrete gray when mixed. Mixing Ratio Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon. Application Time Initial Slump 5°-7°; Slump at 30 minutes >4° Flexural Strength (ASTM C-481) 28 days 700 psi (5.0 MPa) Splitting Tensile Strength (ASTM C-495) 28 days 700 psi (5.4 MPa) Bond Strength* (ASTM C-781) 28 days 700 psi (5.4 MPa) Bond Strength* (ASTM C-435) 28 days 700 psi (5.4 MPa) Bond Strength* (ASTM C-435) 28 days 700 psi (5.4 MPa) Bond Strength* (ASTM C-435) 28 days 700 psi (5.4 MPa) Bond	Description					
Eliminates the risk of reactive aggregate. High bond strength. Compatible with coefficient of thermal expansion of concrete. Increased resistance to deicing salts. Simple-to-use labor-saving system. Easily applied to clean, sound substrate. Not a vapor barrier. Not flammable Coverage Approximately 0.65 ft. <sup>3</sup> /unit Packaging 80 lb. multi-wall bag. Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER RASED UPON STATISTICAL VARIATIONS DEPENDING UPON MXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS. Shelf Life 1 year in original, unopened packaging. Storage Conditions Store dry at 40°-95°F (4°-35°C). Condition material to 65°- 75°F before using. Color Concrete gray when mixed. Mixing Ratio Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon. Application Time Initial Slump 5"-7"; Slump at 30 minutes >4" Flexural Strength (ASTM C-78) 28 days 700 psi (5.0 MPa) Splitting Tensile Strength (ASTM C-382 modified 28 days 1,500 psi (15.2 MPa) Bond Strength* (ASTM C-882 modified 28 days 1,500 psi (15.2 MPa) Compressive Strength (ASTM C-39) 1 day 2,000 psi (13.0 MPa) 2 days 4,500 psi (3.10 MPa) 2 days 4,500 psi (	Where to Use	<ul> <li>On grade, above, and below grade on concrete.</li> <li>On horizontal, vertical and overhead surfaces.</li> <li>As a structural repair material for parking facilities, industrial plants, walkways, bridges, tunnels, dams and balconies.</li> </ul>				
Packaging       80 lb. multi-wall bag.         Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.).         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       1 year in original, unopened packaging.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color       Concrete gray when mixed.         Mixing Ratio       Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon.         Application Time       Initial Slump 5"-7"; Slump at 30 minutes >4"         Flexural Strength (ASTM C-78)       28 days       750 psi (3.4 MPa)         Bond Strength* (ASTM C-882 modified       28 days       1,500 psi (15.2 MPa)         Compressive Strength (ASTM C-39)       1 day       2,000 psi (13.8 MPa)         1 day       2,000 psi (31.0 MPa)       28 days       5,000 psi (31.0 MPa)         28 days       5,000 psi (31.0 MPa)       28 days       <1,500 Coloumbs	Advantages	<ul> <li>Pre-packaged coarse aggregate: Eliminates need to extend material in the field; Eliminates the risk of reactive aggregate.</li> <li>High bond strength.</li> <li>Compatible with coefficient of thermal expansion of concrete.</li> <li>Increased resistance to deicing salts.</li> <li>Simple-to-use labor-saving system.</li> <li>Easily mixed.</li> <li>Good freeze/thaw resistance.</li> <li>Easily applied to clean, sound substrate.</li> <li>Not a vapor barrier.</li> </ul>				
Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       1 year in original, unopened packaging.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color       Concrete gray when mixed.         Mixing Ratio       Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon.         Application Time       Initial Slump 5"-7"; Slump at 30 minutes >4"         Flexural Strength (ASTM C-78)       28 days       750 psi (3.4 MPa)         Bond Strength (ASTM C-882 modified       28 days       1,500 psi (15.2 MPa)         Compressive Strength (ASTM C-39)       1 day       2,000 psi (13.8 MPa)         7 days       4,500 psi (31.0 MPa)       28 days       <1,500 coloumbs         Shrinkage (ASTM C-157)       28 days       <1,500 Coloumbs	Coverage	Approximately 0.65 ft. <sup>3</sup> /unit				
<ul> <li>RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>Shelf Life 1 year in original, unopened packaging.</li> <li>Storage Conditions Store dry at 40°-95°F (4°-35°C). Condition material to 65°- 75°F before using.</li> <li>Color Concrete gray when mixed.</li> <li>Mixing Ratio Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon.</li> <li>Application Time Initial Slump 5"-7"; Slump at 30 minutes &gt;4"</li> <li>Flexural Strength (ASTM C-78) 28 days 700 psi (5.0 MPa)</li> <li>Splitting Tensile Strength (ASTM C-496) 28 days 750 psi (3.4 MPa)</li> <li>Bond Strength* (ASTM C-39) 1 day 2,000 psi (13.8 MPa) 7 days 4,500 psi (31.0 MPa)</li> <li>28 days 5,000 psi (37.9 MPa)</li> <li>Shrinkage (ASTM C-157) 28 days &lt;0.05%</li> <li>Chloride ion permeability (Astm C-1202) 28 days &lt;1,500 Coloumbs</li> </ul>	Packaging	80 lb. multi-wall bag.				
		<ul> <li>RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>Shelf Life 1 year in original, unopened packaging.</li> <li>Storage Conditions Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.</li> <li>Color Concrete gray when mixed.</li> <li>Mixing Ratio Mix with clean potable water at rate of up to 1 gallon per bag. Start with 4/5 gallon and mix to consistency required with remainder of gallon.</li> <li>Application Time Initial Slump 5"-7"; Slump at 30 minutes &gt;4"</li> <li>Flexural Strength (ASTM C-78) 28 days 700 psi (5.0 MPa)</li> <li>Splitting Tensile Strength (ASTM C-496) 28 days 1,500 psi (15.2 MPa)</li> <li>Bond Strength* (ASTM C-882 modified 28 days 1,500 psi (15.2 MPa)</li> <li>Compressive Strength ( ASTM C-39)</li> <li>1 day 2,000 psi (13.8 MPa)</li> <li>7 days 4,500 psi (31.0 MPa)</li> <li>28 days 5,000 psi (37.9 MPa)</li> <li>Shrinkage (ASTM C-157) 28 days &lt;0.05%</li> <li>Chloride ion permeability (Astm C-1202) 28 days &lt;1,500 Coloumbs</li> </ul>				



PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET. PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.v. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537

RESPONSIBLE CARE ISO 9001 RC 14001

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Product Data Sheet Edition 7.14.2014 Sikacrete 211 SCC Plus



# Sikacrete<sup>®</sup> 211 SCC Plus

One-component, cementitious, polymer-modified, self consolidating concrete mix with an integral migrating corrosion inhibitor

Description	Sikacrete 211 SCC Plus is a one-component, self blended coarse aggregate. This self consolidatin modified and also contains a migrating corrosion	g concrete b	
Where to Use	<ul> <li>Full depth repairs.</li> <li>On grade, above and below grade on concrete.</li> <li>On horizontal surfaces.</li> <li>Vertical and overhead surfaces when formed an</li> <li>As a structural repair material for parking facilitit tunnels, dams, and balconies.</li> <li>Filler for voids and cavities.</li> </ul>	nd pumped c	
Advantages	<ul> <li>Self consolidating concrete - Excellent placeme</li> <li>Polymer-modified.</li> <li>Integral Penetrating Corrosion Inhibitor.</li> <li>Silica Fume Enhanced.</li> <li>Prepackaged coarse aggregate. Eliminates the -nates the risk of reactive aggregate.</li> <li>Can be pumped or poured into forms and gets</li> </ul>	need to exte	end material in the field. Elimi
Coverage	Approximately 0.50 ft.3/bag. Actual results on site	may vary.	
Packaging	65 lb. bag.	J - J	
	Typical Data (Material and curing complexity of the second sec	ons depending actual site co unopened pa "F (4°-35°C) C) before us s approx. 1 day 7 days 28 days	UPON MIXING METHODS AND EQUIPMENT, DNDITIONS AND CURING CONDITIONS. Ickaging. . Condition material to ing. 500 psi (3.4 MPa) 750 psi (5.2 MPa) 1,000 psi (6.9 MPa) 750 psi (5.1 MPa) 1,000 psi (6.9 MPa) 1,000 psi (6.9 MPa) 1,000 psi (6.9 MPa) 1,500 psi (10.3 MPa)
	Direct Tensile Bond (ACI 503)	28 days 1 day 7 days	2,500 psi (17.2 MPa) 250 psi (1.7 MPa) 300 psi (2.1 MPa)
	Compressive Strength(ASTM C-39)	1 day 7 days 28 days	2,000 psi (13.8 MPa) 5,500 psi (37.9 MPa) 6,500 psi (44.8 MPa)
	Shrinkage (ASTM C-157)	28 days	<0.05%
	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MI	UST ALWAYS RE	AD AND FOLLOW THE WARNINGS AND



		e ion permeability (AS		<b>20</b> davia (050 Cal	
	Scaling Sulfate Length	Thaw Resistance (AST Resistance (ASTM C-4 Resistance (ASTM C-1 change after 6 months ubbed into substrate.	M C-666) 672)	28 days       <650 Col         300 cycles       > 99%         50 cycles       2         0.006	loumbs
S	surface. Be su	eteriorated concrete, dir re repair area is not less	s than 1 in. in o	depth. Preparation w	ork should be done
ess	exposed aggre	re water blast, scabbler egate surface with a mir ean water. Substrate sh pplication.	nimum surface	e profile of ±1/8 in. (	CSP-7-8). Saturate
F tu ti	Reinforcing S to remove all t the steel shou	teel: Steel reinforcement races of rust. Where cor Id be high-pressure was rotection of reinforcing st	rosion has oc shed with clea	curred due to the pre an water after mecha	sence of chlorides, inical cleaning. For
Mixing S c n	Start mixing w over water as mix. Mix to a u	ith 5.5 pints of water. An excess water will cause iniform consistency, max pm) and paddle or in ap	e segregation ximum 3 minu	. Add Sikacrete 211 Ites. Mechanically mi	while continuing to ix with a low-speed
Application F s s p F F	Pre-wet surfact strate is achiev suitable means sure. Vibrate fo pumping until	e to SSD(Saturated Sur ved. To accomplish this, r s should be employed su orm while pouring or pun a 3 to 5 psi increase in ot deflect. Vent to be ca	face Dry). En naterial shoul ich as vibratio nping. Pump v normal line p	sure good intimate co d be scrubbed into the n of the material or pu with a variable pressu ressure is evident the	ontact with the sub- e substrate or other umping under pres- ure pump. Continue en STOP pumping.
C le fi	with wet burlar compound. Cu leveling morta finishing. Prote	ommendations for portla o and polyethylene, a fin iring compounds advers r or protective coatings. ect newly applied materia compound is recommended.	e mist of wate ely affect the Moist curing s	er or a water based* adhesion of following should commence im	compatible curing g layers of mortar, mediately after
-	<ul> <li>Minimum an</li> <li>As with all chemical rea</li> </ul>	hickness: Minimum 1 in nbient and surface temp cement based materia action and possible produ ninum bars, rails, posts et	eratures 45°F Ils, avoid cor ctfailure. Insu	(7°C) and rising at t ntact with aluminum late potential areas of	ime of application. to prevent adverse contact by
INSTI WHIC AT 8 AND	RUCTIONS ON THE ICH ARE AVAILABL 300-933-7452. NOT FOLLOW THE WA	OF ANY SIKA PRODUCT, THE E PRODUCT'S MOST CURRENT F E ONLINE AT HTTP://USA.SIKA HING CONTAINED IN ANY SIK RNINGS AND INSTRUCTION FOI T LABEL AND SAFETY DATA SH	PRODUCT DATA S COM/ OR BY CA A MATERIALS REI R EACH SIKA PROI	HEET, PRODUCT LABEL AND LLING SIKA'S TECHNICAL S LIEVES THE USER OF THE C DUCT AS SET FORTH IN THE	D SAFETY DATA SHEET ERVICE DEPARTMENT DBLIGATION TO READ
For further actual Safet	information and ac	KEEP OUT OF REACH OF CHILDREN. NO lvice regarding transportation, ha aining physical, ecological, toxico ise of emergency, call CHEMTREC	andling, storage an ological and other s	d disposal of chemical produ afety related data. Read the c	ucts, users should refer to the
Data Sheet, ment at 800	, product label and \$ )-933-7452. Nothing ka product as set fo	oduct, the user must always read a Safety Data Sheet which are availa contained in any Sika materials re rrth in the current Product Data SI	ble online at http:// lieves the user of th	/usa.sika.com/ or by calling S ne obligation to read and follo	ika's Technical Service Depart- w the warnings and instruction
the current Buyer's sole EXPRESS C SHALL NOT THE USE OF SALE OF S	Product Data Sheet le remedy shall be lin OR IMPLIED SHALL T BE LIABLE UNDEF F THIS PRODUCT IN	one year from date of installation if used as directed within shelf life mited to the purchase price or repla APPLY INCLUDING ANY WARRAN ANY LEGAL THEORY FOR SPEC A MANNER TO INFRINGE ON ANY I ARE SUBJECT SIKA'S TERMS A	e. User determines acement of product NTY OF MERCHANT AL OR CONSEQUE PATENT OR ANY OT	suitability of product for inten exclusive of labor or cost of la ABILITY OR FITNESS FOR A INTIAL DAMAGES. SIKA SHAI 'HER INTELLECTUAL PROPEI OF SALE AVAILABLE AT H	Ided use and assumes all risks. abor. NO OTHER WARRANTIES PARTICULAR PURPOSE. SIKA LL NOT BE RESPONSIBLE FOR RTY RIGHTS HELD BY OTHERS. TTP://USA.SIKA.COM/ OR BY
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Product Data Sheet Edition 5.7.2015 SikaTop<sup>®</sup> 111 PLUS

TESTED PER ICRI GUIDELINE FOR INORGANIC REPAIR MATERIAL DATA SHEET PROTOCOL GUIDELINE NO. 320.3R

### **SikaTop® 111 PLUS** Two-component, polymer-modified, cementitious, screed mortar plus Sika FerroGard® 901 penetrating corrosion inhibitor

Description	SikaTop® 111 PLUS is a two-component, polymer-modified, portland cement-based, fast-setting, screed mortar. It is a high performance repair mortar for horizontal, vertical and overhead surfaces in form and pour applications. It offers the additional benefit of Sika FerroGard® 901, a penetrating corrosion inhibitor included in its formulation.
Where to Use	<ul> <li>On grade, above and below grade on concrete and mortar substrates.</li> <li>On horizontal, vertical and overhead surfaces.</li> <li>As a structural repair material for parking structures, industrial plants, walkways, bridges, tunnels, dams, floors, etc.</li> <li>Approved for reapairs over cathodic protection systems.</li> <li>Free-flowing repair mortar for hard-to-reach areas.</li> <li>Filler for voids and cavities.</li> </ul>
Advantages	<ul> <li>Extremely low shrinkage proven by four industry standard test methods.</li> <li>High compressive and flexural strengths.</li> <li>Increased freeze/thaw durability and resistance to deicing salts.</li> <li>Compatible with coefficient of thermal expansion of concrete - Passes ASTM C 884.</li> <li>Increased density - improved carbon dioxide resistance (carbonation) without adversely affecting water vapor transmission (not a vapor barrier).</li> <li>Enhanced with Sika FerroGard® 901, a penetrating corrosion inhibitor - reduces corrosion even in the adjacent concrete USDA certifiable for incidental food contact.</li> <li>ANSI/NSF Standard 61 potable water compliant.</li> </ul>
Coverage	0.5 cu. ft./ unit. Approximately 0.75 cu. ft./unit concrete (mixed mortar + 42 lbs. of 3/8" pea gravel)
Packaging	Component 'A' - 1-gal. plastic jug; 4/carton. Component 'B' - 61.5-lb. multi-wall bag.

# Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Shelf Life One year in original, unopened packaging. Storage Conditions Store dry at 40°-95°F. Condition material to 65°-75°F before using. Protect

<b>g</b> .		Component 'A' from freezing. If frozen, discard.
Color		Concrete gray when mixed.
Mixing F	Ratio	Plant-proportioned kit, mix entire unit.
Applica	tion Time	Approximately 30 minutes.
Finishin	g Time	50-120 minutes
Note:		adding Component 'B' to Component 'A' and are highly affected by temperature, ibstrate temperature, wind, sun and other job site conditions.

relative numidity, substrate terr	iperature, wind, sun and othe	er job site co	onaltions.		
Density (wet mix)	ASTM C 138		136 lbs./ft <sup>3</sup>	(2.18 kg./l)	
Flexural Strength	ASTM C 293	28 days		1,400 psi	
Split Tensile	ASTM C 496	28 days		600 psi	
Bond Strength	ASTM C 882 (modified)	28 days		2,000 psi	
Compressive Strength	ASTM C 109				
		1 day		2,500 psi	
		7 days		5,500 psi	
		28 days		6,500 psi	
Shrinkage	ASTM C 157				
	(mod. ICRI 320.3R)				
Specimen Size 1" x 1" x 11-1/4"		28 days	<0.05%		
Specimen Size 3" x 3" x 11-1/4"		28 days	0.022%		
Ring Test (days)	ASTM C 1581		>70 days		
Ring Test - Average Max Strain	ASTM C 1581		-16 µstrain		
Ring Test - Average Stress Strain	ASTM C 1581		1.46 psi/da	ау	
Ring Test - Potential for Cracking	ASTM C 1581		Low		
Baenzinger Block		90 days	No crackin	g	
Freeze/Thaw Durability (300 cycles)	ASTM C 666		98%		
CI Permeability	ASTM C 1202		<500 Could	ombs.	
Direct Bond Strength	ASTM C 1583	28 days	>500 psi (s	substrate failure)	
Modulus of Elasticity	ASTM C 531		3.00 x 10 <sup>6</sup>	psi	
Initial Set Time (min)	ASTM C 266		40-70		
Final Set Time (min)	ASTM C 266		>90		



How to Use			
Substrate	Concrete, mortar, and masonry p	roducts.	
Surface Preparation	Remove all deteriorated concrete, dirt, oil, grease and all bond inhibiting materials from surface. Be sure repair ar less than 1/2 inch in depth. Preparation work should be done by high pressure water blast, scabbler, or other appendentical means to obtain an exposed aggregate surface with a minimum surface profile of ±1/16 inch (CSP-5); (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water application.		
	Where corrosion has occurred du	e to the presence of chlor	nly prepared by mechanical cleaning to remove all traces of rust. des, the steel should be high-pressure washed with clean water use Sika® Armatec® 110 EpoCem (consult Product Data Sheet).
		heet). Alternately, a scrub	te with a brush or sprayed applied coat of Sika® Armatec® 110 coat of SikaTop® 111 PLUS can be applied prior to placement of scrub coat before it dries.
Mixing	Mix mechanically with a low spe	ed drill (400-600 rpm) and nsistency is desired. Mix to	ntainer. Add Component 'B' (powder) while mixing continuously. I mixing paddle or mortar mixer. Add remaining Component 'A' o a uniform consistency, maximum 3 minutes. Thorough mixing ary.
	then introduce 3/8 inch coarse ag is 42 lbs. per bag (approx. 3.0 to	gregate at desired quantit 3.5 gal. by loose volume).	A' into mixing container. Add all of Component 'B' while mixing, y. Mix to uniform consistency, maximum 3 minutes. Addition rate The aggregate must be non-reactive (reference ASTM C 1260, y, have low absorption and high density, and comply with ASTM
			physical properties of SikaTop 111 PLUS. The yield is increased .). Do not use limestone aggregate
Application		e to set to desired stiffnes	ubstrate, filling all pores and voids. After filling repair, screed the , then finish with wood or sponge float for a smooth surface, or
	pressure pump. Continue pumpir	ng until a 3 to 5 psi increas	D. Vibrate form while pouring or pumping. Pump with a variable is in normal line pressure is evident then STOP pumping. Form evident, and forms stripped when appropriate.
Tooling and Finishing	mist of water or a water based* co	mpatible curing compound rtar, leveling mortar or prot aterial from direct sunlight, v	ring is required. Moist cure with wet burlap and polyethylene, a fine (ASTM C 309 compliant). Curing compounds adversely affect the ective coatings. Moist curing should commence immediately after <i>i</i> nd, rain and frost.
Limitations	Application thickness:	Min.	Max. inches one lift
	Neat	1/2 inch (12 mm)	1 inch (25 mm)
	Extended	1 inch (25 mm)	6 inches (150 mm)
	<ul> <li>Do not use solvent-based curin</li> </ul>	may result in variations of g compound.	the physical properties of the mortar.
	product failure. Insulate potenti	,	Iminum to prevent adverse chemical reaction and possible ing aluminum bars, rails, posts etc. with an appropriate epoxy
	such as Sikadur <sup>®</sup> 32, Hi-Mod.		

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

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Fracc. Industrial Balvanera Corregidora, Querétaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-697-3087 1-800-933-SIKA NATIONWIDE

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**Product Data Sheet** Edition 2.3.2016 SikaQuick<sup>®</sup> FNP

## SikaQuick<sup>®</sup> FNP

Self-consolidating, fast-setting, one-component, structural repair mortar with fiber reinforcement and integral corrosion inhibitor

Description	SikaQuick FNP is a self consolida concrete repair applications.	ting mortar for pouring and pumping into pre-placed aggregate,
Where to Use	<ul> <li>Horizontal, vertical and over</li> </ul>	head repairs (formed)
	<ul> <li>Parking garages, bridges, be structural applications</li> </ul>	ams, columns, tunnels, building facades, retaining walls and other
	<ul> <li>Pre-placed aggregate application</li> </ul>	ations
	<ul> <li>Marine structures such as pie</li> </ul>	ers, damns, sea walls, etc.
Advantages	<ul> <li>High fluidity for ease of pum</li> </ul>	ping and pouring in congested repairs
_	<ul> <li>Fiber Reinforced</li> </ul>	
	<ul> <li>Integral corrosion inhibitor</li> </ul>	
	<ul> <li>One-component for easy mix</li> <li>Up to 8" in thickness</li> </ul>	king
	<ul> <li>Freeze/Thaw resistant</li> </ul>	
	<ul> <li>Extremely Low Shrinkage</li> </ul>	
	<ul> <li>Excellent bond strength</li> </ul>	
Coverage	~0.5 cu.ft. per 55 lb bag.	
Packaging	55 lb bag	
	Typical Data (Material and curing conditions @ 7	3°F (23°C) and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATION TEMPERATURE, APPLICATION METHODS, TEST METHODS, A	
	Shelf Life: Storage Conditions: Condition material: Pot Life Initial Set Final Set VOC:	1 year in original, unopened packaging. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. 60 minutes 4-5 hours 6-7 hours 0 g/L
	Compressive Strength (ASTM C-109), Day 1 Day 7 Day 28	<b>psi (MPa)</b> 4500 8500 >11000
	Flexural Strength (ASTM C-348) Day 1	<b>psi(MPa)</b> 700
	Day 7	1300
	Day 28	1500
	Modulus of Elasticity (ASTM C-469) Day 28	<b>psi(GPa)</b> 5x10° (34)
	Chloride Perm. (ASTM C1202/ AASHTO T277)	500 coulombs
	Freeze Thaw Resist. (ASTM C666)	98%
	Splitting Tensile Strength (ASTM C496)	900 psi (28 days)
	Volume Change (ASTM C806)	+0.06
	Direct Tensile Bond Strength (ACI 503R)	500-600 psi
	Slant Shear Bond (ASTM C881)	3000 psi (28 days)



How to Use	
Surface Preparation	Remove all deteriorated concrete, dirt, oil, grease, and all bond-inhibiting materials from surface. Be sure repair area is not less than 1 in. in depth. Preparation work should be done by high pressure water blast, scabbler, or other appropriate mechanical means to obtain an exposed aggregate surface with a minimum surface profile of ±1/8 in. (CSP-7-8). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standingwater during application.
	<b>Reinforcing Steel:</b> Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high-pressure washed with clean water after mechanical cleaning. For priming and protec-tion of reinforcing steel use Sika® Armatec® 110 EpoCem (consult Product Data Sheet).
Mixing	Start with 10 pints of water in mixing container. Add SikaQuick FNP while continuing to mix. Add additional water up to 0.5 pints. Mix to a uniform consistency, maximum 3 minutes. Mechanically mix with a low-speed drill (400-600 rpm) and paddle or in appropriate size mortar mixer or concrete mixer.
Application	Form and pour or pump applications: Pre-wet surface to SSD(Saturated Surface Dry). Ensure good intimate contact with the substrate is achieved. To accomplish this, material should be scrubbed into the substrate or other suitable means should be employed such as vibration of the material or pumping under pressure. Vibrate form while pouring or pumping. Pump with a variable pres-sure pump. Continue pumping until a 3 to 5 psi increase in normal line pressure is evident then STOP pumping. Form should not deflect. Vent to be capped when steady flow is evident and forms stripped when appropriate. When preplaced aggregate, pre-wash aggregate before placing in repair area.
Tooling & Finishing	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a water based* compatible curing compound. Curing compounds adversely affect the adhesion of following layers of mortar, leveling mortar or protective coatings. Moist curing should commence immediately after finishing. Protect newly applied material from direct sunlight, wind, rain and frost. *Pretesting of curing compound is recommended.
Limitations	<ul> <li>Application thickness: Minimum 1 in. (25 mm); Maximum 8 in. (200 mm). Thicker appliations have been done successfully. Please consult Sika Technical Service.</li> </ul>
	<ul> <li>Minimum ambient and surface temperatures 45°F (7°C) and rising at time of application. Refer to the American Concrete Institute (ACI) for cold-weather or hot-weather application guidelines.</li> </ul>
	<ul> <li>Do not add any additives (plasticizers, accelerators, retarders, etc.) or cement to SikaQuick FNP</li> </ul>
	<ul> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts, with an appropriate epoxy such as Sikadur<sup>®</sup> 32 Hi- Mod.</li> </ul>
INSTRUCT SHEET WH PARTMENT TO READ A	EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND IONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA IICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE T AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- IDUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
application ar and applied u tions, actual recommenda vice, recomm plication and notice. All se <b>Prior to each</b>	KEEP CONTAINER TIGHTLY CLOSED • KEEP OUT OF REACH OF CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY on provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to t nd use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handl inder normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling com site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advic tions or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, a endations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended a purpose before proceeding with the full application of the product(s). Sika reserves the right to change the properties of its products witho less of Sika product(s) are subject to its current terms and conditions of sale which are available at <u>www.sikausa.com</u> or by calling 800-933-745 to use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Techn
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Product Data Sheet Edition 7.25.2014 Sikacem 103

# Sikacem<sup>®</sup> 103

Machine-applied, silica fume enhanced, cementitious mortar

Sikacem 103 is a ready-to-use, non-accelerated, cementitious, silica fume enhanced mortar with a dust contro agent. Sikacem 103 is formulated for machine applications using dry or wet process spray equipment.
<ul> <li>Sikacem 103 is particularly suitable for structural repairs in large area applications; for structures such as bridges, viaducts, retaining walls, parking structures, tunnels, galleries, industrial and residential buildings, piers, off-shore platforms, etc.</li> <li>Use on grade, above, and below grade on concrete and mortar.</li> <li>Use on vertical, overhead and horizontal surfaces.</li> </ul>
<ul> <li>One-component, ready to use mortar.</li> <li>Excellent adhesion to currently prepared, sound substrates.</li> <li>High compressive and flexural strength, rapid strength and development</li> <li>High density.</li> <li>Not a vapor barrier.</li> <li>Formulated to minimize dust formation.</li> <li>Low in rebound, extremely economical in use.</li> <li>Low water cement ratio, very low shrinkage.</li> <li>Can be troweled and screed after application.</li> </ul>
Yield in service will vary according to amount of water utilized in the shotcreting process. Theoretical yield without waste, of a 55 lb. bag is approximately 0.48 cu.ft/bag. Estimating should be based on prior experience or actual field evaluation
55 lb. multi-wall bags.
Typical Data (Material and curing conditions @ 73F (23°C) and 100% R.H.)
RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       1 year in original, unopened bags.
<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.
Color Concrete gray
Density (wet mix) 137 lbs./cu.ft. (2.2 kg/l)
Compressive Strength (ASTM C-109)           (3 inch cubes)           2 day         6,000 psi         (41.4 MPa)           7 day         7,000 psi         (48.3 MPa)           28 day         8,000 psi         (55.2 MPa)           Freeze/Thaw Resistance (ASTM C-666)         300 cycles         95%
Rapid Chloride Permeability Testing (AASHTO T-277) Coulombs passed: less than 750 (very low)
Flexural Strength (ASTM C-78)       Could more remeability resting (ASTM C-78)         7 day       1,000 psi       (6.9 MPa)         28 day       1,400 psi       (9.7 MPa)
Tensile Strength (ASTM C-496)           7 day         600 psi         (4.1 MPa)           28 day         750 psi         (5.2 MPa)
Direct Bond Strength (pull off test) (ACI 503.R)
<b>28 day</b> 290-580 psi (2-4 MPa) mostly concrete failure (substrate)
-



How to Use Surface Preparation	<b>Concrete/Mortar:</b> Substrate must be sound, clean, and free from oil, grease, loose material, surface contaminants and other bond-inhibiting materials. Steel reinforcement must be clean and free from any rust. Be sure repair area is not less than 1/3 in. in depth. Preparation work should be done by high pressure water blast,
	scabbler, or other appropriate mechanical means, to obtain an exposed aggregate surface (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during application. When applying on critical substrates, the use of Sika Armatec 110 EpoCem as a bonding agent is advised.
	<b>Reinforcing Steel:</b> Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high-pressure washed with clean water after mechanical cleaning. For priming of reinforcing steel, use Sika Armatec 110 EpoCem (consult Product Data Sheet).
Application	<b>Dry Process:</b> Sikacem 103 is applied by conventional dry spray shotcrete equipment. Generally, do not use equipment with high rotor capacity. Apply Sikacem 103 in accordance with ACI 506-R85, "Guide to Shotcrete". Important factors to observe during shotcreting are nozzle distance (2-6 ft.), angle to substrate (90°F), and consistency of mortar. Immediately after application and before set, mortar consistency should be plastic, like a firm jell.
	Wet Process: Mixing: Conventional wet-process spray equipment such as the Mayco ST-45 or C-30HD ma- chine should be used. Set up wet-process equipment; then add the water (approx. 5 pints per bag) directly into mixer. Start the mixer in motion and add the Sikacem 103 mortar while continuing to mix. Mix to uniform consistency using a maximum of 6 pints of water per 55 lb. (25 kg.) bag (approx. 3 minutes).
	<b>Application:</b> At time of application, surfaces should be saturated surface dry but hold no standing water. Apply Sikacem 103 mortar by spraying or trowelling for repairing vertical or overhead surfaces. Shoot the material perpendicular to the surface. This minimizes rebound, creates the smoothest pattern (reduces 'bumps') and properly encases the rebars. The velocity of the material is sufficient if, at a distance of 18 to 24 in., the material pattern flattens out on contact with the surface and the rebars are encased. After applying the material, allow it to stiffen for about 10 minutes before removing bumpy areas with a trowel. Before applying the next layer, allow the material to reach initial set. This will take anywhere from 2 -4 hours, depending on mix consistency, mix and ambient temperature, wind conditions and humidity. Begin and finish a given patch on the same day.
Tooling and Finishing	<ul> <li>g A natural gun finish may be used. If a gun-finish is too rough, special finishes may be applied. Approximately 5-10 min. after initial set, excess material should be sliced off with a sharp-edged cutting screed. The surface may then be finished to your requirements:</li> <li>broomed for a rough texture</li> <li>wood-flo ted for a granular texture</li> <li>steel-trowelled for a smooth finish</li> </ul>
	As per ACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap a polyethylene, a fine mist of water or a water based* compatible curing compound. Curing compounds advers affect the adhesion of following layers of mortar, leveling mortar or protective coatings. Moist curing sho commence immediately after finishing. Protect newly applied material from direct sunlight, wind, rain and from "Pretesting of curing compound is recommended."
Limitations	<ul> <li>Application thickness: Minimum 1/3 inch (8 mm) for large areas, local 1/4 inch (6 mm) can be tolerated.</li> <li>Maximum in one layer for large areas, 2 inches (50 mm). Local applications up to 6-10 inches (150-250 mm) are possible.</li> </ul>
	<ul> <li>Minimum ambient and surface temperatures 40°F (4°C) and rising at the time of application.</li> <li>Do not use solvent-based curing compounds.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>
	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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Product Data Sheet Edition 7.25.2014 Sikacem 103F

# Sikacem<sup>®</sup> 103F

# Machine-applied, silica fume enhanced, fiber-reinforced cementitious mortar

Description	Sikacem 103F is a ready-to-use, non-accelerated, cementitious, silica fume enhanced, fiber-reinforce morta with a dust control agent. Sikacem 103F is formulated for machine applications using dry or wet process spray equipment.
Where to Use	<ul> <li>Sikacem 103F is particularly suitable for structural repairs in large area applications; for structures such as bridges, viaducts, retaining walls, parking structures, tunnels, galleries, industrial and residential buildings piers, off-shore platforms, etc.</li> <li>Use on grade, above, and below grade on concrete and mortar.</li> <li>Use on vertical, overhead and horizontal surfaces.</li> </ul>
Advantages	<ul> <li>One-component, ready to use mortar.</li> <li>Excellent adhesion to currently prepared, sound substrates.</li> <li>High compressive and flexura strength, rapid strength and development.</li> <li>Fiber-reinforced</li> <li>High density.</li> <li>Not a vapor barrier.</li> <li>Formulated to minimize dust formation.</li> <li>Low in rebound, extremely economical in use.</li> <li>Low water cement ratio, very low shrinkage.</li> <li>Can be troweled and screed after application.</li> </ul>
Coverage	Yield in service will vary according to amount of water utilized in the shotcreting process. Theoretical yield without waste, of a 55 lb. bag is approximately 0.48 cu.ft/bag. Estimating should be based on prior experience or actual fiel evaluation.
Packaging	55 lb. multi-wall bags.
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       1 year in original, unopened bags.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color       Concrete gray         Density (wet mix)       137 lbs./cu.ft. (2.2 kg/l)         Compressive Strength (ASTM C-109)         (3 inch cubes)         2 day       6,000 psi (41.4 MPa)         7 day       7,000 psi (48.3 MPa)         28 day       8,000 psi (55.2 MPa)         Freeze/Thaw Resistance (ASTM C-666)       300 cycles       95%         Rapid Chloride Permeability Testing (AASHTO T-277)       Coulombs passed: less than 750 (very low)
	Flexural Strength (ASTM C-78)         7 day       1,000 psi       (6.9 MPa)         28 day       1,400 psi       (9.7 MPa)         Tensile Strength (ASTM C-496)         7 day       600 psi       (4.1 MPa)         28 day       750 psi       (5.2 MPa)         Direct Bond Strength (pull off test) (ACI 503.R)         28 day       290-580 psi       (2-4 MPa) mostly concrete failure (substrate)



How to Use				
Surface Preparation	nants and other bond-i repair area is not less scabbler, or other appr surface with clean wate plication. When applyin	nhibiting materials. Steel than 1/3 in. in depth. Pre opriate mechanical mean er. Substrate should be s	reinforcement must be clear eparation work should be do s, to obtain an exposed agg aturated surface dry (SSD) v	Nose material, surface contaminand free from any rust. Be surface hand free from any rust. Be surface by high pressure water blass regate surface (CSP-6). Saturate vith no standing water during ap D EpoCem as a bonding agent is
	traces of rust. Where co	prrosion has occurred due ter after mechanical clea	to the presence of chlorides,	nechanical cleaning to remove a the steel should be high-pressure ing steel, use Sika Armatec 110
Application	equipment with high rot Important factors to ob	tor capacity. Apply Sikace oserve during shotcreting	n 103F in accordance with A are nozzle distance (2-6 ft.	equipment. Generally, do not use CI 506-R85, "Guide to Shotcrete" ), angle to substrate (90°F), and Ir consistency should be plastic
	Wet Process: Mixing: chine should be used. into mixer. Start the mix consistency using a ma	Set up wet-process equ xer in motion and add the aximum of 6 pints of wate	pment; then add the water Sikacem 103F mortar while r per 55 lb. (25 kg.) bag (ap	
	Sikacem 103F mortar to perpendicular to the su properly encases the re pattern flatten out on c it to stiffen for about 10 allow the material to re	by spraying or trowelling t urface. This minimizes re abars. The velocity of the r contact with the surface and minutes before removing ach initial set. This will ta	or repairing vertical or over bound, creates the smoothe material is sufficien if, at a dis nd the rebars are encased. A g bumpy areas with a trowe ke anywhere from 2 -4 hours	but hold no standing water. Appl- ead surfaces. Shoot the material st pattern (reduces 'bumps') and tance of 18 to 24 in., the material fiter applying the material, allow I. Before applying the next layer s, depending on mix consistency a given patch on the same day.
Tooling and Finishing	5-10 min. after initial se	et, excess material should be finished to your requir h texture granular texture	be sliced off with a sharp-e	r may be applied. Approximately dged cutting screed.
	and polyethylenes, a fi adversely affect the ad	in mist of water or a wa hesion of following layers nediately after finishing F	ter based* compatible curing of mortar, leveling mortar or	ired. Moist cure with wet burla g compound. Curing compound protective coatings. Moist curing al from direct sunlight, wind, rain
Limitations	<ul> <li>Maximum in one la mm) are possible.</li> <li>Minimum ambient a</li> <li>Do not use solvent-</li> <li>As with all cement b possible product fai</li> </ul>	yer for large areas, 2 inc and surface temperatures based curing compounds based materials, avoid con	hes (50 mm). Local applicat 40°F (4°C) and rising at the that with aluminum to preve eas of contact by coating alu	inch (6 mm) can be tolerated. ions up to 6-10 inches (150-250 time of application. nt adverse chemical reaction and minum bars, rails, posts etc. with
	PRIOR TO EACH USE O INSTRUCTIONS ON THE WHICH ARE AVAILABLE AT 800-933-7452. NOTH AND FOLLOW THE WAR	F ANY SIKA PRODUCT, THE PRODUCT'S MOST CURRENT ONLINE AT HTTP://USA.SIK HING CONTAINED IN ANY SII ININGS AND INSTRUCTION FO	USER MUST ALWAYS READ AN PRODUCT DATA SHEET, PRODUC A.COM/ OR BY CALLING SIKA'S (A MATERIALS RELIEVES THE US	ID FOLLOW THE WARNINGS AND CT LABEL AND SAFETY DATA SHEET FECHNICAL SERVICE DEPARTMENT ER OF THE OBLIGATION TO READ ORTH IN THE CURRENT PRODUCT
				STRIAL USE ONLY. FOR PROFESSIONAL USE ON mical products, users should refer to t
actua	al Safety Data Sheets containi	ng physical, ecological, toxicol		Read the current actual Safety Data She
Data ment for ea	Sheet, product label and Safe at 800-933-7452. Nothing con	ety Data Sheet which are availat tained in any Sika materials reli	le online at http://usa.sika.com/ or	ons on the product's most current Produ by calling Sika's Technical Service Depa ad and follow the warnings and instructi iheet prior to
the ci Buye EXPF SHAL THE U SALE	urrent Product Data Sheet if u rr's sole remedy shall be limite RESS OR IMPLIED SHALL APF LL NOT BE LIABLE UNDER AN USE OF THIS PRODUCT IN A M	sed as directed within shelf life. d to the purchase price or replar PLY INCLUDING ANY WARRAN Y LEGAL THEORY FOR SPECI ANNER TO INFRINGE ON ANY P.	User determines suitability of prod cement of product exclusive of labor Y OF MERCHANTABILITY OR FITN L OR CONSEQUENTIAL DAMAGES ATENT OR ANY OTHER INTELLECTU	ts and to meet the technical properties uct for intended use and assumes all risi or cost of labor. NO OTHER WARRANTI ESS FOR A PARTICULAR PURPOSE. SII SIKA SHALL NOT BE RESPONSIBLE FO JAL PROPERTY RIGHTS HELD BY OTHER ABLE AT HTTP://USA.SIKA.COM/ OR J
R Visit	our website at usa.sika.co		1-1 our nearest Sika sales office, conta	800-933-SIKA NATIONWIDE act your regional center.
KC S	ika Corporation 01 Polito Avenue yndhurst, NJ 07071 hone: 800-933-7452 ax: 201-933-6225	Sika Canada inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792	Sika Mexicana S.A. de C.v. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537	

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### Sikacem<sup>®</sup> 133 Machine-applied, polymer-modified, silica fume enhanced, cementitious mortar

Description	Sikacem <sup>®</sup> 133 is a high performance, ready-to-use, non-accelerated, cementitious, polymer-modified, silica fume enhanced mortar with a dust control agent. Sikacem <sup>®</sup> 133 is formulated for machine applications using dry or wet process shotcrete equipment.
Where to Use	<ul> <li>Sikacem<sup>®</sup> 133 is particularly suitable for structural repairs in large area applications; for structures such as bridges, viaducts, retaining walls, parking structures, tunnels, galleries, industrial and residential buildings piers, off-shore platforms, etc.</li> <li>Use on grade, above, and below grade on concrete and mortar.</li> <li>Use on vertical, overhead and horizontal surfaces.</li> </ul>
Advantages	<ul> <li>One-component, ready to use mortar.</li> <li>Excellent adhesion to currently prepared, sound substrates.</li> <li>High compressive and flexural strength, rapid strength development.</li> <li>Excellent freeze/thaw durability and resistance to deicing salts.</li> <li>Tested for application during dynamic load (under traffic conditions).</li> <li>Increased density and durability - can be used as a thin overlay for additional protection of reinforcement</li> <li>High resistance to the diffusion of carbon dioxide (carbonation).</li> <li>Not a vapor barrier.</li> <li>Constant modulus of elasticity in a wide temperature range.</li> <li>Formulated to minimize dust formation.</li> <li>Low in rebound, extremely economical in use.</li> <li>Low water cement ratio, very low shrinkage.</li> <li>Can be troweled and screed after application.</li> </ul>
Coverage	Yield in service will vary according to rebound and amount of water utilized in the shotcreting process. Average yields for overhead consistencies approximately 0.42 cu. ft./bag. For vertical consistencies approximately 0.45 cu. ft./bag. For horizontal consistencies approximately 0.48 cu. ft./bag. Estimating should be based on prior experience or actual field evaluation.
Packaging	55 lb. multi-wall bags.
	Typical Data (Material and curing conditions @ 73°F (23°C) and 100% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life       1 year in original, unopened bags.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.
	Color Concrete gray
	Density (wet mix) 137 lbs./cu. ft. (2.2 kg./l) Compressive Strength (ASTM C-109)
	2 day         4,000 psi (27.6 MPa)         7 day         6,000 psi (41.4 MPa)         28 day         8,000 psi (55.2 MPa)           Freeze/Thaw Resistance (ASTM C-666)         300 cycles         100%
	Flexural Strength (ASTM C-78) 7 day 1,250 psi (8.6 MPa) 28 day 1,630 psi (11.2 MPa)
	Rapid Chloride Permeability Testing (AASHTO T-277) Coulombs passed: less than 500
	Tensile Strength (ASTM C-496)         7 day         630 psi (4.3 MPa)         28 day         800 psi (5.5 MPa)
	Direct Bond Strength (pull off test) (ACI 503.R)28 day290-580 psi (2-4 MPa) mostly concrete failure (substrate)
	Modulus of Elasticity           Static Modulus (28 days)         3.5 x 10 <sup>6</sup> psi (24,000 MPa) at -4°/68°F (-20°/+20°C)           Dynamic Modulus (28 days)         4.8 x 10 <sup>6</sup> psi (33,000 MPa)
	Carbon Dioxide DiffusionCoefficient (µCO2)20,000
	Coefficient of Thermal Expansion4.4 x 10-6/F (8 x 10-6/C)
	Tested and approved for application during dynamic load by the Technical University, Aachen for the German Federal Ministry of Transportation.
ka	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- RENT PRODUCT DATA SHEET. PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

	How to Use	
	Surface Preparation	<b>Concrete/Mortar</b> : Substrate must be sound, clean, and free from oil, grease, loose material, surface con- taminants and other bond-inhibiting materials. Steel reinforcement must be clean and free from any rust. Be sure re-pair area is not less than 1/4" in depth. Preparation work should be done by high pressure water blast, scabbler, or other appropriate mechanical means, to obtain an exposed aggregate surface (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with no standing water during ap- plication. When applying on critical substrates, the use of Sika® Armatec® 110 EpoCem as a bonding agent is advised.
		<b>Reinforcing Steel:</b> Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high-pressure washed with clean water after mechanical cleaning. For priming of reinforcing steel, use Sika <sup>®</sup> Armatec <sup>®</sup> 110 EpoCem (consult Product Data Sheet).
	Application	<b>Dry Process:</b> Sikacem <sup>®</sup> 133 is applied by conventional dry spray shotcrete equipment. Generally, do not use equipment with high rotor capacity. Apply Sikacem <sup>®</sup> 133 in accordance with ACI 506-R85, "Guide to Shotcrete". Important factors to observe during shotcreting are nozzle distance (2-6 ft.), angle to substrate (90), and consistency of mortar. Immediately after application and before set, mortar consistency should be plastic, like a firm jelly.
		Wet Process: Mixing: Conventional wet-process spray equipment such as the Mayco ST-45 or C-30HD ma- chine should be used. Set up wet-process shotcrete equipment; then add the water (approx. 5 pints per bag) directly into mixer. Start the mixer in motion and add the Sikacem <sup>®</sup> 133 mortar while continuing to mix. Mix to uniform consistency using a maximum of 6 pints of water per 55 lb. (25 kg.) bag (approx. 3 minutes).
		<b>Application:</b> At time of application, surfaces should be saturated surface dry but hold no standing water. Apply Sikacem <sup>®</sup> 133 mortar by spraying or trowelling for repairing vertical or overhead surfaces. Shoot the material perpendicular to the surface. This minimizes rebound, creates the smoothest pattern (reduces 'bumps') and properly encases the rebars. The velocity of the material is sufficient if, at a distance of 18-24 in., the material pattern flattens out on contact with the surface and the rebars are encased. After applying the material, allow it to stiffen for about 10 minutes before removing bumpy areas with a trowel. Before applying the next layer, allow the material to reach initial set. This will take anywhere from 2-4 hours, depending on the mix consistency, mix and ambient temperature, wind conditions, and humidity. Begin and finish a given patch on the same day.
	Tooling & finishing	A natural gun finish may be used. If a gun-finish is too rough, special finishes may be applied. Approximately 5-10 min. after initial set, excess material should be sliced off with a sharp-edged cutting screed. The surface may then be finished to your requirements: broomed for a rough texture; wood-floated for a granular texture; steel-trowelled for a smooth finish.
		<b>Curing</b> As perACI recommendations for portland cement concrete, curing is required. Moist cure with wet burlap and polyethylene, a fine mist of water or a water based* compatible curni g compound. Curing compounds adversely affect the adhesion of following layers of mortar, leveling mortar or protective coatings. Moist curing should commence immediately after finishing. Protect newly applied material from direct sunlight, wind, rain and frost. *Pretesting of curing compound is recommended.
	Limitations	<ul> <li>Application thickness: Minimum 1/3 inch (8 mm) for large areas, local 1/4 inch (6 mm) can be tolerated.</li> <li>Maximum in one layer for large areas, 2 inches (50 mm). Local applications up to 6-10 inches (150-250 mm) are possible.</li> <li>Minimum ambient and surface temperatures 40°F (4°C) and rising at the time of application.</li> <li>Do not use solvent-based curing compounds.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential area of contact by coating aluminum bars, rails, posts, etc. with an appropriate epoxy such as Sikadur* Hi-Mod 32.</li> </ul>
	INS SHI PAI TO	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- T PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
	KEEP	ONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.
	actua	rther information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.
	Prior Data ment for ea	o each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product heet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart- t 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction ch Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to ct use.
	the ci Buye EXPF SHAI THE SALE	varrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on rrent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. is sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES SS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR SE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY MG 201-933-8800.
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1	ka	Nation and Sales Centers. For the location of your hearest state solice, contraction and sales centers.       Sike Canada Inc.         01 Polito Avenue yndhurst, NJ 07071 hone: 800-933-7452 ax: 201-933-6225       Sike Canada Inc.       Sike Mexicana S.A. de C.V.         Phone: 514-697-2610 Fax: 514-694-2792       Phone: 514-694-2792       Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920       Phone: 52 442 2385800 Fax: 52 442 2250537

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Product Data Sheet Edition 7.14.2014 SikaRepair 224

### **SikaRepair**<sup>®</sup> **224** One-component, cementitious, sprayable mortar for structural repairs

Description	SikaRepair 224 is a one-component, pre-packaged, ready-to-use, cementitious, silica fume, fiber reinforced, high strength shrinkage-compensated mortar. Formulated for application by trowel or low pressure spray. It is designed especially for repair of overhead and vertical surfaces.		
Where to Use	<ul> <li>A high performance repair mortar for wet spray application. Suitable for new construction, repairs, and maintenance work. Typical applications include:</li> <li>Structural repair material for water and wastewater treatment plants, parking structures, industrial plants, bridges, tunnels and dams, etc.</li> <li>Use on vertical and overhead surfaces.</li> <li>Use on grade, above, and below grade on concrete and mortar.</li> <li>Potable water tank. (NSF approved in Marion, OH and Santa Fe Springs, CA)</li> </ul>		
Advantages	<ul> <li>Ready-for-use, one-component material.</li> <li>Easy to use; just add water.</li> <li>Sprayable system.</li> <li>Potable water approved.</li> <li>Superior workability. Can be trowelled and screeded after application.</li> <li>Labor-saving system.</li> <li>Superior abrasion resistance over conventional Portland cement mortar.</li> <li>Bond strength ensures superior adhesion.</li> <li>Not a vapor barrier.</li> <li>Compatible with coefficien of thermal expansion of concrete.</li> <li>Increased resistance to de-icing salts.</li> <li>Good freeze/thaw resistance.</li> <li>High early strengths.</li> <li>Very low shrinkage.</li> <li>Silica Fume enhanced.</li> <li>Fiber reinforced.</li> </ul>		
Coverage	Yield in service will vary. Average yield is approximately 0.40 cu. ft./bag. Estimating should be based on prior experience or actual field evaluation.		
Coverage Packaging	<ul> <li>Yield in service will vary. Average yield is approximately 0.40 cu. ft./bag. Estimating should be based on prior experience or actual field evaluation.</li> <li>50-lb. (22.7 kg) multi-wall bags.</li> </ul>		
0	Yield in service will vary. Average yield is approximately 0.40 cu. ft./bag. Estimating should be based on prior experience or actual field evaluation.         50-lb. (22.7 kg) multi-wall bags.         Typical Data (Material and curing conditions @ 73°F and 100% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life         1 year in original, unopened bags.		
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0	Yield in service will vary. Average yield is approximately 0.40 cu. ft./bag. Estimating should be based on prior experience or actual field evaluation.         50-lb. (22.7 kg) multi-wall bags.         Typical Data (Material and curing conditions @ 73°F and 100% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life 1 year in original, unopened bags.         Storage Conditions         Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.         Color Dark gray.         Mixing Ratio       3/4 gallon to 7/8 gallon liquid per 50 lb. bag of material         Density (wet mix)       125 lbs./cu. ft. (2.0 kg./l.)         Compressive Strength (ASTM C-109)         73°F         1 day       4,500 psi (31 MPa)         7 day       8,000 psi (55 MPa)         28 day       10,000 psi (69 MPa)         Flexural Strength (ASTM C-348)         28 day         Direct Tensile Pull off (ACI 503)         28 day       735 psi (5.0 MPa)         Direct Tensile Pull off (ACI 503)       28 day       735 psi (5.0 MPa)         Direct Tensile Pull off (ACI 503)       2		

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How to Use	
Surface Preparation	Substrate must be sound, clean, and free from oil, grease, loose material, surface contaminants and other bond-inhibitin materials. Steel reinforcement must be clean and free from any rust. Be sure repair area is not less than 3/8 in. in depth Preparation work should be done by high pressure water blast, or other appropriate mechanical means, to obtain an expose aggregate surface (CSP-6). Saturate surface with clean water. Substrate should be saturated surface dry (SSD) with n stand-ing water during application. Reinforcing Steel: Steel reinforcement should be thoroughly prepared by mechanical cleaning to remove all traces of rust. Where corrosion has occurred due to the presence of chlorides, the steel should be high-pressure washed with clean water after mechanical cleaning. For priming of reinforcing steel, use Sika Armatec 11 EpoCem (consult Technical Data Sheet).
Priming Mixing	<b>Concrete Substrate:</b> Prime the prepared substrate with a brush or sprayed applied coat of Sika Armate 110 EpoCem (consult Technical Data Sheet). Alternately, a scrub coat of Sika Repair 224 can be applie prior to placement of the mortar. The repair mortar has to be applied into the wet scrub coat before it drie <b>With water:</b> Add the water (approx. 3/4 gal.) directly into mixer. Start the mixer in motion and add the SikaRepair 224 mortar while the start of the start and the sikaRepair 224 mortar while the start of the start and the sikaRepair 224 mortar while the start of the start and the sikaRepair 224 mortar while the start and the sikaRepair 224 mortar w
	continuing to mix. Mix to uniform consistency using a maximum of 7/8 gallons of water per 50 lb. (22.7 kg.) bag (approx. 3 minutes With Latex R: Pour 6-7 pints of Sika Latex R into the mixing container. Slowly add powder and mix as above With Diluted Latex R: Sika Latex R may be diluted up to 5:1 (water: Sika Latex R) for projects requiring minim polymer-modification Pour 6-7 pints of the mixture into the mixing container. Slowly add powder and mix as above SikaRepair 224 Concrete: For horizontal applications greater than 1 inch deep, add 3/8 inch coarse aggregate. Aggregate mus be non-reactive (reference ASTMC1260, C227 and C289), clean, well-graded, saturated surface dry (SSD), have low absorptio and high density, and comply with ASTM C33 size number 8 per Table 2. Addition rate must not exceed 25 lbs. of aggregate/bas of SikaRepair 224 (25 lbs. of 3/8 in. aggregate is approximately 2.0 to 2.5 gal. by loose volume of aggregate). If the placemee is vertical or overhead, temporary support of the material is required. Contact Sika Technical Service for application details
Application	Conventional wet-process shotcreting equipment such as a low-pressure or a high-pressure machine should be used. At time of application, surfaces should be saturated surface dry but hold no standing water. Apply SikaRepair 224 mortar by low pressure spraying or trowelling for repairing vertical or overhead surfaces. Shoot the shotcrete perpendicular to the surface. This minimize rebound, creates the smoothest pattern (reduces 'bumps') and properly encases the rebars. The velocity of the shotcrete is surficien if, at a distance of 18 to 24 in., the shotcrete pattern flatten out on contact with the surface and the rebars are encased. After applying the shotcrete, allow it to stiffen for about 10 minutes before removing bumpy areas with a trowel. Before applyin the next layer, allow the shotcrete to reach initial set. This will take anywhere from 45 minutes to several hours, depending o mix consistency, mix and ambient temperature, wind conditions and humidity. Begin and finis a given patch on the same date the surface and the mathematical set.
Tooling and Finishing	g As per ACI recommendations for portland cement mortar, curing is required when jobsite conditions warrant. Moist cure wit wet burlap and polyethylene, a fine mist of water or a water based* compatible curing compound. Curing compound adversely affect the adhesion of following layers of mortar, leveling mortar or protective coatings. Moist curing shoul commence immediately after finishing Protect newly applied material from direct sunlight, wind, rain and frost. *Pretesting of curing compound is recommended.
Limitations	<ul> <li>Application thickness:</li> <li>Minimum 3/8 inch (9 mm).</li> <li>Vertical applications:</li> <li>SikaRepair 224 can be spray applied up to 2" thickness in one lift.</li> <li>Overhead applications:</li> <li>The thickness should be no more than 1 to 1.5" per pass. If repair requires several lifts (over 1.5"), each lift should be applied as soon as the previous lift will support it.</li> <li>General:</li> <li>For additional information, consult Technical Service.</li> <li>Minimum ambient and surface temperatures 40°F (4°C) and rising at the time of application.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur Hi-Mod 32.</li> </ul>

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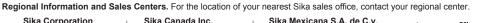
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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# Sikacrete<sup>®</sup>-213F Fire protection mortar

Pre-bagged, cement-based, fire protection mortar. Protects FRP/ epoxy from exposure due to high temperatures of fire.

<ul> <li>hazards. It contains phyllosilicate of hydrocarbon fires. The thicknes specified fire resistance. The outs thickness of the fire protection lat</li> <li>Pre-bagged, dry mortar mix for</li> <li>Minimal layer thickness to mee</li> <li>Easy to apply.</li> <li>Lightweight, low density.</li> <li>Does not require reinforcementions.</li> </ul>	application by wet spray process. t specifications.	
<ul> <li>Minimal layer thickness to mee</li> <li>Easy to apply.</li> <li>Lightweight, low density.</li> <li>Does not require reinforcementions.</li> </ul>	t specifications.	
<ul> <li>Pre-bagged, dry mortar mix for application by wet spray process.</li> <li>Minimal layer thickness to meet specifications.</li> <li>Easy to apply.</li> <li>Lightweight, low density.</li> <li>Does not require reinforcement up to 40 mm (1.57 in.) thick except for overhead applica-</li> </ul>		
Consumption Approx. 6 kg/m2 for a layer thickness of 10 mm. Approx. 6 sf/12 kg bag for layer thickness of 40 mm (1.57 in.)		
26.46 lb bag (12 kg)		
RESULTS MAY DIFFER BASED UPON STATIST	ns @ 73°F (23°C) and 50% R.H.) CAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, AL SITE CONDITIONS AND CURING CONDITIONS.	
Self Life: Density: pH Value: Layer Thickness:	1 Year in original, unopened packaging in cool and dry conditions.         Powder:       Approx. 0.46 kg/l         Fresh applied:       Approx. 1.17 kg/l (sprayed)         Applied after 28 days:       Approx. 0.61 kg/l (sprayed)         12.0 -12.5       40 mm (1.57 in.)	
Mechanical / Physical Properties Compressive Strength: Freeze/Thaw/De-Icing: Thermal Conductivity:	Approx. 2.0 N/mm In order to guarantee resistance to frost, freeze thaw cycles and de-icing salts, the Salt Resistance surface of the mortar must be treated with Sikagard-Wallcoat T. Approx. 0.23 W/mK at +10°C	
	103C/230C fabrics - UL File BXUV.N857 - fabrics - UL File BXUVC.N85 -ULC File BXUVC.N81 SikaWrap® 103C/230 - ULC File BXUVC.N81 fabrics - ULC File BXUVC.X8 Independently assessed by UL durance Tests of Building Cons Test Methods of Fire Tests of B Fire-resistance ratings tested in Consumption Approx. 6 kg/m2 for Approx. 6 sf/12 kg bag for layer th 26.46 lb bag (12 kg) Typical Data (Material and curing condition RESULTS MAY DIFFER BASED UPON STATISTIC APPLICATION METHODS, TEST METHODS, ACTU Self Life: Density: PH Value: Layer Thickness: Mechanical / Physical Properties Compressive Strength: Freeze/Thaw/De-Icing:	

Application Ario State S	container. Add 1 bag (12 kg) Sikacrete-213F powder slowly while mechanically mixing, using a heavy duty, low speed drill (300 – 450 rpm) with a mud mixer or other suitable baddle. Mix to a uniform consistency for a minimum of 3 minutes. Mixing can also be done in a mortar mixer setup for a direct feed in to wet shotcreting equipment, maintaining the same mixing requirements as when mixing with a drill. Once mixed, if a wetter consistency is required, increase the water content up to a maximum of 3 gallons, 4 pints (14 liters). <b>Note:</b> Do <b>not</b> overwater as excessive water will cause severe bleeding, retardation and will educe the strength and performance of the mortar. Extending ("bulking") the mortar with additional aggregate or adding any other material into the mix is not permitted as this may mpact the fire resistance of the mortar. At the time of application, the concrete substrate must be SSD (saturated surface dry) with no surface water visible. FRP Composite and steel surfaces should be dry and clean. Resingurfaces must have an acceptable contact surface to which the mortar will adhere. Sikacrete <sup>®</sup> -213F is applied by the wet-spray, dense stream or wet-spray, thin stream method (for vertical/overhead surfaces). Position spray nozzle 18 – 24 inches (450 – 600 mm) perpendicular to the surface. This will minimize rebound, create a smoother finished surface and will falten but when applied at the proper pressure. Allow Sikacrete <sup>®</sup> -213F to set sufficiently before fin-
Application At out is contained of the system of the syste	At the time of application, the concrete substrate must be SSD (saturated surface dry) with no surface water visible. FRP Composite and steel surfaces should be dry and clean. Resin surfaces must have an acceptable contact surface to which the mortar will adhere. Sikacrete®- 213F is applied by the wet-spray, dense stream or wet-spray, thin stream method (for vertical/ overhead surfaces). Position spray nozzle 18 – 24 inches (450 – 600 mm) perpendicular to he surface. This will minimize rebound, create a smoother finished surface and will flatten but when applied at the proper pressure. Allow Sikacrete®-213F to set sufficiently before fin- shing or scraping to the desired lines. When application requires an aesthetic or protective
nd st 2' ov th ot is cc A	no surface water visible. FRP Composite and steel surfaces should be dry and clean. Resin surfaces must have an acceptable contact surface to which the mortar will adhere. Sikacrete®- 213F is applied by the wet-spray, dense stream or wet-spray, thin stream method (for vertical overhead surfaces). Position spray nozzle 18 – 24 inches (450 – 600 mm) perpendicular to the surface. This will minimize rebound, create a smoother finished surface and will flatter but when applied at the proper pressure. Allow Sikacrete®-213F to set sufficiently before fin- shing or scraping to the desired lines. When application requires an aesthetic or protective
Sy	
-	Application equipment should include wet-spray, screw pump systems such as an Aliva® rotor system, Putzmeister®, Bunker® spray concrete system or similar.
	To achieve the optimum physical characteristics, the spray nozzle must be handled by a rained and experienced operator.
pl	Where a risk of vibration or mechanical damage to the surface exists and for overhead ap- plications, the use of a light wire mesh reinforcement is recommended in order to prevent any debonding of the mortar layer.
Tooling and finishing A W R us of A be do	Application equipment: Wet Spray Screw pump. Reinforcement: Where there is a risk of vibration or mechanical damage to the surface, the use of a light wire mesh reinforcement is recommended in order to prevent any debonding of the mortar layer. As per ACI 308 requirements for cementitious materials, curing is required. To achieve performance consistent with the properties on this technical data sheet, curing must be done by recognized curing methods such as mist spray or water/damp burlap, white poly-
	ethylene film or approved curing compound. Curing must start immediately after finishing. Protect freshly applied mortar from direct sunlight, wind, rain and frost.
	■ Substrate Temperature +5°C min. / +35°C max.
	<ul> <li>Ambient Temperature +5°C min. / +35°C max.</li> <li>The surface of the freshly applied mortar can be finished for up to one hour after ap-</li> </ul>
-	<ul> <li>plication dependent on the temperature and humidity.</li> <li>Wire mesh reinforcement required when applied in thicknesses greater than 40 mm (1.57 in.) and for overhead applications.</li> </ul>

- Sikacrete®-213F must not assume any load-bearing function
- Sikacrete®-213F is a sacrificial layer and must be replaced in the event of a fire
- Sikacrete®-213F must not be exposed to weathering (frost, freeze/thaw, moisture) without additional protection

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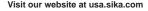
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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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C.P. 76920



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Product Data Sheet Edition 11.20.2015 SikaTop® Seal 107

### **SikaTop® Seal 107** Flexible, waterproofing and protective slurry mortar

Description	SikaTop <sup>®</sup> Seal 107 is a two-component, polymer-modified, cementitious waterproofing and protective slurry mortar for concrete. It is slightly flexible to tolerate fine cracks and suitable in both interior and exterior applications.		
Advantages       SikaTop® Seal 107 provides the following beneficial properties:         Improves the watertightness of water-containing concrete tanks, reservoirs, and clearwells.         Protects against water penetration, yet water vapor permeable (breathable).         Excellent freeze/thaw resistance.         Good adhesion to sound, prepared substrates.         Easy and fast mixing and application.         Good abrasion resistance.         Protects against concrete carbonation (80 mils SikaTop® Seal 107 is equivalent to 6 inches of concret         Can be mixed to slurry or trowelable consistency.         Improves concrete/masonry appearance.         Available in concrete gray and off-white.         SikaTop® Seal 107 is ANSI/NSF 61 potable water compliant.         Where to use         Horizontal surfaces subjected to light foot traffic (balconies).         For waterproofing of drinking water, tanks, reservoirs, and clear wells.			
	<ul> <li>For internal and external waterproofing and damp-proofing concrete, mortar blockwork and brickwork.</li> <li>For protection of concrete structures against the deleterious effects of deicing salts and freeze/thaw cycles.</li> <li>For sealing "hairline" cracks in concrete structures not subject to movement surfaces.</li> <li>For interior and exterior waterproofing of basements.</li> <li>Vertical surfaces.</li> </ul>		
Coverage	<ul> <li>For damp-proofing: apply one coat at 40 mils.</li> <li>For waterproofing: apply two coats at 40 mils per coat. Theoretical thickness (wet film) on smooth substrates: 40 ft.<sup>2</sup>/gal. = 40 mils (2 kg./m<sup>2</sup> = 1 mm). The above figures are theoretical and do not allow for substrate profile and wastage. Three coats may be required in areas of extremely high water infiltration.</li> </ul>		
Packaging	44 lb. unit - when mixed yields 2.65 gallons (10 l)		
	Component 'A' - 1 gal. plastic jug; 4/carton. Component 'B' - 35.5 lb. multi-wall bag.		
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)		
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.		
	Shelf Life 1 year when unopened.		
	Storage Protect Component 'A' from freezing and Component 'B' from moisture.		
	Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°-75°F conditions before using.		
	Colors         Concrete gray and off white.           Mixing Ratio         Component 'A': Component 'B'. Slurry consistency 1:4.1 by weight (full unit)		
	Trowelable consistency 1:4.5 by weight (90% liquid to full bag)		
	Density (wet mix)125 lbs./ft.3 (2.0 kg./l.) = 16.6 lbs./gal.Working TimeApproximately 60 minutes at 68°F; Approximately 30 minutes at 86°F		
Compressive Strength (ASTM D-695) @ 28 days         Type White       3,000 psi (20.7 MPa)         Type Gray       3,400 psi (23.4 MPa)			
	Tensile Strength (ASTM C-307) 28 daysWhite870 psi (6.0 MPa)Gray990 psi (6.8 MPa)		
	Bond Strength (ACI 503R-30 Modified): Pull-off Test       28 days       180 psi (1.25 N/mm²)         Flexibility (ASTM D522 modified)       Approximately 25%         Water tightness under hydrostatic pressure (DIN 1048 mod.)         Water Pressure feet (bar)       Penetrated Water grains (grams)         grains (grams)       grains (grams)		
	$ft^2 \cdot hours (m^2 \cdot hours)$ 16 (0.5) 0 (0) 0 (0)		
	33 (1) 15 (1) 3 (2)		
	99 (3) 31 (2) 10 (7)		
	Rendering mortars absorbing less than 91 grains/ft. <sup>2</sup> • h (64 grams/m <sup>2</sup> • h) are considered watertight.		
	Vapor Permeability (ASTM E-96)       U.S. perms: 28 days       18 (not a vapor barrier)         Carbon Dioxide Diffusion       Coefficient (μCO2)       Approximately 35,000, equivalent to 6 inches of concrete         Water Vapor Diffusion       Coefficient (μH2O)       Approximately 500 ("breathable")		
ka	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND NSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- ARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION O READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-		

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How to Use	
Substrate Preparation	Concrete, mortar and masonry surfaces must be clean, free from grease, oil and loosely adhering particles. All surfaces must be as true and flat as possible. An open-textured, sandpaper-like substrate is ideal (CSP-3). All surfaces must be saturated surface dry (SSD), with no standing water at time of application. It is necessary to stop water ingress prior to the application of SikaTop <sup>®</sup> Seal 107. Use a quick setting, waterproof slurry (SikaSet <sup>®</sup> ) to seal water leaks.
Mixing	The consistency of the mix can be altered by reducing the amount of Component 'A' (liquid) to be used. Under normal circumstances, when the full quantities of both components are mixed together, a slurry consistency will result. For a trowel- able consistency use only 90% of component 'A'. Mix in a clean container by slowly adding the powder component to the liquid component and mixing with slow speed drill and mixing paddle.
Application	SikaTop <sup>®</sup> Seal 107 can be applied by trowel, notched trowel, stiff bristle, or spray equipment. Work the material well into the prepared substrate, filling all pores and voids.
	For brush consistency: Apply the first coat of SikaTop <sup>®</sup> Seal 107 with horizontal brush strokes and leave to harden (4 to 8 hours). Apply the second coat with vertical brush strokes.
	For trowel consistency: Apply the first coat with a notched trowel and leave to harden (4 to 8 hours). Apply the second coat with a flat trowel.
	<b>For spray application:</b> Use a hopper gun spray equipment, textured sprayer (e.g. Texspray E110c), or a rotor/stator pump equipment. Allow the first coat to harden (4 to 8 hours) prior to the application of the second coat. As soon as the mortar layer starts to set, a uniform surface texture can be obtained by rubbing the surface with a fine sponge or a plastic trowel. Do not overwork SikaTop® Seal 107 during finishing and avoid the use of additional water. [Where required, a third coat of SikaTop® Seal 107 may be applied no later than 24 hours after the second coat (in this case, do not trowel or sponge finish the second coat). If intercoat period exceeds 24 hours, light grit blasting is required prior to further application].
	<b>Balcony Waterproofing Layer:</b> Fill in any spalled areas in the existing substrate with the appropriate Sika repair mortar as required. Apply an appropriately sized closed cell backer rod along transition (wall-slab) to prevent three-sided adhesion. Apply a continuous cant bead of Sikaflex® 11-FC or Sikaflex® 2C, to a depth of 1/8" minimum and 1/2 inch thickness. Allow sealant to cure sufficiently. Substrate must be SSD with no standing water at time of application. Apply a 1/16" thick layer of SikaTop® Seal 107 over the entire balcony. While the material is still wet apply a "360 degree pull" non-alkaline, woven fiberglass mesh to reinforce the 107 layer along static hairline cracks, wall to slab transitions and patched areas. Using trowels remove any wrinkles in the mesh by forcing down into the SikaTop® Seal 107. Ensure the mesh is completely embedded and covered with SikaTop® Seal 107. If any areas are not covered apply additional SikaTop® Seal 107 over top of mesh to cover. Trowel to a smooth uniform finish. Allow curing so that surface can take foot traffic without harming the coating.
Tooling & Finishing	Curing: As with all cement based products, curing is important. Protect newly applied product against direct sunlight, wind, rain and frost.
Limitations	<ul> <li>If rain is anticipated within 1-2 days after application, the surface should be protected in order to prevent streaking.</li> <li>Not an aesthetic coating.</li> <li>Minimum ambient and substrate temperatures are 45°F (7°C) and rising at the time of application.</li> <li>Maximum application thickness per coat = 80 mils (2 mm). Do not apply less than 20 ft.²/gal. = 1 m²/liter.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> <li>Allow 2 days of air curing before subjecting SikaTop<sup>®</sup> Seal 107 to submersion.</li> </ul>

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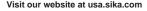
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452

Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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Product Data Sheet Edition 9.29.2015 Sika<sup>®</sup> Primer MB

# Sika<sup>®</sup> Primer MB

Solvent Free, Epoxy Primer and Moisture Barrier for use with SikaBond Adhesives, SikaLevel underlayments and other flooring systems on critical substrates

Description	Sika Primer MB is a 2-component, solvent-free, low-viscosity, epoxy primer for use with under ALL flooring products, wood, carpet, vinyl, LVT, self-leveling underlayments, floating floors, and other flooring systems that require protection from sub-floor moisture.		
Where to Use	Moisture barrier to help control moisture propagation in cementitious substrates with a moisture content not exceeding 6% by Tramex Method and residual moisture up to 100% R.H. or 25 lbs./1000 sq.ft./24 hrs.		
	For substrate consolidation on concrete, cement and gypsum screeds.		
	Adhesion promoter for old and new adhesive residues in conjunction with other Sika products.		
Advantages	<ul> <li>Solvent-free (100% solids)</li> </ul>		
	<ul> <li>Easy roller applied application, low viscosity</li> </ul>		
	<ul> <li>Convenient, easy to mix packaging</li> </ul>		
	Shorter construction periods		
	Excellent penetration and stabilization of the substrate		
	Reduction of adhesive consumption		
	Suitable for use on floors with radiant heating		
	<ul> <li>Compatible with SikaBond wood flooring adhesives, SikaLevel MB Excel, and other underlay ment systems</li> </ul>		

Can be used below floating floors

**Typical Data** (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf life	f life 2 years from date of production if stored properly in undamaged sealed containers	
Storage ConditionsStore dry at 50°F (10°C) - 77°F (25°C)		
Color Blue tint		
Viscosity		
Chemical Base Two component epoxy		
<b>Density</b> 9.14 lbs/gal (1.1 kg/l)		
Cure Time Minimum curing time, prior to walking on primer/or for applying SikaBond		
Adhesives:		
	at 50°F (10°C) 18 hours	
	at 73°F (23°C) 8 hours	
	at 86°F (30°C) 6 hours	
* When Sika Primer MB is left on the substrate for more than the maximum allowable open time at 36 hours prior to placing adhesive, the surface must be mechanically prepared (i.e. sanded) solvent wiped before proceeding.		
Service Temperature	-40°F to +158°F	
Compressive Strength	10,000 psi (after 7 days, at 73°F [23°C] and 50% RH)	
Shore D Hardness 83 (after 7 days at 73°E [23°C] and 50% RH) (mixed A&B)		

 Shore D Hardness
 83 (after 7 days, at 73°F [23°C] and 50% RH) (mixed A&B)

 Water Vapor Permeability
 0.06 g/m2-24hour-mmHG

per ASTM E-96 Standard Test Method of Water Vapor Transmission of Materials



Coverage	250-300 sq.ft. per pail, depending on substrate porosity				
	When used as an adhesion promoter or surface consolidator alone, coverage will be approximitly 400-450 sq.ft. per pail depending on substrate.				
	<ul> <li>MUST produce a monolithic, pinhole-free finish with a continuous film. The need for multiple coats is directly related to surface absorption. Dense substrates can consume less material and absorbent substrates can consume more material.</li> </ul>				
Packaging	2.64 gallon pails				
How to Use					
Surface Preparation	Substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust, and loose or friable particles. Paint, laitance, and other poorly adhering contents must be mechanically removed.				
	<ul> <li>Substrate must have an open textured surface to allow Sika Primer MB to penetrate. (i.e. Blast cleaning, grinding are considered acceptable means to achevie the desired surface profile but. Acid and chemical etching are not acceptable)</li> </ul>				
	At least 50 % of the surface area must be cleared of residual adhesive and cutbacks. (i.e. by grinding or mechanical substrate preparation)				
	<ul> <li>Minimum compressive strength &gt; 1160 psi. Tensile Bond strength &gt; 116 psi.</li> <li>The floor must be cleaned with an industrial vacuum prior to installation of the Sika Primer MB. Consult level/patch system manufacturer regarding priming prior to the placement of materials.</li> <li>Applicator must always verify that preparation of the surface is sufficient prior to using Primer MB or patch/level compound.</li> </ul>				
	On fiber reinforced concrete, fibers should be flamed off the surface prior to application of Sika Primer MB as a moisture barrier.				
	Please contact Sika Technical Service for any questions related to your project.				
	<b>Conditions/Limits:</b> Substrate temperature during laying and until Sika® Primer MB has fully cured should be above 50°F (10°C) and in case of radiant floor heating below 86°F (30°C). Application temperature of substrate must be minimum 5°F (3°C) above the measured dew point temperature. Substrate Humidity: Subfloor moisture content should not exceed 6% when measured with a Tramex moisture meter or 4% when measured using the CM method.				
Mixing	Add one full can of Component A to one full can of Component B then mix with an electric drill and mixing (Jiffy Mixer type) paddle at a low speed to reduce air entrainment (300-400 rpm). Using a paint stick or similar is not sufficient to mix the primer. A minimum mixing time of 3 minutes shall be observed; mixing shall continue until a homogeneous mix has been achieved. Scrape sides of pail with paint stick or paddle to ensure all contents are thoroughly mixed together. Unmixed material applied to the floor will not cure properly.				
Application	<ul> <li>Apply Sika Primer MB uniformly (in 2 directio ensuring that a continuous coat is achieved finish)</li> </ul>				
	Pour contents of pail onto the floor for best working time. Attempting to work from the pail will reduce working time.				
	Application	Recommended Coatings	Results in		
	Moisture barrier only	Minimum 1x	Mirror like finish		
	Substrate consolidation only	Minimum 1x	Good penetration		
	Adhesion promotion only	Minimum 1x	Mirror like finish		
	Moisture barrier + substrate consolidation Minimum 2x Mirror like finis		Mirror like finish		
	Moisture barrier + adhesion promotion	Minimum 2x	Mirror like finish		
	A waiting time of > 8 hours and < 36 hours must be observed between coats of Sika Primer MB				

When used as a primer for helping moisture mitigation in cement substrates prior to applying SikaLevel-125 & SikaLevel-315, prepare the substrate mechanically as in accordance with the guidelines stated in subtitle "Substrate Preparation". Apply the first coat at 75-115 sq. ft. gal. Apply the second coat at 150-225 sq. ft. gal. after a minimum of 8 hours and a maximum of 36 hours after the first coat is applied. Broadcast to refusal oven dried silica sand (20/30) on the second coat immediately. Sweep sand once the epoxy is cured. Apply SikaLevel-125 / 315 on cured epoxy

Alternately, when used in conjunction with the SikaLevel MB Excel system, prepare the substrate mechanically as in accordance with the guidelines stated in subtitle "Substrate Preparation". Apply the first coat at 75-115 sq. ft. gal. Apply the second coat at 150-225 sq. ft. gal. after a minimum of 8 hours and a maximum of 36 hours after the first coat is applied. Apply SikaLevel 02 EZ Primer at 350-500 sq. ft. gal. after a minimum of 8 hours and a maximum of 36 hours after the second



	Pot Life (Max. open time), If primer is left in pail after mixing:
	at 50°F (10°C) $\sim$ 60 minutes
	at +68°F (20°C) ~ 30 minutes
	at +86°F (30°C) ~ 15 minutes
Removal	Clean all tools and application equipment with cleaning solvent (Xylene, MEK are effective). Hardene cured material can only be removed mechanically.
-imitations	<ul> <li>Proper coverage must be used to achieve moisture barrier properties.</li> <li>Sika Primer MB will not act as a moisture barrier for gypsum screeds.</li> <li>Sika Primer MB only protects from moisture coming from below the concrete.</li> <li>Sika Primer MB does not prevent moisture or acclimation, e.g. water condensation.</li> <li>Sika Primer MB is not suitable for use with bonded systems due to possible curing and adhesion problems.</li> <li>Gypsum based sub-floors are very susceptible to excess moisture and will be degraded if exposed to excess moisture from below or above.</li> <li>Sika Primer MB will not prevent damage to gypsum based sub-floors that are exposed to excess moisture levels.</li> <li>Sika recommends the use of Portland Cement underlayments for best results. Consult level/ patch system manufacturer regarding priming and other application/limitation guidelines prior t the placement of materials.</li> <li>Sika Primer MB will not prevent hydrostatic pressure.</li> <li>Floor covering manufacturer's and Wood flooring manufacturer's recommendations, like room humidity levels and wood acclimation requirements should be strictly followed.</li> <li>Sika Primer MB must not be applied to a visibly wet substrate.</li> <li>When Sika Primer MB is left on the substrate for more than the maximum allowable open time of 36 hours, prior to placing the adhesive, the surface must be thoroughly cleaned and mechanically prepared (i.e. screened sand) and solvent wiped. Failure to do this, may result ir adhesion problems. For detailed instructions consult the Product Data Sheets or contact our Technical Service. When used in conjunction with SikaBond Wood Floor Adhesives</li> </ul>
	and floating floors, Sika Primer MB does not need to be broadcasted with sand.

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 10.1.2014 SikaLevel®-01 Primer

# SikaLevel<sup>®</sup>-01 Primer

Concrete primer and sealer for use with SikaLevel<sup>®</sup>-125 and SikaLevel<sup>®</sup>-315.

Description	SikaLevel® -01 Primer is a one-part, water-dispersed and solvent-free, acrylic-based solution used to prime and seal floor surfaces prior to the application of SikaLevel®-125 and SikaLevel®-315 underlayment.		
Where to Use	Use as a primer/sealer for absorbent substrates including concrete and cement screeds. Particularly suitable as an adhesion promoter and surface sealer beneath SikaLevel®-125 and SikaLevel®-315, enhancing the bond and integrity of the underlayment when applied onto porous substrates.		
Advantages	<ul> <li>Ready to use, no dilution required.</li> <li>Water-based and solvent-free.</li> <li>Penetrates substrate to reduce outgassing and formation of bubbles in the underlayment.</li> <li>Prevents water loss from the underlayment into the substrate.</li> <li>Quick-drying and fast film formation to increase productivity.</li> <li>Achieves excellent bond values throughout the recommended range of application temperatures.</li> <li>Effectively seals concrete surfaces in a single, economic operation.</li> </ul>		
Coverage	Approximately 325 to 500 ft. <sup>2</sup> gal or 8 to 10 m <sup>2</sup> /ltr approximately. Coverage figures do not include allowa for surface profile and porosity or material waste.		
Packaging	1 U.S. gal. jug		
	RESULTS MAY DIFFER BASE	<ul> <li>cial and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DUPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, NM METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>2 years in original, unopened container. Protect from high heat and freezing; if frozen, discard.</li> </ul>	
	Storage Conditions	Store dry at 40°-77°F (5°-25°C). Condition material to 65°-75°F (18°-24°C) before using.	
	Specific Gravity	approx. 1.02 kg/ltr.	
	Solids Content	23%	
	Drying time	<2 hours	
	Recoat Time	Allow previous coats to become tack-free before applying additional coats	
	Bond Strength	>217 psi (>1.5 MPa) (substrate failure)	
	VOC (EPA method 24)	< 10 g/L	

### How to Use

Surface Preparation

The substrate must be dry, clean and sound before priming and applying the underlayment materials. Remove all existing treatments such as coatings, sealers, wax, latex compounds, impregnations and curing agents, together with all contaminants i.e. dirt, dust, laitance, grease, oils, and foreign matter, which will interfere with the penetration of a primer and the adhesion of an underlayment. Prepare concrete and cement substrates by mechanical means, such as shotblasting, sandblasting, waterjetting, scarifying, or other appropriate methods, to achieve an open-textured, fine- gripping surface (ICRI - CSP 3 minimum). Weak concrete should be removed and surface defects such as blowholes and spalls fully exposed and repaired with a suitable Sika mortar prior to priming and levelling. All cracks and holes should be similarly filled to prevent loss of coverage or seepage of the primer through to lower areas. Consult Sika Technical Service for recommendations.

All loose friable material, including preparation residue, must be completely removed using a vacuum before application of the SikaLevel®-01 Primer. The compressive strength of the concrete substrate should be at least >3000 psi / 20.7 MPa at 28 days with a minimum tensile strength of >145 psi / 1.0 MPa at the time SikaLevel®-01 Primer is applied. Moisture vapor emission rates of the substrate should comply and meet the requirements of the proposed floor covering. Please consult the manufacturer of the final floor finish for recommendations. Careful consideration should be given to the selection of the method of mechanical surface preparation and the



timing of the primer a	nd the underlayment application . Immediately following mechanical preparation on some excessively porous substrates, Outgassing will increase for a short period of time (approx. 48 hours) until an equilibrium in slavapor pressure and the ambient environment is reached. Before overall installation begins, Sika recommend the application of several small test patches to determine primer application requirements and acceptability of final product performance. In general a one-coat application of the SikaLevel®-01 Primer should be sufficien however, allowance should be made for double priming on excessively porous substrates. Where multiplicoats are required, do not apply excessive material.		
Mixing	efore applying SikaLevel <sup>®</sup> -01 Primer, thoroughly shake the container in which the material is supplied to gitate the contents, ensure all solids are distributed throughout the dispersion and a uniform consistency achieved.		
Application	Ensure that both concrete/cement based substrates and ambient temperatures are between (50°F)10°C 95°F(35°C) before commencing the application of SikaLevel®-01 Primer. The stated application temperature are to be achieved before priming and should be maintained for a period of at least 3 days after installation of the underlayment. Should colder conditions prevail, make allowance for the use of indirect and vented hear ers to achieve and maintain the application temperature required. Where temperatures exceed 86°F(30°C refer to and follow ACI hot weather application and protection guidelines.		
Tooling & Finishing	Apply SikaLevel <sup>®</sup> -01 Primer by brush or roller (long nap roller for rougher surfaces), working the ma the prepared substrate. Typically, one single application is required; however, porous substrates ma two or more coats of primer to effectively seal the surface. Ensure coverage is at most 325 to 500 ft²/U to 12 m²/ltr per coat, depending upon the substrate, but ponding of the primer on the surface must be and puddles must be removed. Where multiple applications are necessary to seal the surface, allow coats to become tack-free before applying additional primer. When first applied, SikaLevel <sup>®</sup> Primer white; once dry, it is clear. This facilitates quality control in terms of complete coverage and clearly when the underlay can be installed.		
Over Painting	To ensure proper adhesion, SikaLevel®-125 and SikaLevel®-315 underlayment is applied within 24 I the application of the SikaLevel®-01 Primer, but only once the primer is clear (without milky spots) are the touch (typically after a minimum of 2 hours drying time under normal environmental conditions) temperatures and/or humid conditions may extend the drying time between priming coats or before ins of the underlayment.		
Limitations	<ul> <li>For interior use only. Primer developed for SikaLevel<sup>®</sup>-125 and SikaLevel<sup>®</sup>-315.</li> <li>Condition material to 65-75°F (18-24°C) before using.</li> </ul>		
	<ul> <li>Do not apply to substrates at temperatures below +(50°F)10°C as this will slow the drying and effectivenes of the primer.</li> <li>Do not apply where the relative humidity of the substrate exceeds 75% as this will limit the efficiency of the</li> </ul>		
	<ul> <li>Do not apply where the relative humidity of the substrate exceeds 75% as this will limit the enciency of the primer.</li> <li>The substrate should be surface dry with relative humidity of surrounding air low enough to allow efficiendrying of the primer.</li> </ul>		
	<ul> <li>Ponding of the primer must be avoided; ensure even distribution by brush or roller to work the primer interest the substrate.</li> </ul>		
	<ul> <li>Low temperature or high humidity will extend the drying time and the waiting time before applying the underlayment.</li> <li>SikaLevel<sup>®</sup>-01 Primer does not form a moisture barrier. For proper moisture mitigation, consult Sika Techni</li> </ul>		
	cal Services.		

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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CAUTION	IRRITANT. May cause eye and skin irritation.		
Handling & Storage	Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.		
First Aid	Eyes – Hold eyelids apart and flush thoroughly with water for 15 minutes. Skin – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. Inhalation – Remove to fresh air. Ingestion – Do not induce vomiting. Dilute with water. Contact physician. in all cases, contact a physician immediately if symptoms persist.		
Clean Up	Use personal protective equipment (chemical resistant gloves/ goggles/clothing). Without direct contact, sweep up spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable local, state, and federal regulations. Hardened material may have to be manually or mechanically removed.		

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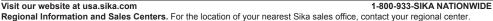
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## Sika<sup>°</sup> Level-02 EZ Primer

Acrylic Primer for use with Sika® Level underlayments on difficult substrates

Description	Special Acrylic Primer for use on sound, smooth and non-porous substrates in interior areas. Applied prior to the use of Sika <sup>®</sup> Level underlayments and patching compounds on epoxy, ceramic tiles, old vinyl, linoleum, rubber and other coverings.			
Where to Use	Sika <sup>®</sup> Level-02 EZ Primer is s	a° Level-02 EZ Primer is suitable for use on:		
	<ul> <li>Smooth and sound substrates e.g.: terrazzo, ceramic tiles, natural stone covering</li> <li>Epoxy based moisture control membranes</li> <li>Old coatings and sealers</li> <li>Old, smooth and sound concrete surfaces</li> <li>Metal substrates e.g. channelled plate</li> <li>Well fitted, vacuumed and sanded vinyl, linoleum and rubber coverings in domestic areas</li> <li>Thermoplastic and semi-flexible tiles</li> <li>Well fitted quartz-vinyl coverings in domestic and commerical areas</li> </ul>			
Advantages	<ul> <li>Increased bond to substrate</li> <li>High coverage</li> <li>Single component; ready for use</li> <li>Quick dry time</li> <li>Low VOC</li> <li>Solvent-free</li> <li>Suitable for use with radiant heating</li> <li>Low odor</li> </ul>			
Coverage	Unit yields approx. 350 - 500	) sq.ft. per gallon depending upon actual porosity of the prepared substrate.		
Packaging	1 gal. pail			
Product Shelf Life	1 year in original, unopened container			
Product Storage	Store in cool, frost-free conditions with temperatures above 40°F (4.5°C)			
	RESULTS MAY DIFFER BASED UPON	nd curing conditions @ 73°F (23°C) and 50% R.H.) STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, AP- IS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.		
	Basis	Acrylic dispersion with additives		
	Color	Mint		
	Drying time	Approx. 1 - 2 hours prior to application of underlayments		
	Storage temperature Application temperature Temperature resistance	Between 40°F - 95°F (5°C - 35°C) Between 40°F - 95°F (5°C - 35°C) Up to 122°F (50°C)		
How to Use				
Surface Preparation	Subfloors must be smooth, sound, clean, dry and free of any contaminants which may hinder adhesion Surface treatments or any "friable" areas of the subfloor must be mechanically removed and the subfloor repaired with Sika leveling compounds as required. On absorbent substrates use Sika Primer MB. All slad on or below grade level must be known to have an intact vapor retarder directly beneath or on top of the concrete in conformance to the relevant standards. If moisture readings are above 75%RH or 3 lbs./100 sq.ft./24 hrs. then use of Sika Primer MB is recommended to suppress residual moisture (see data sheet Old water-soluble adhesives should be removed completely; old water-resistant adhesives should be m chanically removed as far as possible. The complete mechanical removal of cutback (i.e. grinding, sandin blasting) can be hazardous as old cutback adhesive may contain asbestos. Do not sand or grind adhesive residue. Harmful dust may result. Inhalation of asbestos dust may cause asbestosis or other serior bodily harm. Please consult the adhesive manufacturer and all applicable government agencies for rule			
R _				



	and regulations concerning the removal of flooring and adhesives that contain asbestos. Prime remaining adhesive residues accordingly.
	<b>Old vinyl, linoleum and rubber coverings (up to 2.5 mm).</b> Substrates consisting of old vinyl coverings with cushioned backings are not suitable. In heavy loaded areas (e.g. hospitals), laying on top of old coverings is not recommended. Soft old coverings are not suitable for installation of parquet. Please consult Sika technical service. Old coverings must be well fitted to the substrate. Poorly attached coverings should be removed. Vinyl, linoleum and rubber coverings should be thoroughly cleaned and sanded. Quartz vinyl coverings should be cleaned thoroughly. As it is only possible to partially test the full surface bond on old coverings, especially on larger surfaces, we recommend that a mock be installed prior to total application.
Mixing	Prior to installation, stir Sika® Level-02 EZ Primer before use for consistent dispersion. Apply undiluted.
Application	Apply primer with a suitable tool, e.g. a 1/4" nap roller, paintbrush or brush, short-pile roller or pad applicator. Avoid formation of puddles. Ensure that both concrete/cement based substrates and ambient temperatures are between 40°F - 95°F (5°C - 35°C) before commencing the application of Sika® Level-02 EZ Primer. The stated application temperatures are to be achieved before priming and should be maintained for a period of at least 3 days after installation of the underlayment. Should colder conditions prevail, make allowance for the use of indirect and vented heaters to achieve and maintain the application temperature required. Where temperatures exceed 86°F(30°C), refer to and follow ACI hot weather application and protection guidelines. Clean tools in water immediately after use. Apply SikaLevel underlayments or reprofiling mortars once SikaLevel 02 EZ is dry to the touch, typically 1-2 hours after primer application
Limitations	<ul> <li>For interior use only. Not to be used as a primer for Sikafloor resins</li> <li>Do not apply to substrates at temperatures below 41°F (5°C) as this will slow the drying and effectiveness of the primer.</li> <li>Do not apply Sika* Level-02 EZ Primer or Sika* Level underlayments onto chipboard, particle board, hardboard, metal, gypsum or dimensionally unstable substrates.</li> <li>Where substrates exhibit a Tramex reading over 4% or a Moisture Vapor Emission Rate (MVER) of over 3 lbs. per 1,000 ft2 per 24 hours using a calcium chloride test (ASTM F-1869), pre apply Sikafloor MB Primer. Consult the manufacturer of the final floor covering to identify the maximum permitted MVER and retained moisture content for their product.</li> <li>Do not apply where the relative humidity of the substrate exceeds 75% as this will limit the efficiency of the primer.</li> <li>The substrate should be surface dry with relative humidity of surrounding air low enough to allow efficient drying of the primer.</li> <li>Sika* Level-02 EZ Primer does not form a moisture barrier. For proper moisture mitigation, consult Sika Technical Services.</li> <li>Product should not be used if exposed to freezing temperatures.</li> <li>Not suitable on polyolefin and floor coverings with Sealers which are not removable with basic detergent chemicals. If in doubt test in a small area.</li> <li>Do not apply SlkaLevel underlayaments or reprofiling mortars while SikaLevel 02 EZ is still wet or tacky</li> </ul>

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Constructior



# Sika<sup>®</sup> Level SkimCoat

Fast setting, cement based smoothing and finishing compound

	repair or reprofiling of conc ceramic or quarry tiles before	ne-component, easy to use and fast drying, cementitious skim mortar ideal for the rete, approved wood subfloors, gypsum based subfloors and correctly prepared one the installation of Sika Level underlayments or final floor coverings. Can be dge as well as filling voids and leveling defects up to 1/2" (0-13mm) in depth.
Where to Use	<ul> <li>Sika Level Underlaymen</li> <li>Repair minor defects, ho</li> <li>To pre-fill non-moving joi</li> <li>To skim correctly prepar adhesive residue. such a</li> <li>Used to re-profile rough levelers or floor finishes.</li> </ul>	oles and cracks in concrete and wood subfloors. ints and seams in concrete and wooden substrates. red ceramic or quartz tiles and encapsulate stable, non-bleeding, water resistar as cutback substrates or subfloor surfaces from feather edge to 1/2" (13 mm) prior to applyin r MB, not to exceed 1/8" (3 mm), within 36 hours of primer application
Advantages	<ul> <li>Zero VOC's.</li> <li>Repairs new and renova</li> <li>Good adhesion to substi</li> <li>Rapid setting; receives p</li> <li>Excellent standard of fin</li> </ul>	hieve a true feather edge or only), no moisture vapor emission limitations on properly prepared concrete.
Coverage	33 sq ft. at 1/8 inch. 110 sq	ft or more at feather edge Coverage will vary based on substrate smoothness
Packaging	10 lb bag. Pack of 4 bags.	
	Typical Data (Mater	ial and curing conditions @ 70°F (22°C) and 65% R.H.)
	Typical Data (Matern Shelf Life	ial and curing conditions @ 70°F (22°C) and 65% R.H.) 1 year in original, unopened packaging
	Shelf Life Storage Conditions	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard
	Shelf Life Storage Conditions	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. <b>re</b> Substrate and ambient room temperatures must be above 50°F (10°C) and
	Shelf Life Storage Conditions Application Temperatu	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. <b>re</b> Substrate and ambient room temperatures must be above 50°F (10°C) and below 86°F (35°C). Gray
	Shelf Life Storage Conditions Application Temperatu Color	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. <b>re</b> Substrate and ambient room temperatures must be above 50°F (10°C) and below 86°F (35°C). Gray
	Shelf Life Storage Conditions Application Temperatu Color Mixing Ratio	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. re Substrate and ambient room temperatures must be above 50°F (10°C) and below 86°F (35°C). Gray Mix entire contents of bag (10 lbs/4.5 kg of powder) with up to 2 qts. (1.9L) of water.
	Shelf Life Storage Conditions Application Temperatu Color Mixing Ratio Application Thickness	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. <b>re</b> Substrate and ambient room temperatures must be above 50°F (10°C) and below 86°F (35°C). Gray Mix entire contents of bag (10 lbs/4.5 kg of powder) with up to 2 qts. (1.9L) of water. Feather edge - 1/2 in. (13 mm)
	Shelf Life Storage Conditions Application Temperatu Color Mixing Ratio Application Thickness Working Time Setting Times (ASTM 266)	1 year in original, unopened packaging Store dry at 41°-90°F (5°-32°C). Protect from moisture; if damp, discard material. re Substrate and ambient room temperatures must be above 50°F (10°C) and below 86°F (35°C). Gray Mix entire contents of bag (10 lbs/4.5 kg of powder) with up to 2 qts. (1.9L) of water. Feather edge - 1/2 in. (13 mm) 10 to 20 min. Initial Set - 20 to 30 min. Final Set - 30 to 60 min. 28 days (ASTM C109 mod.) 3700 psi (25 N/mm <sup>2</sup> ) ays (ASTM C348) 1300 psi (7 N/mm <sup>2</sup> )

How to Use	
Surface Preparation	All concrete, cement and ceramic/quarry tile substrates must be dry, clean and stable before applying the skir mortar compound. Remove all existing treatments such as coatings, sealers, wax, latex compounds, impregna tions and curing agents, together with all contaminants and loose matter e.g. dirt, dust, laitance, grease, oils and foreign matter, which will interfere with the adhesion of Sika Level SkimCoat. Prepare concrete, cemer and ceramic/quarry tile substrates by mechanical means, such as light shotblasting, sanding or other appropriate methods, to remove weak material and achieve a matt, glaze free open textured, fine-gripping surface Vacuum substrates thoroughly.
	All subfloors must be structurally stable and well bonded or fastened. Plywood subfloors must consist or exterior-grade wood which complies with Group 1 CC Type, is engineer approved and either recommende or warranted by the wood manufacturer or final floor covering supplier.
	Ensure wooden floors are well ventilated from below. Moisture Vapor Emission Rates of the substrate shoul comply and meet the requirements of the proposed floor covering. Test substrates for moisture content an consult the manufacturer of the final floor finish for advice.
Mixing	As with all prebagged cement products, some settlement may have occurred during storage and transportation and dry blending of the material is recommended. Mix entire contents of bag (10 lb of powder) with up to 2 quarts (1.9 l) of water. For mixing less than a full bag at once, use up to a ratio of 2:1 part water. Pour coo potable water into a suitably sized and clean mixing container, using a calibrated measuring jug, or similar, t ensure strict control of the water content (avoid over-watering). Cool water (70°F/21°C) serves to maximiz the pot life and working time. Slowly add Sika Level SkimCoat powder to the water using a high speed electric mixer (min 600 rpm) and mortar/grout mixing paddle to blend water and powder for 2-3 minutes. Smallevolumes can also be mixed by hand for 2-3 minutes. Mix until a uniform, lump free and smooth consistency i achieved.
	<b>Note:</b> Do not overwater and avoid entrapment of air and excessive mixing as this will impact performance. Do not mix more mortar than can be used within the stated pot life and working time, taking into consideratio ambient temperatures.
Application	The stated ambient and substrate application temperatures are to be achieved before works are started. When temperatures exceed 86°F (30°C), refer to and follow ACI hot weather application and protection guidelines. Using a flat edge steel trowel, apply Sika Level SkimCoat immediately following mixing. Ensure that th compound is tightly trowelled into all defects, seams, and non-moving joints or across roughened surfaces a required. Where defects, details or roughened surfaces require repair or reprofiling to a depth greater tha 1/2" (13 mm), use the appropriate SikaLevel <sup>®</sup> self levelling underlayment. Consult Sika Technical Services for advice or alternative recommendations.
Limitations	<ul> <li>For interior use only. Not suitable for exposed repairs or resurfacing.</li> <li>Do not exceed the recommended water dosage and use clean potable water.</li> <li>Do not apply onto dimensionally unstable substrates.</li> <li>Do not use on presswood, flakeboard, metallic or similar substrates and always comply with the final floor manufacturer's recommendations or instructions as to substrate or subfloor standards.</li> <li>Not suitable for use on water soluble adhesive residues or those which suffer from migration/bleeding.</li> <li>Do not use as a large or deep surface leveler.</li> <li>Do not expose to adverse drying conditions while curing. Protect from other trades, traffic, dust, dirt, high ambient temperatures and direct sunlight until final floor covering is completely dry.</li> <li>Sika Level SkimCoat must be covered with an underlayment or final floor covering.</li> <li>Not suitable for applications where hydro static pressure is present.</li> <li>Sika Primer MB must be clean before application of SkimCoat A solvent wine is recommended</li> </ul>

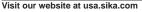
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## Sika<sup>®</sup> Level Rapid Patch

Fast-setting cementitious patch for use with Sika<sup>®</sup> Level underlayments and general floor coverings to repair or reprofile old, damaged or uneven floors

Description	Sika <sup>®</sup> Level Rapid Patch is a one-component, polymer modified, easy to use and fast drying cementitious patching mortar ideal for the repair or re-profiling of concrete, approved wood subfloors and correctly pre-pared ceramic or quarry tiles before the installation of Sika <sup>®</sup> Level underlayments or final floor coverings. Easily applied and with both high adhesion values and fine finishing qualities it can be used fill and level defects from 1/2 inch (0-13 mm) in depth.
Where to Use	<ul> <li>Used to repair minor defects, holes and cracks in concrete and wood subfloors before installing underlayments or final covering</li> <li>To pre-fill non-moving joints and seams in concrete and wooden substrates.</li> <li>Used to re-profile rough substrates or subfloor surfaces from feather edge to 1/2 inch (13 mm) prior to applying levelers or floor finishes.</li> <li>Used as a parge coat to fill bug holes and surface voids creating a contiguous surface.</li> </ul>
Advantages	<ul> <li>Easy to prepare and quick to apply.</li> <li>Excellent high build properties.</li> <li>Zero VOC content.</li> <li>Repairs new and renovates old floors</li> <li>Good adhesion to substrates, subfloors and stable adhesive residue.</li> <li>Rapid setting; receives primers, levelers, adhesives and coverings without delay.</li> <li>Excellent standard of finish can be achieved to allow direct application of coverings.</li> </ul>
Packaging	25 lb (11.3 kg) bags.

### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life Storage Conditions	1 year in original, und Store dry at 41°-90°F discard material.	• •	ckaging. Protect from moisture; if damp,
Application Temperature			
Color	Gray		
Mixing Ratio	Mix entire contents of with up to 1 gal. (3.75	0.	s [11.3 kg] of powder) ater.
	For part mixes, use u water by volume.	p to 3 parts	s powder with up to 1 part
	For a creamier mix, u	se less wa	ter.
Application Thickness	Feathere	edge - 1/2 i	n. (13 mm).
Working Time	15 to 20	min.	
Setting Times			
	Initial Set		20 to 30 min.
(ASTM 266)	Final Set		30 to 45 min.
Compressive Strength	(ASTM C 109 mod.)	28 days	>3000 psi (21 N/mm <sup>2</sup>

Drying Time before Covering Once material has hardened sufficiently so that a primer, underlayment or adhesive does not disturb the surface, it may be covered. Drying time will be dependent upon temperature, humidity and the thickness of the skim mortar.



How to Use Surface Preparation	compounds, impregnations and curing agents, together with all contaminants and loose matter i.e. dirt, dust, laitance, grease, oils, and foreign matter, which will interfere with the adhesion of Sika® Level Rapid Patch. Prepare concrete, cement and ceramic/quarry tile substrates b mechanical means, such as light shotblasting, sanding or other appropriate methods, to remove wea material and achieve a matt, glaze free open-textured, fine-gripping surface (ICRI - CSP 3 minimum). All subfloors must be structurally stable and well bonded or fastened. Remove all existing treatments such as coatings, sealers, wax, latex compounds, impregnations and curing agents, together with all contaminants and loose matter i.e. dirt, dust, laitance, grease, oils, and foreign matter. Plywood subfloors must consist of exterior-grade wood which complies with Group 1 CC Type, is engineer approved and either recommended or warranted by the wood manufacturer or final floor covering supplier. Ensure wooden floors are well ventilated from below. Moisture Vapor Emission Rates of the substrate should
Mixing	comply and meet the requirements of the proposed floor covering. Test substrates for moisture content and consult the manufacturer of the final floor finish for advice         As with all pre-bagged cement products, some settlement may have occurred during storage and trans-portation and dry blending of the material is recommended. Mix entire contents of bag (25 lb of powder) with up to 1 gal. of water. For part mixes, use up to 3 parts Sika® Level Rapid Patch
	powder with up to 1 part water by volume. For a creamier mix, use less water. Pour cool, potable water into a suitably sized and clean mixing container, using a calibrated measuring jug, or similar, to ensure strict control of the water content (avoid over-watering). Cool water (70°F/21°C) serves to maximize the pot life and work-ing time. Slowly add Sika <sup>®</sup> Level Rapid Patch powder to the water while either hand mixing or using a low speed electric mixer (300 to 450 rpm) and mortar/groum mixing paddle to blend water and powder for a minimum of 3 minutes. Mix until a uniform, lump free and smooth consistency is achieved. Mixing with a low speed drill equipped with a mixing paddle produces a more uniform, creamier mix with better workability. <b>Note:</b> Do not over water and avoid entrapment of air and excessive mixing as this will impact upon performance. Do not mixing more mortar than can be used within the stated pot life and working time, taking into consideration ambient temperatures.
Application	The stated ambient and substrate application temperatures are to be achieved before works ar started. Where temperatures exceed 86°F (30°C), refer to and follow ACI hot weather application an protection guidelines. Using a flat edge steel trowel, apply Sika <sup>®</sup> Level Rapid Patch immediatel following mixing. Ensure that the compound is tightly trowelled into all defects, seams, and non-movin joints or across roughened surfaces as required. Where defects, details or roughened surfaces requir repair or reprofil-ing to a depth greater than 13 mm, use the appropriate Sika <sup>®</sup> Level self levellin underlayment. Consult Sika Technical Services for advice or alternative recommendations.
Limitations	<ul> <li>For interior use only. Not suitable for exposed repairs or resurfacing.</li> <li>Do not exceed the recommended water dosage and use clean potable water.</li> <li>Do not install over substrates that contain asbestos.</li> <li>Not suitable for use on water soluble adhesive residues or those which suffer from migration/bleeding.</li> <li>Do not expose to adverse drying conditions while curing. Protect from other trades, traffic, dust and dirt until final floor covering is completely dry.</li> <li>Sika<sup>®</sup> Level Rapid Patch must be covered with an underlayment or final floor covering.</li> <li>Not a final wearing surface.</li> <li>Substrate and ambient temperatures must be between 50°F (10°C) and 100°F (38°C).</li> <li>Do not use on self-stick tile, particleboard, presswood, flake board, metallic or similar substrates and always comply with the final floor manufacturer's recommendations or instructions as to substrate or subfloor standards.</li> <li>Gypsum substrates should always be dry.</li> </ul>
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For f actu befo Prior Data meni	CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE O further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to al Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data She re using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. r to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Prod Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Dep t at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruc- ach Sika product sate forth in the current Product Data Sheet product label and Safety Data Sheet product and the current Product Sika Sika Sika Sika Sika Sika Sika Sika
prod SiKA the c Buye EXPI SHA THE SAL	ach Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to luct use. A warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties urrent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all riser's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANT RESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. S LI NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE F USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHE E OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR LING 201-933-8800.
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Phone: 800-933-7452 Fax: 201-933-6225

Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Fracc. Industrial Balvane Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





Product Data Sheet Edition 9.30.2015 Sika® Level-315

# Sika<sup>®</sup> Level-315

Very rapid hardening and durable, cementitious, self-leveling underlayment for use at 1/25 to 2 inches\* (1 to 50 mm) thickness

cementitious, wood and tile	omponent, fast track and versatile cementitious underlayment for interior concrete ed substrates. It can be applied manually or by pump to produce a self-smoothing economical substrate prior to the application of a final floor finish. Typical application es* (1 to 50 mm).
Institutional - schools, col Commercial - offices, corr	moothing applications where floor coverings are to follow, such as: leges, hospitals, clinics, libraries, galleries, museums idors, hallways, canteens, cafeterias, stores, hotels, restaurants operties, condominiums and high rise construction
<ul><li>Ceramic tiles and natura</li><li>Floor coverings (carpet,</li></ul>	low odor eling plication uble in pedestrian areas
1/25 in (1 mm) 1/8 in (3 mm) 3/16 in (5 mm) 3/8 in (10 mm) 5/8 in (16 mm) 1 in (25 mm)	ter 50 lb (22.7 kg) bag ypical thicknesses per 50 lb bag 140 ft <sup>2</sup> 41.25 ft <sup>2</sup> 27.5 ft <sup>2</sup> 13.75 ft <sup>2</sup> 8.7 ft <sup>2</sup> 5.6 ft <sup>2</sup> de allowance for surface profile and porosity or material waste)
Polymer modified rapid har	rdening cement.
50 lb (22.7 kg) bag	
Typical Data (Materia	al and curing conditions @ 73°F (23°C) and 50% R.H.)
RESULTS MAY DIFFER BASED	UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
Shelf Life	1 year from date of production if stored properly in original, unopened and undamaged sealed packaging.
Storage Conditions	Store dry at 40°-86°F (4°-30°C). Condition material to 65°-75°F
	(18°-24°C) before using. Protect from moisture. If damp, discard material.
Color Yield	Concrete gray Approximately 0.46 cu. ft. (0.013 m <sup>3</sup> ) per 50 lb (22.7 kg) bag. Approximate coverage at typical thicknesses per 50 lb (22.7 kg) bag. Coverage figures do
	not include allowance for surface profile and porosity or material waste.
Mixing Ratio	9.0 - 9.5 pints of water per 50 lb (22.7 kg) bag
Application Temp. (substrate & ambient)	Minimum 50°F (10°C); Maximum 95°F (35°C)
(Substrate & ambient)	
Application Thickness	Minimum 1/25 in (1.0 mm); Maximum 2 in (50 mm)
	very rapid-setting, flat and e thickness is 1/25 to 2 inch * in localized areas Interior floor leveling and s Institutional - schools, col Commercial - offices, corr Residential - domestic pro- Easy and quick to instal Zero VOC content and Highly fluid and self-lew Manual or pumpable ap Feather-edging accepta Levels new and renovat Very rapid drying, can b Ceramic tiles and natur Floor coverings (carpet, Excellent underlay for ti Approximately 0.46 cu.ft. p Approximate coverage at t 1/25 in (1 mm) 1/8 in (3 mm) 3/16 in (5 mm) 3/8 in (10 mm) 5/8 in (16 mm) 1 in (25 mm) (Coverage figures do not inclu Polymer modified rapid hat 50 lb (22.7 kg) bag <b>Typical Data (Materia</b> RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions

	16 hour 24 hours 3 day	<b>73°F* (23°C)</b> 2,000 2,750 3,250	7 day 14 day 28 day	3,875 4,125 > 5,000
	Pull-Out Strength 3/16 in (5			ner (ACI 503)
	VOC (EPA method 24)	> 2.0 MPa (29 0 g/L		
How to Use Surface Preparation	substrates, including wood su using Sika®Level-02 Primer in stable before priming and app ings, sealers, wax, latex comp	ubfloors, ceramic, c n accordance with t plying the underlayr pounds, impregnation of foreign matter, wh	uarry and vinyl tiles a he product data sheet nent materials. Remov ons and curing agents,	el-01 Primer and all difficult-to-bo ind cut back adhesive must be pr . The substrate must be dry, clear /e all existing treatments such as together with all contaminants i.e he penetration of Sika <sup>®</sup> Level-01 P
	Concrete & Dense Substrat			
	means, such as shotblasting, an open-textured, fine-grippi surface defects such as blow mortar prior to priming and le primer through to lower areas including preparation residue Level-01 Primer. The compre at 28 days with a minimum te	sandblasting, wate ng surface (ICRI - holes and spalls full evelling. All cracks a s. Consult Sika Tec e, must be complete essive strength of th ensile strength of 1.0 s of the substrate sh	r-jetting, scarifying, or CSP 3 minimum). We ly exposed and repaire ind holes should be si hnical Sales for recom ely removed using a v le concrete substrate 0 MPa (>145 psi) at the hould comply and meet	quarry and vinyl tiles by mecha other appropriate methods, to ac eak concrete should be removed ed Sika® Level SkimCoat or SikaC milarly filled to prevent seepage of mendations. All loose friable ma acuum before application of the should be at least 20 MPa (>290) e time Sika® Level-01 Primer is ap the requirements of the proposed dvice.
	the timing of application of pr excessively porous substrate equilibrium in slab vapor press Sika recommends the applica and acceptability of final pro should be sufficient; however substrates. Where multiple co	imer and underlayn es, outgassing will soure and the ambie ation of several sma duct performance. ; allowance should l oats are required, d	nent. Immediately follo increase for a short p nt environment is reac all test patches to dete In general, a one-coa be made for double pri	of mechanical surface preparation wing mechanical preparation on period of time (approx. 48 hours) shed. Before overall installation be rmine primer application requirer application of Sika® Level-01 P ming on excessively porous or pr primer.
	at least two layers of exterior minimum, the deflection parar must then be suitably secured	315 underlayment r grade plywood, a meters of L/360 (live d, bonded and prep	minimum of 1 ¼ inch and dead loads taken ared to a contaminant	s, ensure that the subfloor consi (32mm) in thickness and meets, into consideration). The wood/ply free and sound condition. Refer quirements of the floor finish syst
Mixing	Pour 9.0 - 9.5 pints of cool, pot suring jug, or similar, to ensur to maximize the working time; cooling the water. Add Sika®Le	table water into a sui re strict control of the if available water is evel-315 to the water	itably sized and clean n e water content (avoid not at this temperature , while slowly stirring, ac	nixing container, using a calibrated over-watering). Cool water 70°F s e, then consideration should be giv dding the complete contents of the ree and uniform consistency is achi
	electric mixer (300 to 450 rpn of 3 minutes, until a uniform m of material as this will introdu	n) and egg beater s nix has been produc ice and entrap air ir	tyle mixing paddle to b ed. Do not overmix or nto the mix, potentially	o as stated above and use a low s olend water and powder for a min allow the paddle to rise above the shortening the working life or ca najority of air bubbles have dispe
		that the mixing and	d pumping elements a	in sound working order. Pre-clea re fully functional and that meshe spensed onto the floor.
Application	avoid accelerated curing and re are to be achieved before inst colder conditions prevail, make application temperatures requi application and protection guid that installers can maintain a co in terms of width, should also b and control joints in the substr expansion and control joints w	duced physical proper allation and should le e allowances for the ired. Where tempera elines. Before laying ontinuous flow of ma be set accordingly. Si rate re bridged; such here specified, inclu	erties. The stated ambien be maintained for a per use of indirect and ven atures exceed 86°F (30 the material, organize la terial and avoid creating ka <sup>®</sup> Level-315 must not joints must be detailer ding at the perimeter of	rying or direct sunlight are blocked nt and substrate application tempera- iod of at least 3 days thereafter. S ted heaters to achieve and mainta "C), refer to and follow ACI hot we abor to operate most effectively, ens g cold joints. The dimensions of the be applied in such a way that expa d through the underlayment. Provi rooms, columns, and pedestals. S e underlayment. Joints, of at least
	<b>TRUCTIONS ON THE PRODUCT</b>	S MOST CURRENT	PRODUCT DATA SHEET SIKA.COM/ OR BY CAL	AD AND FOLLOW THE WARNINGS I, PRODUCT LABEL AND SAFETY LING SIKA'S TECHNICAL SERVIC UEVES THE USED OF THE ORI CA

		application. Pour or pur ensuring that a wet edg ing the necessary cove up to 2" per lift are poss can be used to minimiz 1. The material can be in one lift. A reduction is smooth finished floor. V of aggregate. 2. Pre-washed 3/8" pe Applicator must be aw adding aggregate, ext lifts can also be applie lifts. If necessary, furth Service Department.	mp the mixed material onto ge is maintained; spread by rage over high points. Non sible. For large scale areas are material cost: e extended by adding up t in flow, approximately 15% When adding aggregate, e ea-gravel can be pre-place vare that the aggregate ca pect coverage to increass d to achieve greater deptt her detailed recommenda Over large areas, applica priate. Thoroughly spike n	the of laying or can be cut into Sika <sup>®</sup> Level-315 within 24 h the primed surface quickly and without delay, in a ribbon p trowel or pin screed/gauge rake to the required thickness is inal maximum thickness is 1" per lift. Localized areas with that require deeper applications, the following recommend 0 30% of 20/30 grade sand during mixing to achieve up b, can be expected. The final layer should be neat to allo kpect coverage to increase by approximately .16 cu.ft. per ed into the area being leveled allowing for up to 2.5" in o in cause voids in the underlayment if not filled correctly. a by approximately .16 cu.ft. per 25 lbs of aggregate. M is, making sure to prime with Sika <sup>®</sup> Level 01 Primer in be tions can be obtained by calling Sika Corporation's Ter- tion by conventional piston, rotor-stator or underlayme bil in two directions (90°) to remove installation marks a	pattern, achiev- depths dations to 2.5" ow for a r 25 lbs one lift. . When Multiple etween achnical ent type
	Over Painting	Waiting Time / Overco Suitable for overcoatin reached after 24 hours hours. Suitable for wor at 73°F(+23°C) and 50 the temperature and re has achieved the requiness and ambient hun	coating ig with impermeable mois's. Suitable for overcoating od floor bonding at 1/8 inc % R.H. and thus will be aff elative humidity. When ov ired value for the coating hidity. (Refer to the top coa o overcoating. Other test re	ure sensitive floors after drying (max. 3% humidity); norr with tiles or other moisture insensitive floor covering after h (3 mm) thickness after 24 hours. Times are approxima ected by changing substrate and ambient conditions, part ercoating Sika <sup>®</sup> Level-315 always ensure the moisture co product, as the waiting time will vary with the application at product data sheet). Typical moisture content of the pr ecommended by floor covering manufacturer should be u	er 1-2 ate and ticularly ontent thick- roduct
	Limitations	<ul> <li>Do not apply Sika<sup>®</sup> or dimensionally un</li> <li>Engineer-approved be properly secure</li> <li>Always prime cond</li> <li>Protect Sika<sup>®</sup> Leve ventilation for 24 h</li> <li>Do not exceed the</li> <li>Temperature variad</li> <li>Protect newly appl</li> <li>Prevent contamina do not expose to ro</li> <li>When overcoating laitance and mater</li> <li>If subsequent layer ration and re-primi</li> <li>As the thickness of stones, tiles, or co substrate moisture</li> <li>Sika<sup>®</sup> Level-315 do</li> <li>For adhesives othe</li> </ul>	nstable substrates. d wooden (plywood) subf d, bonded, and prepared rete and cement substrat I-315 from excessive heat ours before installation and recommended water dos- tions will affect working the ied Sika® Level-315 from ints, dust and dirt from cor- biling dynamic loads for 2 with Sika Primer MB, m ial which could interfere w rs of Sika® Level-315 are in ng is required. the underlayment will infly verings, the manufacture content and other charactere than SikaBond®, we recom- <b>NY SIKA PRODUCT, THE U</b>	pboard, particle board, hardboard, metal, gypsum-based oors must be at least 1.25 in. (3.2 cm) in thickness an and free of contaminants and loose friable material. es with SikaLevel® Primer-01 primer it and moving air by turning off radiant heating and for d while the underlayment is curing. age and use clean potable water. ne, with low temperatures extending drying times. condensation and water for at least 24 hours. ning into contact with the underlayment for at least 4 hou days (at 73°F, 50% R. H.). echanical preparation may be required to remove all s <i>v</i> ith adhesion. nstalled on existing, cured Sika®Level-315, mechanical uence the time at which it can be overcoated or overlayer of such materials must be consulted for guidance reg	d must rced air urs and surface prepa- red with garding g. SS AND
		SHEET WHICH ARE AVAILAI PARTMENT AT 800.933.7452 TO READ AND FOLLOW THE RENT PRODUCT DATA SHEE KEEP CONTAINER TIGHTLY CLOSED. KEE For further information and advice actual Safety Data Sheets containi before using the product. In case of Prior to each use of any Sika produ Data Sheet, product label and Safe	BLE ONLINE AT HTTP://US NOTHING CONTAINED IN A WARNINGS AND INSTRU T, PRODUCT LABEL AND POUT OF REACH OF CHILDREN. NOT e regarding transportation, han ng physical, ecological, toxicolo of emergency, call CHEMTREC ict, the user must always read an ty Data Sheet which are availab	A.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVIT NY SIKA MATERIALS RELIEVES THE USER OF THE OBLIG CTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THIS SAFETY DATA SHEET PRIOR TO PRODUCT USE. FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL I dling, storage and disposal of chemical products, users should ref orgical and other safety related data. Read the current actual Safety Da at 1-800-424-9300, International 703-527-3887. Id follow the warnings and instructions on the product's most current le online at http://usa.sika.com/ or by calling Sika's Technical Service	CE DE- GATION E CUR- USE ONLY. fer to the ata Sheet t Product e Depart-
Ji	ka ®	for each Sika product as set forth product use. SIKA warrants this product for one the current Product Data Sheet if u Buyer's sole remedy shall be limite EXPRESS OR IMPLIED SHALL APF SHALL NOT BE LIABLE UNDER AN THE USE OF THIS PRODUCT IN AM SALE OF SIKA PRODUCTS ARE CALLING 201-933-8800. Visit our website at usa.sika.co	in the current Product Data She e year from date of installation t sed as directed within shelf life. d to the purchase price or replac PLY INCLUDING ANY WARRANI YL LEGAL THEORY FOR SPECIA ANNER TO INFRINGE ON ANY P SUBJECT SIKA'S TERMS AN m	Aves the user of the obligation to read and follow the warnings and inside, product label and Safety Data Sheet prior to be free from manufacturing defects and to meet the technical propulser determines suitability of product for intended use and assumes ement of product exclusive of labor or cost of labor. NO OTHER WARF Y OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSITE TO LOR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSITE TO D CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM. 1-800-933-SIKA NATIONVIDE tour nearest Sika sales office, contact your regional center. Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800	erties on all risks. RANTIES SE. SIKA BLE FOR OTHERS.

Carretera Libre Celaya Km. Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



Product Data Sheet Edition 9.30.2015 Sika® Level-125

# Sika<sup>®</sup> Level-125

Durable, cementitious, self-leveling underlayment for use at 1/25 to 2 inches\* (1 to 50 mm) thickness

- schools, colleges, he - offices, corridors, ha - domestic properties, quick to install - content and low odor d and self-leveling - pumpable application dging acceptable in per- w and renovates old fl I drying, can be walked or overcoating with no erings (carpet, vinyl, P underlay for tiles, sheet y 0.438 cu.ft. per 50 lt coverage at typical th n) 	edestrian areas loors d on in after 2-3 hours at 73°F (23°C) in-moisture sensitive tile after 2-3 hours V/C, rubber, engineered wood flooring) can be installed after 1-3 days et products and wood floor bonding systems b (22.7 kg) bag icknesses per 50 lb bag 131.4 ft <sup>2</sup> 42.0 ft <sup>2</sup> 28.0 ft <sup>2</sup> 14.0 ft <sup>2</sup> 8.4 ft <sup>2</sup> 5.3 ft <sup>2</sup> ance for surface profile and porosity or material waste) cement.
content and low odor d and self-leveling pumpable application dging acceptable in per- w and renovates old fl drying, can be walker or overcoating with no erings (carpet, vinyl, P underlay for tiles, sheat y 0.438 cu.ft. per 50 lt coverage at typical the n) n) n) n) res do not include allowa	edestrian areas loors d on in after 2-3 hours at 73°F (23°C) in-moisture sensitive tile after 2-3 hours V/C, rubber, engineered wood flooring) can be installed after 1-3 days et products and wood floor bonding systems b (22.7 kg) bag icknesses per 50 lb bag 131.4 ft <sup>2</sup> 42.0 ft <sup>2</sup> 28.0 ft <sup>2</sup> 14.0 ft <sup>2</sup> 8.4 ft <sup>2</sup> 5.3 ft <sup>2</sup> ance for surface profile and porosity or material waste) cement.
coverage at typical th 1) 1) 1) 1) res do not include allowa lified rapid hardening o	icknesses per 50 lb bag 131.4 ft <sup>2</sup> 42.0 ft <sup>2</sup> 28.0 ft <sup>2</sup> 14.0 ft <sup>2</sup> 8.4 ft <sup>2</sup> 5.3 ft <sup>2</sup> ance for surface profile and porosity or material waste) cement.
) bag	
)ata (Material and c	uring conditions @ 73°F (23°C) and 50% R.H.)
	ATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, S, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	r from date of production if stored properly in original, unopened ndamaged sealed packaging.
onditions Store	dry at 40°-86°F (4°-30°C). Condition material to 65°-75°F
(18°-2	24°C) before using. Protect from moisture. If damp, discard material.
Appro covera	ete gray ximately 0.46 cu. ft. (0.013 m <sup>3</sup> ) per 50 lb (22.7 kg) bag. Approximate age at typical thicknesses per 50 lb (22.7 kg) bag. Coverage figures do clude allowance for surface profile and porosity or material waste.
	on of water per 50 lb (22.7 kg) bag
n Temp. Minim	um 50°F (10°C); Maximum 95°F (35°C)
Thickness Minim	um 1/25 in (1.0 mm); Maximum 2 in (50 mm)
(EN 12706) nes (ASTM C 266) ange 28 days	25 minutes at 3/16 in (5 mm) thickness ~ 5" at 15 minutes Initial Set – 45-90 min.; Final Set – 70-100 min. <0.04%
	et mix} (ASTM C-185 ime (EN 12706) nes (ASTM C 266) ange 28 days 57 modified)

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

		Compressive Strength (AS 24 hours 3 days 7 days 28 days	TM C-109), psi 50°F* (10°C) 1,000 1,375 1,625 2,875	<b>73°F* (23°C)</b> 1,250 1,500 2,500 4,000	<b>86°F* (30°C)</b> 1,390 1,665 2,600 3,125
		Pull-Out Strength 3/16 in (5			ner (ACI 503)
		VOC (EPA method 24)	> 2.0 MPa (290 p 0 g/L	SI)	
	How to Use Surface Preparation	substrates, including wood sub using Sika <sup>®</sup> Level-02 Primer in a	floors, ceramic, quar accordance with the	ry and vinyl tiles and product data sheet. T	1 Primer and all difficult-to-bond-to cut back adhesive must be primed he substrate must be dry, clean and all existing treatments such as coat-
			foreign matter, which		gether with all contaminants i.e. dirt, penetration of Sika <sup>®</sup> Level-01 Primer
		Concrete & Dense Substrates	5		
		means, such as shotblasting, sa an open-textured, fine-gripping surface defects such as blowho mortar prior to priming and leve primer through to lower areas including preparation residue, r Level-01 Primer. The compress at 28 days with a minimum tens	andblasting, water-je surface (ICRI - CS les and spalls fully e elling. All cracks and Consult Sika Technic nust be completely n sive strength of the c ile strength of 1.0 MF f the substrate shoul	tting, scarifying, or oth P 3 minimum). Weak xposed and repaired holes should be simil cal Sales for recommo removed using a vac oncrete substrate sho Pa (>145 psi) at the tin d comply and meet the	arry and vinyl tiles by mechanical her appropriate methods, to achieve c concrete should be removed and Sika® Level SkimCoat or SikaQuick® arly filled to prevent seepage of the endations. All loose friable material, jum before application of the Sika® buld be at least 20 MPa (>2900 psi) ne Sika® Level-01 Primer is applied. e requirements of the proposed floor ce.
		the timing of application of prim excessively porous substrates, equilibrium in slab vapor pressu Sika recommends the application and acceptability of final products should be sufficient; however, a substrates. Where multiple coardinates the substrates of the subs	er and underlayment outgassing will incr irre and the ambient e on of several small te ict performance. In g llowance should be r	t. Immediately followin ease for a short peri environment is reache est patches to determ general, a one-coat a nade for double primi	nechanical surface preparation and ng mechanical preparation on some od of time (approx. 48 hours) until d. Before overall installation begins, ine primer application requirements pplication of Sika® Level-01 Primer ng on excessively porous or profiled aterial.
		Wooden/Plywood Subfloors			
		at least two layers of exterior g minimum, the deflection parame must then be suitably secured,	rade plywood, a mir eters of L/360 (live and bonded and prepare	nimum of 1 ¼ inch (3. d dead loads taken int d to a contaminant fre	ensure that the subfloor consists of 2mm) in thickness and meets, as a o consideration). The wood/plywood are and sound condition. Consult the rements of the floor finish system.
	Mixing	jug, or similar, to ensure strict co mize the working time; if available	ntrol of the water con le water is not at this o the water, while slow	tent (avoid over-wateri temperature, then con vly stirring, adding the	ntainer, using a calibrated measuring ng). Cool water 70°F serves to maxi- sideration should be given to cooling complete contents of the 50 lb. sack. uniform consistency is achieved.
		electric mixer (300 to 450 rpm) of 3 minutes, until a uniform mix of material as this will introduce	and egg beater style has been produced. and entrap air into t	mixing paddle to bler Do not overmix or allo the mix, potentially sh	s stated above and use a low speed ad water and powder for a minimum ow the paddle to rise above the level ortening the working life or causing ority of air bubbles have dispersed.
		test the equipment, checking th in place to prevent foreign matt	at the mixing and pu er from entering the	imping elements are the hopper or being disperent	
ſ	Application	avoid accelerated curing and redu are to be achieved before install colder conditions prevail, make a application temperatures require application and protection guidelii that installers can maintain a con in terms of width, should also be a and control joints in the substrate expansion and control joints whe	ced physical propertie ation and should be r illowances for the use d. Where temperature hes. Before laying the tinuous flow of materia set accordingly. Sika® e re bridged; such joir re specified, including	s. The stated ambient a naintained for a period of indirect and vented es exceed 86°F (30°C material, organize labo al and avoid creating or Level-125 must not be nts must be detailed th g at the perimeter of roo	ng or direct sunlight are blocked off to nd substrate application temperatures of at least 3 days thereafter. Should I heaters to achieve and maintain the ), refer to and follow ACI hot weather r to operate most effectively, ensuring old joints. The dimensions of the pour, applied in such a way that expansion arough the underlayment. Provide for pms, columns, and pedestals. Should nderlayment. Joints, of at least 1/4 in
Ji	ka	PRIOR TO EACH USE OF ANY SIKA P NSTRUCTIONS ON THE PRODUCT'S SHEET WHICH ARE AVAILABLE ONLIN PARTMENT AT 800.933.7452 NOTHING FO READ AND FOLLOW THE WARNING RENT PRODUCT DATA SHEET, PRODU	MOST CURRENT PRO NE AT HTTP://USA.SIK CONTAINED IN ANY S GS AND INSTRUCTION	DUCT DATA SHEET, F (A.COM/ OR BY CALLI IKA MATERIALS RELIE NS FOR EACH SIKA PF	RODUCT LABEL AND SAFETY DATA NG SIKA'S TECHNICAL SERVICE DE- EVES THE USER OF THE OBLIGATION RODUCT AS SET FORTH IN THE CUR-

	<ul> <li>(6 mm) can be formed using foam tape at the time of laying or can be cut into Sika<sup>®</sup> Level-125 within 24 hours of application. Pour or pump the mixed material onto the primed surface quickly and without delay, in a ribbon pattern, ensuring that a wet edge is maintained; spread by trowel or pin screed/gauge rake to the required thickness achieving the necessary coverage over high points. Nominal maximum thickness is 1" per lift. Localized areas with depths up to 2" per lift are possible. For large scale areas that require deeper applications, the following recommendations can be used to minimize material cost:</li> <li>1. The material can be extended by adding up to 30% of 20/30 grade sand during mixing to achieve up to 2.5" in one lift. A reduction in flow, approximately 15%, can be expected. The final layer should be neat to allow for a smooth finished floor. When adding aggregate, expect coverage to increase by approximately .16 cu.ft. per 25 lbs of aggregate.</li> <li>2. Pre-washed 3/8" pea-gravel can be pre-placed into the area being leveled allowing for up to 2.5" in one lift. Applicator must be aware that the aggregate can cause voids in the underlayment if not filled correctly. When adding aggregate, expect coverage to prime with Sika<sup>®</sup> Level 01 Primer in between lifts can also be applied to achieve greater depths, making sure to prime with Sika<sup>®</sup> Level 01 Primer in between lifts. If necessary, further detailed recommendations can be obtained by calling Sika Corporation's Technical Service Department. Over large areas, application by conventional piston, rotor-stator or underlayment type pumps is more appropriate. Thoroughly spike roll in two directions (90°) to remove installation marks and any entrapped air, but avoid overworking.</li> </ul>
Over Painting	Waiting Time / Overcoating Suitable for overcoating with impermeable moisture sensitive floors after drying (max. 3% humidity); normally reached after 24 hours. Suitable for overcoating with tiles or other moisture insensitive floor covering after 2-3 hours. Suitable for wood floor bonding at 1/8 inch (3 mm) thickness after 24 hours. Times are approximate andat 73°F(+23°C) and 50% R.H. and thus will be affected by changing substrate and ambient conditions, particularly the temperature and relative humidity. When overcoating Sika® Level-125 always ensure the moisture content has achieved the required value for the coating product, as the waiting time will vary with the application thick- ness and ambient humidity. (Refer to the top coat product data sheet). Typical moisture content of the product should be <4% prior to overcoating. Other test recommended by floor covering manufacturer should be used as the final decision making tool.
Limitations	<ul> <li>For interior use only. Not suitable for slopes or inclines &gt;0.5%</li> <li>Do not apply Sika®Level-125 onto based, chipboard, particle board, hardboard, metal, gypsum-based floors or dimensionally unstable substrates.</li> <li>Engineer-approved wooden (plywood) subfloors must be at least 1.25 in. (3.2 cm) in thickness and must be properly secured, bonded, and prepared and free of contaminants and loose friable material.</li> <li>Always prime concrete and cement substrates with Sika® Level Primer-01 primer</li> <li>Protect Sika® Level-125 from excessive heat and moving air by turning off radiant heating and forced air ventilation for 24 hours before installation and while the underlayment is curing.</li> <li>Do not exceed the recommended water dosage and use clean potable water.</li> <li>Temperature variations will affect working time, with low temperatures extending drying times.</li> <li>Protect newly applied Sika® Level-125 from condensation and water for at least 24 hours.</li> <li>Prevent contaminants, dust and dirt from coming into contact with the underlayment for at least 4 hours and do not expose to rolling dynamic loads for 2 days (at 73°F, 50% R. H.).</li> <li>When overcoating with Sika® Primer MB, mechanical preparation may be required to remove all surface laitance and material which could interfere with adhesion.</li> <li>If subsequent layers of Sika® Level-125 are installed on existing, cured Sika® Level-125, mechanical preparation and re-priming is required.</li> <li>As the thickness of the underlayment will influence the time at which it can be overcoated or overlayed with stones, tiles, or coverings, the manufacturer of such materials must be consulted for guidance regarding substrate moisture content and other characteristics.</li> <li>Sika® Level-125 does not provide an aesthetic finish and is intended to receive a final floor covering.</li> <li>For adhesives other than SikaBond®, we recommend a test application prior to use.</li></ul>
R	KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.         For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.         Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product Iabel and Safety Data Sheet price or replacement of product use.         SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO THER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER LIATUAL PURPORETY RIGHTS HELD BY OTHERS. SALL OF SIKA PROD

Construction



01 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

arretera Libre Celava Km. 8. Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





### **Sika® FerroGard® 903** Penetrating, corrosion inhibiting, impregnation coating for hardened concrete

-	is designed to penetrate embedded in the concre	a corrosion inhibiting impregnation for hardened, reinforced concrete surfaces. It the surface and then to diffuse in vapor or liquid form to the steel reinforcing bars te. Sika® FerroGard® 903 forms a protective layer on the steel surface which inhibits presence of chlorides as well as by carbonation of concrete.
Where to use	concrete. Use of Sika® F Steel-reinforced concre Building facades and Steel-reinforced conc Parking garages. Piers, piles, and conc	te, bridges and highways exposed to corrosive environments (de-icing salts, weathering). balconies. rete in or near a marine environment.
Advantages	that protects both the and the initiation of corrosion embedded steel by depo	roGard <sup>®</sup> 903 is a combination of amino alcohols, and organic and inorganic inhibitors odic and cathodic parts of the corrosion cell. This dual action effect dramatically delays and greatly reduces the overall corrosion activity. Sika <sup>®</sup> FerroGard <sup>®</sup> 903 protects the ositing a physical barrier in the form of a protective layer on the surface of the stee er inhibits corrosion of the steel.
	crete and diffusing to Enhances the durabil Does not require con-	narmful effects of corrosion by penetrating the surface of even the most dense con- the steel to inhibit corrosion. ity of reinforced concrete. crete removal.
Goverage	<ul> <li>Can be applied to reii</li> <li>Adds additional bene</li> <li>Water based for easy</li> <li>Not a vapor barrier; a</li> <li>FerroGard has been p</li> <li>ANSI/NSF Standard (</li> </ul>	er spray or roller to all existing reinforced concrete. nforced concrete that already exhibits corrosion. fits when used prior to protective coatings in concrete restoration systems. handling and application. llows vapor diffusion. roven effective in both laboratory (ASTM G109/Cracked Beams) and field analysis. 61 potable water approved.
Coverage	<ul> <li>Easily applied by eith</li> <li>Can be applied to reii</li> <li>Adds additional bene</li> <li>Water based for easy</li> <li>Not a vapor barrier; a</li> <li>FerroGard has been p</li> <li>ANSI/NSF Standard of</li> <li>For normal concrete, app</li> <li>For dense concrete, app</li> </ul>	er spray or roller to all existing reinforced concrete. nforced concrete that already exhibits corrosion. fits when used prior to protective coatings in concrete restoration systems. handling and application. llows vapor diffusion. roven effective in both laboratory (ASTM G109/Cracked Beams) and field analysis. 61 potable water approved. plication is 200 ft. <sup>2</sup> /gal. each coat. A minimum of two coats is always recommended. lication may exceed 300 ft. <sup>2</sup> /gal. Therefore, more than two coats may be required to
Coverage Packaging	<ul> <li>Easily applied by eith</li> <li>Can be applied to reii</li> <li>Adds additional bene</li> <li>Water based for easy</li> <li>Not a vapor barrier; a</li> <li>FerroGard has been p</li> <li>ANSI/NSF Standard (</li> </ul>	er spray or roller to all existing reinforced concrete. nforced concrete that already exhibits corrosion. fits when used prior to protective coatings in concrete restoration systems. handling and application. llows vapor diffusion. roven effective in both laboratory (ASTM G109/Cracked Beams) and field analysis. 61 potable water approved. polication is 200 ft. <sup>2</sup> /gal. each coat. A minimum of two coats is always recommended. lication may exceed 300 ft. <sup>2</sup> /gal. Therefore, more than two coats may be required to ation rate: 100 ft. <sup>2</sup> /gal.
	Easily applied by eith     Can be applied to reii     Adds additional bene     Water based for easy     Not a vapor barrier; a     FerroGard has been p     ANSI/NSF Standard (     For normal concrete, app     For dense concrete, app     achieve the total applic:     5 gallon pails with spout,     Typical Dat     RESULTS MAY DIF     TEMPERATURE, A     Shelf life     Storage Cond     Color     Viscosity     Flash Point	er spray or roller to all existing reinforced concrete. Inforced concrete that already exhibits corrosion. fits when used prior to protective coatings in concrete restoration systems. I handling and application. Ilows vapor diffusion. roven effective in both laboratory (ASTM G109/Cracked Beams) and field analysis. S1 potable water approved. polication is 200 ft.²/gal. each coat. A minimum of two coats is always recommended lication may exceed 300 ft.²/gal. Therefore, more than two coats may be required to ation rate: 100 ft.²/gal. , 55 gallon drums. TER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, PPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 18 months minimum in original, unopened container. Ititions Store at 40°-95°F (4°-35°C). Protect from freezing. If frozen, discard. Pale Yellow 15 cps None (water based)
	Easily applied by eith     Can be applied to reii     Adds additional bene     Water based for easy     Not a vapor barrier; a     FerroGard has been p     ANSI/NSF Standard (     For normal concrete, app     achieve the total applic.     5 gallon pails with spout.     Typical Date     RESULTS MAY DIF     TEMPERATURE, A     Shelf life     Storage Cond     Color     Viscosity	er spray or roller to all existing reinforced concrete. Inforced concrete that already exhibits corrosion. fits when used prior to protective coatings in concrete restoration systems. I handling and application. Ilows vapor diffusion. roven effective in both laboratory (ASTM G109/Cracked Beams) and field analysis. 61 potable water approved. plication is 200 ft. <sup>2</sup> /gal. each coat. A minimum of two coats is always recommended. lication may exceed 300 ft. <sup>2</sup> /gal. Therefore, more than two coats may be required to ation rate: 100 ft. <sup>2</sup> /gal. 55 gallon drums. <b>13</b> fat 73°F(23°C)] FER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, PPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 18 months minimum in original, unopened container. Itions Store at 40°-95°F (4°-35°C). Protect from freezing. If frozen, discard. Pale Yellow 15 cps

### How to Use Surface Preparation

Before applying Sika® FerroGard® 903 be sure the surface is clean and sound. Remove all dirt, dust, oil, grease, efflorescence or existing coatings from concrete surface by steam cleaning, water blasting or slightly sandblasting. Allow concrete surface to dry prior to application of Sika® FerroGard® 903. The dryer the surface the better the penetration and effectiveness.

Key Criteria	Performance Level	Test Method/Institute
Corrosion inhibition	FerroGard corrosion inhibitors delay the onset of corrosion and reduce the rate of corrosion by 65% versus control specimen after 1 year.	1
Penetration Rate in hardened concrete	FerroGard 903 penetrates independently of orientation (horizontal, vertical, overhead) at a rate of 1/10 to 4/5 inches (2.5 to 20 mm)per day, depending on the density of the concrete.	2
Depth of Penetration	FerroGard 903 penetrates up to 3 inches (76 mm) in 28 days.	2
Protective layer on steel	FerroGard 903 forms a protective layer on the reinforcing steel of high integrity measured at as much as100 Å in thickness.	3
Displacement of chlorides from steel surface	FerroGard 903 forms a continuous film on the reinforcing steel and displaces chloride ions from the steel surface.	3
Corrosion Rate Field Monitoring	Reduction of corrosion rates in excess of 65%.	4

Cracked Concrete Beam Test (adapted from ASTM G109).

2. Secondary Neutron Mass Spectroscopy (SNMS) / Institute for Radiochemistry, Karlsruhe (Germany), Prof. Dr. J. Goschnick.

- 3. X-ray Photon Spectroscopy (XPS) and Secondary Ion Mass Spectroscopy (SIMS) / Brundle and Associ-
- ates, San Jose, CA and University Heidelberg (Germany), Prof. M. Grunze.
- 4. Performance of Corrosion Inhibitors in Practice, Graeme Jones, C-Probe Technologies Ltd., 2000.

Application Sika® FerroGard® 903 is applied by roller, brush or spray on concrete surfaces. When spraying, use a conventional airless spray system or hand-pressure equipment. A minimum of two coats is always recommended. Dense substrates may require more coats. Waiting time between coats of Sika® FerroGard® 903 is at least 1 hour. Allow a minimum of one day to allow Sika® FerroGard® 903 to dry and penetrate.

> When Sika® FerroGard® 903 is used prior to the application of a repair mortar, concrete overlay, protective coating, or any other application, care must be taken to remove any residue remaining on the surface from the application of Sika® FerroGard® 903. Clean the substrate in such a manner (i.e. push the water in one direction away and off from the surface to be over-coated) to completely remove any residue. Horizontal surfaces require pressure washing (2,000 psi minimum) to remove the residue. Vertical surfaces may be rinsed with water or pressure washed. The use of Sika® Armatec® 110 EpoCem as a bonding agent prior to the application of repair mortars or concrete overlays is suggested. Drying times depend on environmental conditions, absorbency of the substrate and maximum recommended moisture content for the subsequently applied system.

#### Limitations

- Minimum ambient and substrate temperatures 35°F.
  - Do not apply when temperature is expected to fall below 35°F within 12 hours.
  - If the applied surfaces will be submerged after the application of Sika® FerroGard® 903, a waterproofing coating must be applied prior to submersion.
  - Substrate should be as dry as possible prior to the application.
  - Protect glass, wood, brick, galvanized steel, copper and exposed aluminum during the application.
  - Maximum chloride content of concrete structures intended to be treated with Sika® FerroGard® 903 is 6 lbs./  $y^3$  (measured at the level of the reinforcing steel). For levels up to 10 lbs./ $y^3$ , consult technical service.

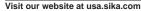
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KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY, FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on ShcA warrants product Data Sheet if used as directed within shelf life. User determines vitability of products for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES, SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



1-800-933-SIKA NATIONWIDE

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Product Data Sheet Edition 11.24.2014 Identification no. Sika® FerroGard®-908

### Sika<sup>®</sup> FerroGard<sup>®</sup>-908

Dual functional surface applied corrosion inhibitor and penetrating sealer for reinforced concrete.

Description		Sika <sup>®</sup> FerroGard <sup>®</sup> -908 is designed to be applied to the concrete surface. Sika <sup>®</sup> FerroGard <sup>®</sup> -908 penetrates the concrete and mitigates active corrosion and/or delays the onset of corrosion.		
Where to Use		Sika® FerroGard®-908® is recommended for steel-reinforced concrete, pre-stressed, pre- cast, post tensioned concrete or concrete in marine environments. Common applications include:		
	<ul> <li>Bridges and highways expose</li> <li>Building facades and balconic</li> <li>Parking garages</li> <li>Piers, piles, and concrete doc</li> </ul>			
	<ul> <li>As part of Sika's system approach for buildings and civil engineering</li> </ul>			
Advantages		orrosion due to chlorides and or carbonation, even in		
	<ul> <li>Increases the resistivity of the</li> </ul>	e reinforced concrete		
	<ul> <li>Enhances the durability of rei</li> </ul>			
	<ul> <li>Long term efficiency, deep per</li> </ul>			
	-			
	Repels additional water and of the second			
	Contains amino alcohol corro			
	Ready to use and easily appl Adda additional hanafite when			
		n used prior to protective coatings in concrete restora		
	<ul><li>tion systems.</li><li>Not a vapor barrier; allows va</li></ul>	nor diffusion		
<ul> <li>Proven effective per ASTM G109/Cracked Bean</li> <li>Increases the resistance of concrete to freeze a</li> </ul>		oncrete to freeze and thaw cycles and de-icing salts		
Packaging	5 gallon pails, 55 gallon drums			
Coverence		Required consumption is 125 sf / gallon. This is normally achieved with 2 coats (250 sf/ gallon/coat); however 3 coats may be required for dense concrete and 1 coat may be		
Coverage				
Coverage	gallon/coat); however 3 coats ma			
Coverage	gallon/coat); however 3 coats ma achievable on porous concrete. <b>Typical Data</b> ( <i>Material and cui</i> RESULTS MAY DIFFER BASED UPON STATISTICAL V	ay be required for dense concrete and 1 coat may be Site mockups should be completed to verify.		
Coverage	gallon/coat); however 3 coats ma achievable on porous concrete. 3 Typical Data (Material and cur	ay be required for dense concrete and 1 coat may be Site mockups should be completed to verify.		
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Coverage	gallon/coat); however 3 coats ma achievable on porous concrete. 3 Typical Data (Material and cur RESULTS MAY DIFFER BASED UPON STATISTICAL V APPLICATION METHODS, TEST METHODS, ACTUAL Storage: Shelf Life: Product Conditioning:	Ay be required for dense concrete and 1 coat may be Site mockups should be completed to verify. <b>Fing conditions @ 73°F and 50% R.H.)</b> ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, SITE CONDITIONS AND CURING CONDITIONS. Store in unopened, undamaged and original sealed packag- ing in dry and cool conditions. Protect from moisture. 2 years from production date. Condition material between 40°F and 95°F		
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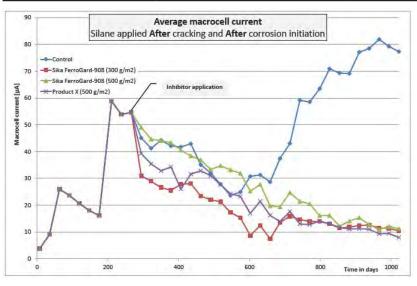


### **Corrosion Data**

### Cracked Concrete Beam (ASTM G 109 modified)

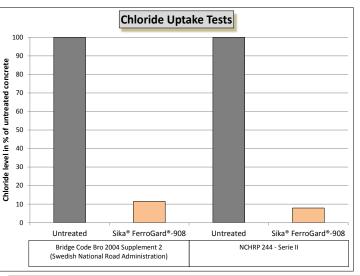
20 Ponding cycles: 2 weeks with 3.0% sodium chloride solution and 2 weeks drying at 68°F. After the 20th cycle, the concentration of the sodium chloride solution was increased to 5.0%

Application before cracking – Measurement after 2.5 years of ponding				
	MacroCell Current in µA	Corrosion reduction		
Untreated 81.9				
Sika <sup>®</sup> FerroGard <sup>®</sup> -908	6.9 92%			
Application after cracking – Measurement after 2.5 years of ponding				
MacroCell Current in μA		Corrosion reduction		
Untreated	81.9			
Sika® FerroGard®-908         0.6         99%		99%		
Application after cracking and after corrosion initiation – Measurement after 2.5 years of ponding				
MacroCell Current in µA		Corrosion reduction		
Untreated 81.9				
Sika® FerroGard®-908 10.9 87%		87%		



### Chloride ion uptake reduction

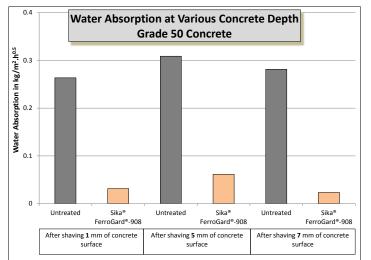
Compared to untreated concrete, concrete treated with Sika® FerroGard®-908 shows a significantly reduced chloride uptake (test carried out using various methods).





### Water penetration reduction

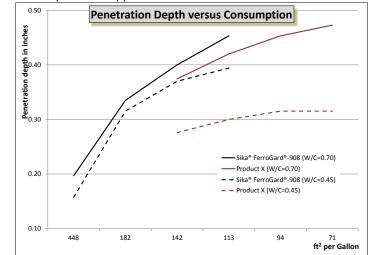
Test performed according to the European Standard EN 13057:2002 modified (100 mm sample size). Capillary absorption measurement were carried out after shaving 1, 5 and 7 mm of the concrete surface to assess the reduction of water absorption in the depth of the concrete surface.



### **Penetration depth**

Sika® FerroGard®-908 is compared to a product available in the market on two types of concrete mixes (one concrete with water cement ratio of 0.70 and the second one with 0.45).

The results show clearly a higher penetration of Sika® FerroGard®-908 into the test concrete when the same consumption was applied.



on the surface.

### How To Use

Mixing

**Surface Preparation** Surfaces must be sound, clean, dry and free of frost, dirt, dust, loose concrete, grease, oil, contaminants or other foreign matter that may adversely affect the penetration of Sika FerroGard<sup>®</sup>-908. New concrete should cure a minimum of 28 days; however, sooner is possible, please contact Technical Services for more information. Concrete surfaces must be prepared using mechanical means (sandblast, shotblast, high pressure water, etc.). Cracks in concrete more than 12 mils should be repaired ahead of the treatment. None required, comes ready to use. Do not dilute with water or solvent. Application Apply using a low-pressure spray, brush or roller, in a single pass from the bottom up taking care not to let the product run. Apply subsequent coats wet on wet. Avoid ponding



	If used as a corrosion treatment prior to the application of Sikagard <sup>®</sup> and Sikalastic <sup>®</sup> protective coatings please contact Sika Technical Services for more information.
	To ensure excellent bond, use of Sika <sup>®</sup> Concrete Repair Systems, sealants and coatings is strongly encouraged. Field mock ups are always recommended to verify final construction installation requirements.
	Do not apply Sika <sup>®</sup> FerroGard <sup>®</sup> -908 to wet or damp substrates. Do not apply if rain is expected within four hours following application, or if high winds or other conditions prevent proper application.
Limitations	<ul> <li>Areas such as window frames which still need to be painted must be protected, avoid contact with Sika FerroGard<sup>®</sup>-908.</li> <li>Can damage some coatings and bituminous products.</li> <li>May lead to darkening of concrete, apply sample areas first.</li> </ul>
	<ul> <li>Cannot be overcoated with limewash or cement paint.</li> </ul>

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINCE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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RESPONSIBLE CARE





**Product Data Sheet** Edition 12.07.2015 Sikagard<sup>®</sup> 701W

### Sikagard<sup>®</sup> 701W

Solvent-free, siloxane emulsion concentrate

Description	<ul> <li>Sikagard<sup>°</sup> 701W is a solvent-free concentrate of silane modified siloxane emulsion. It must be diluted and the diluted liquid solution forms a water and chloride-ion repellent impregnation specifically formulated to seal absorbent cementitious surfaces and other masonry substrates.</li> <li>When diluted, use Sikagard<sup>°</sup> 701W as a colorless, non-vapor-barrier, water and chloride ion-repellent impregnation for absorbent materials.</li> <li>Treat concrete bridges, roadways, runways, parapet walls, precast, beams, columns, curbing, retaining walls, pavers, etc.</li> <li>Treat both new and existing structures.</li> <li>Treat masonry brickwork, stucco, etc.</li> <li>Porous architectural curtain wall panels.</li> <li>Use on steel-reinforced structures to reduce the corrosion and latent damage potential of chlorides.</li> </ul>		
Where to Use			
Advantages	<ul> <li>Sikagard<sup>°</sup> 701W is both an economical and simple-to-use sealer. Because of its unique ability to decrease water and chloride intrusion, Sikagard<sup>°</sup> 701W helps reduce the danger of rebar corrosion.</li> <li>Sikagard<sup>°</sup> 701W:</li> <li>Meets the standards of acceptability for concrete sealers established in NCHRP Report #244.</li> <li>Enhances concrete integrity.</li> <li>Reduces efflorescence.</li> <li>Improves resistance to frost and de-icing salts (chloride ion).</li> <li>Reduces dirt penetration.</li> <li>Does not act as a vapor barrier.</li> <li>May be applied to alkaline substrates.</li> <li>Will not degrade under UV exposure.</li> </ul>		
Coverage	100-250 ft²/gal., (diluted concentrate) depending on porosity of substrate. For proven results against chloride-ion intrusion, 125 ft²/gal. is recommended.		
Packaging	5 gal. pail.		

#### **Typical Data** (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

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Shelf Life	1 year in original, unopened containers (undiluted).		
Storage	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°- 24°C) before using. Protect from freezing.		
Color	white/opaque liquid		
Mix Ratio	1 gal: 4 gal. tap water yields 5 gals. of sealer.		
Viscosity	Approximately 5-20 cps.		
% solids	50% (silane modified siloxane polymer)		
% Non volatiles (ASTM D-5095)	Active level: 10% Solids: 10%		
VOC	211 g/l 46 g/l as diluted		
Flash Point	212°F		
NCHRP244 Report Series 2 Test			
<b>Reduction in Water Absorption</b>	91%		
Water Vapor Transmission	100%		
Reduction in Cl ion intrusion	90%		
Federal Spec SSW - 110C	Water absorption 0.97%		



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How to Use	
Surface Preparation	Before applying Sikagard <sup>®</sup> 701W, be sure surface is clean and sound. The best impregnation is achieved on a dry, very absorbent substrate. Remove all grease, curing compounds, surface treatments, coating, oils, etc.
	<b>Preparation Work:</b> Concrete and masonry surfaces, sandblast, high pressure water blast or use other mechanical means.
Mixing	Dilute Sikagard <sup>®</sup> 701W concentrate with tap water in an appropriately sized mixing container. Mix with a low speed (400-600 rpm) drill with Sika paddle or comparable drum mixer until uniformly blended. Make sure paddle is completely covered so as not to entrain air. For best results, Sikagard <sup>®</sup> 701W should be remixed if unused 24 hours after blending with water.
Application	Apply by roller, brush (horizontal surfaces), or spray. Any pooling of water repellent indicates overdosing on a dense substrate while rapid absorption indicates a porous substrate. Variations in concentration down to 8:1 for dense substrates or coverage area, and/or multiple wet-on-wet applications for porous substrates may be utilized to achieve optimal substrate treatment. Preliminary site test application is recommended to determine effective coverage and performance. <b>Maximum water repellency is gener-</b> <b>ally realized in 72 hours, but may take longer depending on surface and atmospheric conditions.</b>
Limitations	<ul> <li>Adjacent surfaces such as window frames, glass, stainless steel, aluminum, etc., must be masked before application.</li> <li>Do not apply at a temperature below 40°F.</li> <li>Do not apply when substrate temperature exceeds 120°F.</li> <li>Material is not recommended for below-grade waterproofing.</li> <li>Do not apply through standing water.</li> <li>Material is not intended to seal visible cracks or crevices from moisture intrusion.</li> <li>Material is not intended for waterproofing under hydrostatic pressure.</li> <li>Performance and penetration depth are dependent upon the surface composition.</li> <li>Do not use on green concrete.</li> <li>When over-coating: an on-site adhesion test is essential to determine actual compatibility.</li> <li>Sikagard<sup>®</sup> 701W is not a carbonation barrier.</li> </ul>

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# Sikagard<sup>®</sup> 740 W

Silane based reactive water repellent penetrating sealer

	Sikagard <sup>®</sup> 740 W is a one part low viscosity, reactive impregnation for concrete and cementitious substrates based on concentrated Silane emulsion. Sikagard <sup>®</sup> 740 W complies with the requirements of NCHRP Report 244 Series II & IV. Sikagard <sup>®</sup> 740 W is classified under the ALBERTA infrastructure and transportation specifications. Sikagard <sup>®</sup> 740 W complies with the highest requirements of EN 1504-2 for hydrophobic Impregnation (penetration depth class II & resistance to freeze-thaw cycles and chloride ion penetration).		
Where to Use	Sikagard <sup>®</sup> 740 W is used as v strates such as: Walkways and ramps. Industrial floors. Exposed aggregate. Pre-cast or pre-placed cor Masonry. Parking decks. Stadiums. Bridge Decks.	water-repellent penetrating sealer (hydrophobic treatment) for absorbent sub-	
Advantages	<ul><li>Reduction of absorption of</li><li>Not a vapor barrier.</li></ul>	ilable. bsorption, protection against driving rain and splashing on vertical areas. f aggressive or deleterious agents dissolved in water (i.e. chlorides). of concrete to freeze and thaw cycles and de-icing salts.	
Coverage	Coverage is entirely dependent on the porosity of the substrate. Extremely non-porous substrates may only require 1 coat. To ensure proper penetration depth, a field mock up is recommended: ~ 240-380 ft²/gal.		
Packaging	5 gallon pail, 55 gallon drum.		
	RESULTS MAY DIFFER BASED UP	and curing conditions @ 73°F (23°C) and 50% R.H.) PON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, ETHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.	
	TEMI ERATORE, AT LOATION ME		
	Shelf Life	9 months from date of production.	
		9 months from date of production. Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture.	
	Shelf Life	Store in unopened, undamaged and original sealed packaging in dry and cool condi-	
	Shelf Life Storage Conditions	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture.	
	Shelf Life Storage Conditions Product Conditioning	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F.	
	Shelf Life Storage Conditions Product Conditioning Sealer Type	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40%	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion <350 g/l	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion <350 g/l	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD Let	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -350 g/l -34 <10 mm	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD L- Alberta DOT Type 1a	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -350 g/l -34 <10 mm	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD L- Alberta DOT Type 1a Alberta DOT Type 1b	Store in unopened, undamaged and original sealed packaging in dry and cool conditions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -34 <350 g/l -10 mm 129ft²/US Gallon	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD L- Alberta DOT Type 1a Alberta DOT Type 1b Water Repellance	Store in unopened, undamaged and original sealed packaging in dry and cool conditions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -34	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD L- Alberta DOT Type 1a Alberta DOT Type 1b Mater Repellance Alkali Resistance Vapor Transmission	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -34 <350 g/l -34 <10 mm 129ft²/US Gallon 86.3% 85.3%	
	Shelf Life Storage Conditions Product Conditioning Sealer Type Active Ingredient Content Base VOC Depth of Penetration - OHD L- Alberta DOT Type 1a Alberta DOT Type 1b Mater Repellance Alkali Resistance Vapor Transmission	Store in unopened, undamaged and original sealed packaging in dry and cool condi- tions. Protect from moisture. Condition material between 40°F and 95°F. Alkylalkoxy Silane 40% Water emulsion -34 <350 g/l -34 <10 mm 129ft²/US Gallon 86.3% 85.3% 72.3%	

	NCHRP 244 Series IV:	(125 ft²/gal)		
	Absorbed Chloride	i -	79.1%	
	90 Day Salt Ponding -	AASHTO T 259	0.0-0.5"	93%
			0.5-1.0"	73%
		0714 0070	1.0-1.5"	74%
	Scaling Resistance - A 90 Day Salt Ponding -		None 0.0-0.5"	93%
	50 Day Sait Foliding -	AA31110 1 239	0.5-1.0"	73%
			1.0-1.5"	74%
	Scaling Resistance -	ASTM C672:	None	
How to Use				
Surface Preparation				s old concrete – however, due to its hi er penetration might then be expecte
				faces to be sealed must be dry, clea face treatments, coatings, oils, etc.
	shotblast, high press tion of the hydrophot	ure water, etc.). Crae bic treatment. If usin	cks in concrete more than 12	ed using mechanical means (sandbla 2 mils must be repaired prior to applic should be visibly dry (i.e. no damp/da should read 6% or lower.
Mixing	Sikagard <sup>®</sup> 740 W is s	supplied ready for us	e and must not be diluted.	
Application	Substrate and ambie	ent temperature for a	application should be betwe	en 40°F and 95°F. Sikagard <sup>®</sup> 740 W
	applied using a low-p not to let the product	ressure spray, airles run. Apply subseque	ss spray, brush or roller, in a	single pass from bottom up taking ca e required consumption is achieved.
Over Painting	Can be overcoated w recommendations.	ith water and solven	t based polymer paint - cont	act the proposed paint manufacturer
	etration of water is th	us prevented at pos damages such as	ssible weak spots or in the e paint flaking can be reduced	ny Sikagard <sup>®</sup> protective coatings. Pervent of damage to the top coat and the sign of a second to the second to the second secon
	Waiting time: minimu	m 5 hours, maximur	n 1 week.	
Limitations	to its high alkali n expected. Areas such as wi with Sikagard <sup>®</sup> 74 Areas not to be in taminated with Si Sikagard <sup>®</sup> 740 W In rare cases, Sik Cannot be overco Apply Sikagard <sup>®</sup> Refer to the lates method, etc.	esistance; it is still p ndow frames which a 40 W. npregnated such as kagard® 740 W. can damage some d agard® 740 W might bated with limewash 740 W onto a sample t Method Statement	ossible to apply it at an early still need to be painted must window panes need to be p coatings and bituminous pro t lead to light darkening of co or cement paint. e area to confirm consumption for detailed information rega	oncrete, apply sample areas first. on rates versus penetration depth. arding surface preparation, application
INS SHE PAR TO I REN	TRUCTIONS ON THE PR ET WHICH ARE AVAILA TMENT AT 800.933.7452 READ AND FOLLOW TH IT PRODUCT DATA SHE	ODUCT'S MOST CUP BLE ONLINE AT HTT NOTHING CONTAINE E WARNINGS AND IN ET, PRODUCT LABEL	RRENT PRODUCT DATA SHEE P://USA.SIKA.COM/ OR BY CA ED IN ANY SIKA MATERIALS R STRUCTIONS FOR EACH SIK. AND SAFETY DATA SHEET P	EAD AND FOLLOW THE WARNINGS AN ET, PRODUCT LABEL AND SAFETY DA ALLING SIKA'S TECHNICAL SERVICE D ELIEVES THE USER OF THE OBLIGATIC A PRODUCT AS SET FORTH IN THE CU RIOR TO PRODUCT USE. OR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ON
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Data : ment for ea	Sheet, product label and Saf at 800-933-7452. Nothing co	ety Data Sheet which are ntained in any Sika materi	available online at http://usa.sika.c	nstructions on the product's most current Prod om/ or by calling Sika's Technical Service Dep on to read and follow the warnings and instruct Data Sheet prior to
the cu Buyee EXPR SHAL THE U SALE CALL	Irrent Product Data Sheeti fi r's sole remedy shall be limitt IESS OR IMPLIED SHALL AP L NOT BE LIABLE UNDER AI ISE OF THIS PRODUCT IN AM OF SIKA PRODUCTS ARE ING 201-933-8800.	Ised as directed within sh ed to the purchase price PLY INCLUDING ANY WA NY LEGAL THEORY FOR S TANNER TO INFRINGE ON E SUBJECT SIKA'S TER	elf life. User determines suitability r replacement of product exclusive RRANTY OF MERCHANTABILITY O SPECIAL OR CONSEQUENTIAL DAN ANY PATENT OR ANY OTHER INTEL	g defects and to meet the technical properties of product for intended use and assumes all ris of labor or cost of labor. NO OTHER WARRANT R FITNESS FOR A PARTICULAR PURPOSE. S WAGES. SIKA SHALL NOT BE RESPONSIBLE F LECTUAL PROPERTY RIGHTS HELD BY OTHE AVAILABLE AT HTTP://USA.SIKA.COM/ OR
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Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



# Sikagard<sup>®</sup> 705 L

Silane based reactive water repellent penetrating sealer

Description	Sikagard <sup>®</sup> 705 L is a one part low viscosity, solvent free, reactive impregnation for concrete and cementitious substrates based on silane technology with 99% active ingredient. Sikagard <sup>®</sup> -705 L complies with the highest requirements of EN 1504-2 for hydrophobic Impregnation (penetration depth class II & resistance to freeze-thaw cycles and chloride ion penetration) and is tested in accordance with NCRHP 224 Series II & IV.				
Where to Use	Sikagard® 705 L is used as water-repellent penetrating sealer (hydrophobic treatment) for absorbent sub- strates such as:  Parking decks Bridge decks Concrete highway surfaces Ramps and Barriers Cooling Towers Stadiums Natural stone substrates Many other traffic bearing/reinforced concrete substrates and structures				
Advantages	<ul> <li>Excellent penetration (~100% active content).</li> <li>Economical and easy to use.</li> <li>Reduces capillary water absorption, protection against driving rain and splashing on vertical areas.</li> <li>Reduction of absorption of aggressive or deleterious agents dissolved in water (i.e. de-icing salts or chloride from marine environment).</li> <li>Non vapor barrier.</li> <li>Long term efficiency, deep penetration.</li> <li>Increases the resistance of concrete to freeze and thaw cycles and de-icing salts.</li> <li>Low VOC content.</li> <li>Resistant to sea water.</li> <li>Ready and easy to use.</li> </ul>				
Coverage	Dependent on absorbency of the substrate as well as the required penetration depth: 240-360 ft²/ gal per coa				
Cure Mechanism	Sikagard® 705 L does not require any special curing but must be protected from rain for at least 3 hours at +68°L				
Packaging	5 gal. pail, 55 gal. drum.				
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.Shelf Life2 years from production date.Storage ConditionsStore in unopened, undamaged and original sealed packaging in dry and cool conditions. Protect from moisture.Product ConditioningCondition material between 40°F and 95°F.Sealer TypeAlkylalkoxy Silane				
	Active Ingredient Content ~100%				
	<b>VOC</b> 327g/l				
	Application Thickness 7 mils				
	Depth of Penetration - OHD L-34 >10 mm				
	Flash Point     104°F (40°C)				
	Alberta DOT Type 1c				
	Water Repellance after Heavy Abrasion 85.3%				
	Alkali Resistance     84.8%       Vapor Transmission     106.9%				
	NCHRP 244: (125 ft²/gal)				

Series II - Absorbed Chloride

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88%



Series IV - Absorbed Chloride Water Absorption - ASTM C642 Scaling Resistance - ASTM C672 90 Day Salt Ponding - AASHTO T 259	98% .06% (24 hrs)/.1% (48 hrs) None 82.6% (.5-1")	
Jse Best results are achieved when Sikagard <sup>®</sup> 705 L is applied on 28 days old concrete – however, due to its alkali resistance, it is still possible to apply as early as 3 days. Testing should always be done to ensure pro penetration depth. Best results are achieved on a dry, very absorbent substrate. All surfaces to be sealed n be dry, clean, sound before application. Remove all grease, curing compounds, surface treatments, coatii oils, etc.		
<b>Preparation Work</b> : Concrete, masonry and natural stone surfaces must be prepared using mechanical means (sandblast, shotblast, pressure wash, etc.). Cracks in concrete more than 12 mils must be repaired prior to application of the hydrophobic treatment. If using water to clean, substrate should be visibly dry (i.e. no damp/ dark patches) before coating. Surface moisture as measured by Tramex <sup>®</sup> should read 6% or lower.		
Sikagard <sup>®</sup> 705 L is supplied ready to use and must not be diluted.		
Sikagard <sup>®</sup> 705 L is applied using a low-pressure spray, brush or roller, in a single pass from bottom up taking care not to let the product run. Apply subsequent coats wet on wet. Avoid ponding on the surface.		
Can be over-coated with water and solvent based polymer paint - contact the proposed paint manufacturer for recommendations. Sikagard <sup>®</sup> 705 L can be used as a water repellent primer under many Sikagard <sup>®</sup> protective coatings. Penetration of water is thus prevented at possible weak spots or in the event of damage to the top coat and the risk of consequential damages such as paint flaking can be reduced. Waiting time for Sikagard <sup>®</sup> over-coating: minimum 5 hours, maximum 1 week.		
<ul> <li>Best results are achieved when Sikagard<sup>®</sup> 705 L is applied on 28 days old concrete – however, due to its high alkali resistance, it is still possible to apply it at a very early age as 3 days. Testing should always be done prior to application on early age concrete to ensure sufficient penetration depth.</li> <li>Areas such as window frames which still need to be painted must be securely covered to avoid contact with Sikagard<sup>®</sup> 705 L.</li> <li>Areas not to be impregnated such as window panes need to be protected from being accidentally contaminated with Sikagard<sup>®</sup> 705 L.</li> <li>Sikagard<sup>®</sup> 705 L can damage some coatings and bituminous products.</li> <li>Sikagard<sup>®</sup> 705 L can lead to darkening of concrete, apply sample areas first.</li> <li>Cannot be over-coated with limewash or cement paint.</li> </ul>		
	<ul> <li>Water Absorption - ASTM C642</li> <li>Scaling Resistance - ASTM C672</li> <li>90 Day Salt Ponding - AASHTO T 259</li> <li>Best results are achieved when Sikagard® 705 alkali resistance, it is still possible to apply as eapenetration depth. Best results are achieved on be dry, clean, sound before application. Removoils, etc.</li> <li>Preparation Work: Concrete, masonry and nate (sandblast, shotblast, pressure wash, etc.). Cr application of the hydrophobic treatment. If usind dark patches) before coating. Surface moisture:</li> <li>Sikagard® 705 L is supplied ready to use and m Sikagard® 705 L is applied using a low-pressure care not to let the product run. Apply subseque</li> <li>Can be over-coated with water and solvent bass recommendations. Sikagard® 705 L can be use coatings. Penetration of water is thus prevente coat and the risk of consequential damages sure over-coating: minimum 5 hours, maximum 1 we</li> <li>Best results are achieved when Sikagard® 70 its high alkali resistance, it is still possible to always be done prior to application on early</li> <li>Areas such as window frames which still new with Sikagard® 705 L.</li> <li>Sikagard® 705 L.</li> </ul>	

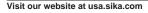
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### Sikagard<sup>®</sup> 706 Thixo Silane based water repellent impregnation cream

Description	80% content of active subs	tance. Sikagard <sup>®</sup> on (penetration d	ane based impregnation cream. It is a solvent free product with ~ 706 Thixo complies with the highest requirements of EN 1504-2 epth class II & resistance to freeze-thaw cycles and chloride ion II & IV.
Where to Use	Sikagard® 706 Thixo is user strates such as: Marine structures Pilings Piers Bridge decks Building facades	d as water-repell	ent impregnation (hydrophobic treatment) for absorbent sub-
Advantages	<ul> <li>deep penetration.</li> <li>Reduction of water absorption chloride from marine en</li> <li>No noticeable change o</li> <li>Not film forming.</li> <li>Ready to use.</li> <li>Long term efficiency, de</li> </ul>	orption. of aggressive or vironment). f water vapor per ep penetration.	ng wastage-free application of sufficient quantities and assuring deleterious agents dissolved in water (i.e. de-icing salts or meability. reeze and thaw cycles and de-icing salts.
Coverage	The exact amount depends agent might liquefy at the to	on the absorber	the operation to vertical and sloped surfaces without loss of materia cy of the substrate. At higher application rates, the impregnating and it may start to run off. A second coat may be applied at an y trial should be carried out to assess the penetration depth in the
Packaging	5 gallon pail, 55 gallon drur	n.	
		IPON STATISTICAL V IETHODS, TEST MET 12 months fro	73°F (23°C) and 50% R.H.) ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, 'HODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 'm date of production. naged and unopened original sealed packaging in dry and cool condi-
	Product Conditioning	+40°F min. / +	100°F max.
	Chemical Base	Silane (~ 80%	active ingredient)
	Density	~ 900 g/l	
	pH Value	~ 8	
	VOC	<320 g/l	
	Resistance to Freeze-Thaw-	Salts Stress	Comply (EN 13581)
	Depth of Penetration Class Test performed on concrete		≥ 10 mm
	Water Absorption	with a $W/C = 0.70$	
	Drying Rate Coefficient Res	istance	<7.5% (EN 13580)
	Alkali Resistance	istance	Class I: > 30% (EN 13579)
	Approvals/Standards - Conforms with NCHRP Repu- - Conforms to the requirement penetration depth, alkali resist	s of LPM-qualificati ance, water vapor t of the "Bro 2002" \$	< 10% V. on test to SIA 162/5, Report A-20 450-1 of 19.04.1999. (Water absorption diffusion, resistance to freeze thaw cycles and de-icing salts). Swedish National Road Administration (SNRA) publication No. VV2002:4
ka®	INSTRUCTIONS ON THE PRODUC SHEET WHICH ARE AVAILABLE ( PARTMENT AT 800.933.7452 NOT TO READ AND FOLLOW THE WA	CT'S MOST CURR ONLINE AT HTTP: HING CONTAINED RNINGS AND INST	IE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN ENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT /USA.SIKA.COW/ OR BY CALLING SIKA'S TECHNICAL SERVICE D IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO 'RUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUI ND SAFETY DATA SHEET PRIOR TO PRODUCT USE

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

How to Use Surface Preparation	Best results are achieved when Sikagard <sup>®</sup> 706 Thixo is applied on 28 days old concrete – however, due to its high alkali resistance, it is still possible to apply it as early as 3 days. Best results are achieved on a dry, very absorbent substrate. All surfaces to be sealed must be dry, clean, sound before application. Remove all grease, curing compounds, surface treatments, coatings, oils , etc.
	<b>Preparation Work</b> : Concrete and masonry surfaces must be prepared using mechanical means (sandblast, shotblast, high pressure water, etc.). Cracks in concrete more than 12 mils must be repaired prior to application of the hydrophobic treatment.
Mixing	Sikagard® 706 Thixo is supplied ready for use and should not be thinned or diluted.
Application	Sikagard® 706 Thixo is applied using airless spray, brush or roller, from bottom up.
Over Painting	Can be over-coated with water and solvent based polymer paint - contact the proposed paint manufacturer for recommendations. Sikagard <sup>®</sup> 706 Thixo can be used as water repellent primer under many Sikagard <sup>®</sup> protective coatings. Penetration of water is thus prevented at possible weak spots or in the event of damage to the top coat and the risk of consequential damages such as paint flaking can be reduced. Waiting time for Sikagard <sup>®</sup> over-coating: minimum 5 hours, maximum 1 week.
Limitations	<ul> <li>Best results are achieved when Sikagard® 706 Thixo is applied on 28 days old concrete – however, due to its high alkali resistance, it is still possible to apply it as early as 3 days.</li> <li>Areas such as window frames which still need to be painted must be securely covered to avoid contact with Sikagard® 706 Thixo.</li> <li>Areas not to be impregnated such as window panes need to be protected from being accidentally contaminated with Sikagard® 706 Thixo.</li> <li>Sikagard® 706 Thixo can damage some coatings and bituminous products.</li> <li>Sikagard® 706 Thixo can lead to darkening of concrete, apply sample areas first.</li> <li>Cannot be over-coated with limewash or cement paint.</li> <li>Apply Sikagard® 706 Thixo onto a sample area to confirm consumption rates versus required penetration depth.</li> </ul>

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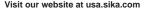
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Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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MEMBER .



# Sikagard<sup>®</sup> 550W Elastocolor

Description	Sikagard <sup>®</sup> 550W Elastoco 550W Elastocolor provide gasses. It offers high resis 550W Elastocolor will not	s protection to reinforce tance to chlorides and o	d concrete from other waterborne	the ingress of c e salts and exce	arbon dioxide ar ellent UV light res	nd other aggressiv sistance. Sikagaro
Where to Use	Protective, crack-bridging to cracking/dynamic mov the top coat in complete	ement. For use on bu	ilding and civil			• • •
Advantages	<ul> <li>Can bridge dynamica</li> <li>Excellent carbonation</li> <li>Vapor permeable.</li> <li>Provides resistance to</li> <li>Crack bridging prope</li> <li>Excellent long term U</li> <li>Can be applied by brid</li> <li>Good color stability.</li> <li>Extremely resistant to</li> <li>Non-flammable as a size a size and size</li></ul>	barrier. o weathering and fros rties maintained at lov V light resistance. ush, roller, or airless s o dirt pick up and mildo system.	v temperatures. pray.			
Coverage	Theoretical yield per coa 'dry' film thickness: 8 mi Consumption is depende unavoidable variation in a first coat in a two coat	s/coat. Normal coatin ent on porosity of subs applied film thickness	g system is two trate. In additio , loss and waste	o coats at a to n, allowance n e. Sikagard <sup>®</sup> El	tal dry film thick nust be made for	ness of 16 mils or surface profile
Packaging	5 gal. Pails					
	Typical Data					
		ER BASED UPON STATIST				
	Shelf Life		inal unopened of			
	Storage Condit	before using.	)°-95°F (4°-35°C Protect from free	) Condition mat zing. If frozen d		(15°-25° C)
	Colors		colors. Custom			ç .
	Pot Life		contamination,		otecting the syst	em from mois-
	Solids Content Smooth 550W	by weight 62%	by volume 55%			
	Sikagard <sup>®</sup> 552W		17%			
	Tensile Propert	ies (ASTM D-412 mod	ified after 21 da	ays cure)		
	Tensile Strength		200 psi			
	Elongation at Br		625% at 73°	°F (23°C)		
	Tensile Strength		1100 psi			
	Waiting Time (b	eak at 0°F (-18°C) <b>etween coats) and Cu</b> 52W Primer+Sikagard®	•	<b>45°F (8°C)</b> 24 hours	<b>68°F (20°C)</b> 12 hours 8 hours	85°F (30°C) 6 hours
	Rain resista	nt (at 75% R.H.) ting old coatings will ind	crease the waitir	12 hours 24 hours og times by 100	4 hours	6 hours 2 hours
	Water Vapor Di μ - value H <sub>2</sub> O (di	fusion (at 16 mils = 4 ffusion coefficient) = 2, nt air thickness) = 2.6 f	00 microns dry 146		·	
	2	diffusion (at 16 mils	= 400 microns	dry film thickn 000 hours	ess)	
	R (equivalent air	oncrete thickness) =	214,000 299 ft. (9 9 inches			
	Static (at -4°	(at 16 mils = 400 mic) F/-20°C) 000 cycles (at -4°F/-20°	30 mils	(0.75 mm) (0.3 mm)		
		Permeability (ASTM I		Perms		
R	PRIOR TO EACH USE OF ANY		•	NAYS READ AN		



#### Resistance to Wind Driven Rain (TT-C-555B) No passage of water through the coating Flame Spread and Smoke Development (ASTM E-84-94) Flame Spread: 5 Smoke Development: 5 Class Rating: A

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	Flame Spread: 5 Smoke Development: 5 Class Rating: A
	Weathering (ASTM G-23) 10,000 hours Excellent, no chalking or cracking
How to Use	
Surface preparation	All surfaces to be coated must be dry, clean, sound, and frost free with curing compound residues and any other foreign matter removed. An open textured sandpaper like surface is ideal (CSP-3). Where necessary, surfaces should be prepared mechanically by blast cleaning or high speed pressure waterjetting. Allow adequate time for drying. Bug holes, cracks or irregularities of substrate should be filled and leveled with SikaTop <sup>®</sup> , SikaRepair <sup>®</sup> , SikaQuick <sup>®</sup> or acrylic surface fillers as appropriate. Cracks 1/32" or greater should be routed and sealed with a polyurethane sealant before coating. <b>Priming</b> : All porous areas or concrete with excessive porosity should be primed using Sikagard <sup>®</sup> 552W Primer
	or SikaLatex® R to allow easy application of Sikagard® 550W Elastocolor.
Mixing	Stir the coating to ensure uniformity using a slow speed (400-600 rpm) drill and 1/2" jiffy style mixing paddle. To minimize color variation when using multiple units, blend two pails of Sikagard <sup>®</sup> 550W Elastocolor. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperatures (ambient and substrate) 45°-95°F (7°-35°C). Sikagard® 550W Elastocolor can be applied by brush, roller, or spray over entire area moving in one direction. Allow a minimum of two hours prior to re-coating. At lower temperatures and high humidity, waiting time will be prolonged. At higher temperatures, work carefully to maintain a wet edge. As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship, material and aesthetics. <b>NOTE:</b> To achieve a dry film thickness of 16 mils, two coats should be anticipated. For maximum adhesion, (especially on porous substrates) the use of Sikagard® 552W is recommended. Sikagard® 552W primer can be applied by brush or roller. Brushing provides more even and pore free coats and better penetration.
Limitations	<ul> <li>Not designed for use as a traffic bearing surface.</li> <li>Substrates must be dry prior to application.</li> <li>Minimum age of concrete prior to application is 14 days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Minimum age of SikaTop<sup>®</sup>, SikaRepair<sup>®</sup>, or SikaQuick<sup>®</sup> prior to application is three days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Allow sufficient time for substrate to dry after rain or other inclement conditions.</li> <li>Protect from freezing. If frozen, discard.</li> <li>Sikagard<sup>®</sup> 550W Elastocolor should not be applied at relative humidity greater than 90%, or if rain is forecast within the specified rain resistance period.</li> <li>Maximum crack width 1/32".</li> <li>During application, regular monitoring of the wet film thickness and material consumption is advised to ensure that the correct layer thickness is achieved. When over-coating existing coatings, compatibility and adhesion testing is recommended.</li> <li>When over-coating Sikaflex<sup>®</sup> sealants, a prime coat of Sikagard<sup>®</sup> 550W Elastocolor Accent Base Coat may be necessary over the sealant to minimize dirt pick up on cured coating.</li> <li>Do not store Sikagard<sup>®</sup> 550W Elastocolor in direct sunlight for prolonged periods.</li> <li>Strong winds can cause shrinkage if material is applied at lower temperatures.</li> <li>Ensure that the primer is thoroughly dry before over-coating to prevent formation of bubbles and blisters, particularly in warmer weather.</li> <li>Not recommended for roofing.</li> </ul>
INS SHE PAR TO I	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND IRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Fracc. Industrial Balvanera Corregidora, Queretaro

C.P. 76920 Phone: 52 442 2385800

Fax: 52 442 2250537

Visit our website at usa.sika.com

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# Sikagard<sup>®</sup>-550 W CA Elastocolor

	Sikaga other a	ard 550 W CA Elastocol ard 550 W CA Elastocolo aggressive gasses. It offi ince. Sikagard 550 W CA ire.	r provides protection ers high resistance	on to reinforced e to chlorides ar	concrete from nd other water	the ingress of c borne salts and	arbon dioxide and excellent UV light
Where to Use	to crac	ctive, crack-bridging coa cking/dynamic moveme o coat in complete repai	nt. For use on buil	lding and civil e			
Advantages	<ul> <li>Exc</li> <li>Vap</li> <li>Pro</li> <li>Cra</li> <li>Exc</li> <li>Ca</li> <li>Go</li> <li>Ext</li> <li>No</li> </ul>	n bridge dynamically mo cellent carbonation barr por permeable. wides resistance to wea ack bridging properties r cellent long term UV ligh n be applied by brush, r od color stability. tremely resistant to dirt n-flammable as a system sily maintained silk finis	ier. athering and frost. maintained at low nt resistance. roller, or airless sp pick up and milde m.	temperatures. pray.			
Coverage	ʻdry' fil Consu unavo	etical yield per coat: 100 Im thickness: 8 mils/coa Imption is dependent or idable variation in applie coat in a two coat syste	at. Normal coating a porosity of subst ed film thickness,	system is two rate. In additior loss and waste	coats at a tot a, allowance m . Sikagard® El	tal dry film thick nust be made fo	ness of 16 mils. r surface profile,
		Typical Data					
		RESULTS MAY DIFFER BA TEMPERATURE, APPLICA					
		Shelf Life	2 years in origi	nal unopened co	ontainer.		
		Storage Conditions	before using. P	rotect from freez	ing. If frozen di		(15°-25° C)
		Colors		olors. Custom c	-		
		Pot Life	ture, freezing, o	ided proper care contamination, c		otecting the syste	em from mois-
		VOCs	ture, freezing, o 42 g/L.	contamination, c		otecting the syste	em from mois-
		VOCs Solids Content Smooth 550W	ture, freezing, o			otecting the syste	em from mois-
		VOCs Solids Content	ture, freezing, o 42 g/L. <b>by weight</b> 62% 20%	by volume 55% 17%	or evaporation.	otecting the syste	em from mois-
		VOCs Solids Content Smooth 550W Sikagard <sup>®</sup> 552W Tensile Properties (A	ture, freezing, o 42 g/L. <b>by weight</b> 62% 20%	contamination, c by volume 55% 17% fied after 21 day	ys cure)	otecting the systematic	em from mois-
		VOCs Solids Content Smooth 550W Sikagard® 552W Tensile Properties (A Tensile Strength	ture, freezing, o 42 g/L. <b>by weight</b> 62% 20% <b>ASTM D-412 modif</b> F (-18°C)	by volume 55% 17% fied after 21 day 285 psi	ys cure)	otecting the syste	em from mois-
		VOCs Solids Content Smooth 550W Sikagard® 552W Tensile Properties (A Tensile Strength Elongation at Break Tensile Strength at 0°I Elongation at Break ai Waiting Time (betwe Sikagard® 552W F Sikagard® 550W Rain resistant (at	ture, freezing, o 42 g/L. by weight 62% 20% ASTM D-412 modif F (-18°C) t 0°F (-18°C) en coats) and Cur Primer+Sikagard® 5 75% R.H.)	contamination, c by volume 55% 17% fied after 21 day 285 psi 610% at 73°F 1100 psi 225% ring Rates 550W	ys cure) = (23°C) 45°F (8°C) 24 hours 12 hours 24 hours	<b>68°F (20°C)</b> 12 hours 8 hours 4 hours	em from mois- 85°F (30°C) 6 hours 6 hours 2 hours
		VOCs Solids Content Smooth 550W Sikagard® 552W Tensile Properties (A Tensile Strength Elongation at Break Tensile Strength at 0°I Elongation at Break at Waiting Time (betwe Sikagard® 552W A Sikagard® 550W Rain resistant (at (Note: Over coating of Water Vapor Diffusiof µ - value H <sub>2</sub> O (diffusiof	ture, freezing, o 42 g/L. by weight 62% 20% ASTM D-412 modif F (-18°C) t 0°F (-18°C) en coats) and Cur Primer+Sikagard® 5 75% R.H.) old coatings will inco n (at 16 mils = 40 n coefficient) = 2,1	contamination, c by volume 55% 17% fied after 21 day 285 psi 610% at 73°F 1100 psi 225% ring Rates 550W	ys cure) = (23°C) 45°F (8°C) 24 hours 12 hours 24 hours 24 hours g times by 100	<b>68°F (20°C)</b> 12 hours 8 hours 4 hours %)	<b>85°F (30°C)</b> 6 hours 6 hours
		VOCs Solids Content Smooth 550W Sikagard® 552W Tensile Properties (A Tensile Strength Elongation at Break Tensile Strength at 0°D Elongation at Break at Waiting Time (betwe Sikagard® 552W A Sikagard® 552W Rain resistant (at (Note: Over coating of Water Vapor Diffusion μ - value H <sub>2</sub> O (diffusion SdH <sub>2</sub> O (equivalent air Carbon dioxide diffur	ture, freezing, o 42 g/L. by weight 62% 20% ASTM D-412 modif F (-18°C) t 0°F (-18°C) en coats) and Cur Primer+Sikagard® 5 75% R.H.) old coatings will incr on (at 16 mils = 40 n coefficient) = 2,1 thickness) = 2.6 ft. sion (at 16 mils =	contamination, c by volume 55% 17% fied after 21 day 285 psi 610% at 73°F 1100 psi 225% ring Rates 550W rease the waiting 00 microns dry 46 . (0.8 m) = 400 microns do	ys cure) = (23°C) 45°F (8°C) 24 hours 12 hours 24 hours 24 hours g times by 100 film thickness	68°F (20°C) 12 hours 8 hours 4 hours %) 5)	<b>85°F (30°C)</b> 6 hours 6 hours
		VOCs Solids Content Smooth 550W Sikagard® 552W Tensile Properties (A Tensile Strength Elongation at Break Tensile Strength at 0°I Elongation at Break at Waiting Time (betwee Sikagard® 552W R Sikagard® 550W Rain resistant (at (Note: Over coating of Water Vapor Diffusion µ - value H <sub>2</sub> O (diffusion SdH <sub>2</sub> O (equivalent air	ture, freezing, o 42 g/L. by weight 62% 20% ASTM D-412 modif F (-18°C) t 0°F (-18°C) en coats) and Cur Primer+Sikagard® 5 75% R.H.) old coatings will inco n (at 16 mils = 40 n coefficient) = 2.6 ft. sion (at 16 mils = n coefficient) = n coefficient) = n coefficient) = n coefficient) =	contamination, c by volume 55% 17% fied after 21 day 285 psi 610% at 73°F 1100 psi 225% ring Rates 550W rease the waiting 00 microns dry 46 . (0.8 m) = 400 microns do	ys cure) = (23°C) 45°F (8°C) 24 hours 12 hours 24 hours g times by 100 film thickness Iry film thickn 100 hours 1 m)	68°F (20°C) 12 hours 8 hours 4 hours %) 5)	<b>85°F (30°C)</b> 6 hours 6 hours



	Moisture Vapor Permeability (ASTM E-96)       14.5 Perms         Resistance to Wind Driven Rain (TT-C-555B)       No passage of water through the coating         Share Oversed on the Development of CATM E - 04.04       Solution
	Flame Spread and Smoke Development (ASTM E-84-94)         Flame Spread: 5       Smoke Development: 5 Class Rating: A         Weathering (ASTM G-23)       10,000 hours       Excellent, no chalking or cracking
Packaging	5 gal. Pails
How to Use Surface preparation	All surfaces to be coated must be dry, clean, sound, and frost free with curing compound residues and any other foreign matter removed. An open textured sandpaper like surface is ideal (CSP-3). Where necessary, surfaces should be prepared mechanically by blast cleaning or high speed pressure waterjetting. Allow adequate time for drying. Bug holes, cracks or irregularities of substrate should be filled and leveled with SikaTop <sup>®</sup> , SikaRepair <sup>®</sup> , SikaQuick <sup>®</sup> or acrylic surface fillers as appropriate. Cracks 1/32" or greater should be routed and sealed with a polyurethane sealant before coating.  Priming: All porous areas or concrete with excessive porosity should be primed using Sikagard <sup>®</sup> 552W Primer or SikaLatex <sup>®</sup> R to allow easy application of Sikagard <sup>®</sup> 550 W CA Elastocolor.
Mixing	Stir the coating to ensure uniformity using a slow speed (400-600 rpm) drill and 1/2" jiffy style mixing paddle. To minimize color variation when using multiple units, blend two pails of Sikagard <sup>®</sup> 550 W CA Elastocolor. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperatures (ambient and substrate) 45°-95°F (7°-35°C). Sikagard® 550 W CA Elastocolor can be applied by brush, roller, or spray over entire area moving in one direction. Allow a minimum of two hours prior to re-coating. At lower temperatures and high humidity, waiting time will be prolonged. At higher temperatures, work carefully to maintain a wet edge. As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship, material and aesthetics. <b>NOTE:</b> To achieve a dry film thickness of 16 mils, two coats should be anticipated. For maximum adhesion, (especially on porous substrates) the use of Sikagard® 552W is recommended. Sikagard® 552W primer can be applied by brush or roller. Brushing provides more even and pore free coats and better penetration.
Limitations	<ul> <li>Not designed for use as a traffic bearing surface.</li> <li>Substrates must be dry prior to application.</li> <li>Minimum age of concrete prior to application is 14 days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Minimum age of SikaTop®, SikaRepair®, or SikaQuick® prior to application is three days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Allow sufficient time for substrate to dry after rain or other inclement conditions.</li> <li>Protect from freezing. If frozen, discard.</li> <li>Sikagard® 550 W CA Elastocolor should not be applied at relative humidity greater than 90%, or if rain is forecast within the specified rain resistance period.</li> <li>Maximum crack width 1/32".</li> <li>During application, regular monitoring of the wet film thickness and material consumption is advised to ensure that the correct layer thickness is achieved. When over-coating existing coatings, compatibility and adhesion testing is recommended.</li> <li>When over-coating Sikaflex® sealants, a prime coat of Sikagard® 550 W CA Elastocolor Accent Base Coat may be necessary over the sealant to minimize dirt pick up on cured coating.</li> <li>Do not store Sikagard® 550 W CA Elastocolor in direct sunlight for prolonged periods.</li> <li>Strong winds can cause shrinkage if material is applied at lower temperatures.</li> <li>Ensure that the primer is thoroughly dry before over-coating to prevent formation of bubbles and blisters, particularly in warmer weather.</li> <li>Not recommended for roofing.</li> </ul>
REPC REPC For fu actual before Prior t Data S ment a for eau produ SIKA v the cu Buyer EXPRI SHALL THE U SALE CALLI Visit o Region S 2 L	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND TRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- TIMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.         CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY. Three information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the a using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.         to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product sheet, product label and Safety Data Sheet which are available online at http://usa.slika.com/ or by calling Sika's Fochnical Service Depart- tion and solves oraling on this of this any Sika materials relieves the user of the obligation to read and follow the warnings and instruction ch Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to ct use.         warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on irrent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. So Rot IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA LNOT BE LIABLE UNDER ANY LEGAL THEORY F

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# Sikagard<sup>®</sup> 552W Primer

Adhesion Promoter, Surface Conditioner for Concrete Surfaces

Sikagard <sup>®</sup> 552W Primer is a one component, penetrating, adhesion promoter for priming concrete and other masonry surfaces prior to the application of acrylic emulsion coatings. Sikagard <sup>®</sup> Primers will reduce the consumption rate of the subsequent coat by providing a uniformly absorptive surface.
Primer coat for concrete and mineral substrates or those showing signs of higher than average porosity when over-coating existing coatings which are firmly bonded.
<ul> <li>Resistant to water vapor diffusion.</li> <li>Environmentally friendly.</li> <li>Water-based.</li> <li>Excellent wetting properties.</li> <li>Reduces consumption of subsequent coat.</li> </ul>
Theoretical: 320 ft²/gal.
All coverages dependent on porosity of substrate. Allowances must be made for surface profile, unavoidable variations in applied film thickness, loss and waste. In addition, two coats may be required on very absorbent surfaces.
5 gal. re-closable metal pail.
-

### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 yea	rs in original, unopened	l container.
Storage Conditions		dry at 40°-75°F (4°-24° 5°F (18°-24°C) before u	°C). Condition material to using.
Color	Milky-	white, opaque.	
Solids Content	20% k	oy volume.	
Application Temperatures	45°-9	0°F (7°-32°C)	
Waiting Times			
Uncoated masonry of conc 45°F (8° 68°F (20 86°F (30	°C) 0°C)	<b>Resistant to Rain</b> 2 hr. 30 min. 15 min.	<b>Prior to Over-coating</b> 12 hr. 5 hr. 2.5 hr.
Previously Coated Substrat 45°F (8 68°F (2 86°F (3	°C) 0°C)	<b>Resistant to Rain</b> 4 hr. 4 hr. 30 min.	<b>Prior to Over-coating</b> 24 hr. 24 hr. 6 hr.



How to Use	
Surface Preparation	All surfaces to be primed must be dry, clean, sound, and free of curing compound residues and other bond inhibiting material.
	<b>Preparation Work</b> : Concrete and masonry surfaces - blast clean, high pressure water blast or use other approved mechanical means to achieve an slightly open, roughened substrate.
Mixing	Stir thoroughly using a slow speed (400-600 rpm) drill and paddle prior to application.
Application	Any areas of glass should be protected by masking.
	Fill all visible hairline cracks and surface defects with appropriate Sika® repair mortar, leveling mortar or Sikagard® surface fill prior to applying primers. Sikagard® Primers can be applied by brush, roller or spray equipment. Brushing provides more even and pore free coats with better penetration. Allow a minimum of 4 hours prior to re-coating. At lower temperature, the waiting time will be prolonged.
Limitations	<ul> <li>When over-coating existing coatings, compatibility and adhesion testing is essential.</li> <li>Ensure primer is thoroughly dry before over-coating to prevent formation of bubbles and blisters, particularly in warmer weather.</li> <li>Ensure that the primer penetrates completely without forming a glaze on the surface.</li> <li>Extremely absorbent substrate may require more than one coat of primer.</li> <li>Sikagard<sup>®</sup> primers should not be stored in direct sunlight for prolonged periods of time.</li> </ul>

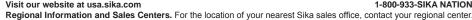
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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



Sika Corporation 201 Polito Avenue

Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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**Product Data Sheet** Edition 10.20.2014 Sika<sup>®</sup> Bonding Primer

# Sika<sup>®</sup> Bonding Primer Two-component, rapid curing, water-based epoxy primer

Description	<b>.</b> .	n water (Part A), and a wa	consisting of two components: a pre- terborne modified polyamine solution y viscous.
Where to Use	Suitable for use on most sound effect is required.	substrate surfaces where	both a penetrative and surface-lying
Advantages	<ul> <li>Fast cure allows same-day</li> <li>Low odor, low VOC formula</li> <li>Compatible with most comm</li> </ul>	tion.	
Coverage	350 ft²/gal on non-absorbent sm 300 ft²/gal on prepared, dry con 200 ft²/gal on absorbent gypsum <b>Note:</b> Rough, porous, or absorb	crete. a and cementitious cover be	oards. Iditional primer and will reduce yield.
Cure Mechanism	Chemical and evaporative cure.		
Chemical Resistance	Not intended for direct exposure	).	
Packaging:	Bonding Primer Kit 1 Gallon 5 Gallons	Part A 0.8 US Gallons 4 US Gallons	Part B 0.2 US Gallons 1 Gallons

### Typical Data (Material and curing conditions @ 75°F (24°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	24 months in original, unopened and undamaged sealed containers.
Storage	Store dry at 35°-77°F (2°-25°C).
Product Conditioning	Condition material to 50°-77°F (10°-25°C) before using for ease of application.
Pot Life	12 hours
Total Volume Solids (ASTM D-2697)	15%
VOCs (ASTM D-2369-81)	12.5 g/l
Flash Point	110°F (59°C)
Service Temperature	-22° to 176°F (-30° to 80°C) intermittent.



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How to Use Surface Preparation	All substrate surfaces shall be clean, dry and sound. Acceptable substrates include: sound concrete and masonry, wood and plywood, mineralized asphaltic cap sheet, sprayed polyurethane foam, gypsum and cementitious cover boards, and coated glass-faced polyisocyanurate foam boards. Reference separate System Data Sheet for specific surface preparation requirements.
Mixing	Mix ratio is 4:1 (A:B) by weight and volume. Add Part B into Part A and mix with stir stick or mechanical mixer (Jiffy) at low speed. Avoid adding air into the primer during mixing. When fully mixed, the primer should be free from streaks and of a uniform light green color. <b>Do not break down kits into smaller quantities.</b>
Application	Apply by brush or phenolic resin core roller at the recommended rate. Correct amount of primer will saturate the substrate and leave a slight film on the substrate top surface. Apply evenly without puddling.
Removal	Remove wet primer with clean water. Once cured, primer can only be removed by mechanical means.
Over Painting	Allow primer to cure completely prior to applying membrane resin. 1 hour at 95°F 2 hours at 68°F 4 hours at 41°F Ideally, membrane resin will be applied within 24 hours of primer application. This is required for applications in tropical/subtropical environments to avoid UV-related primer deterioration. Maximum primer exposure is 7 days. Primer exposed longer than 7 days, and primer exposed to water during curing and exhibiting a chalky appearance, must be reprimed. Deteriorated primer must be mechanically removed before primer reapplication.
	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C).</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex® Concrete Moisture Encounter Meter.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>Do not thin with solvents.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.</li> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/ structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> <li>When applying over existing coatings or membranes compatibility and adhesion testing, subsequent approval by Technical Services is required.</li> <li>On grade concrete decks should not</li></ul>
ka®	<ul> <li>by Technical Services.</li> <li>Not recommended for metal substrates.</li> </ul> PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Fracc. Industrial Balvanera

Corregidora, Queretaro C.P. 76920

Phone: 52 442 2385800 Fax: 52 442 2250537

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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RESPONSIBLE CARE



# Sikagard<sup>®</sup> 570

# Elastomeric, UV curable, high build, fully reinforceable, acrylic facade coating.

Description				
Where to Use	Sikagard 570 is an elastomeric, UV curir 570 provides protection to reinforced co It offers high resistance to chlorides an 570 will not act as a vapor barrier and v exposure to UV radiation present in sun harder than the bulk of the coating be Similarly, as the coating does eventually Protective, crack-bridging coating for co	ncrete from the ingress of ca d other waterborne salts ar vill enhance the appearance light, which aids in the devel neath. This leads to a more begin to wear, the exposed increte, mortar, stucco, mase	arbon dioxide ar and excellent UV of the structure lopment of a sur durable surface material will ma onry, and exterio	nd other aggressive gasses light resistance. Sikagar e. Sikagard 570 is cured b face skin which is relative and reduced dirt pickup intain its hardened surface or finishing systems subject
	to cracking/dynamic movement. For us the top coat in complete repair and prot		neering structure	es subject to cracking or a
Advantages	<ul> <li>UV curable top coat for a more dura</li> <li>Can bridge dynamically moving crassing</li> <li>Excellent carbonation barrier</li> <li>Vapor permeable</li> <li>Provides resistance to weathering a</li> <li>Crack bridging properties maintaine</li> <li>Excellent long term UV light resistant</li> <li>Can be applied by brush, roller, or a</li> <li>Good color stability</li> <li>Extremely resistant to dirt pick up a</li> <li>Nontoxic, nonflammable as a system</li> </ul>	cks and frost ad at low temperatures nce airless spray nd mildew	sser dirt pickup.	
	<ul> <li>Easily maintained silk finish</li> </ul>			
Packaging	5 gallon			
Packaging Coverage	Theoretical yield per coat: 100 sq. ft./gal 'dry' film thickness: 8 mils/coat. Norma Consumption is dependent on porosity unavoidable variation in applied film thi first coat in a two coat system of Sikaga	al coating system is two coa of substrate. In addition, al ckness, loss and waste. Sik ard 570.	ats at a total dr llowance must b agard Elastic B	y film thickness of 16 mils be made for surface profile ase Coat can be used as
	Theoretical yield per coat: 100 sq. ft./gal 'dry' film thickness: 8 mils/coat. Norma Consumption is dependent on porosity unavoidable variation in applied film thi first coat in a two coat system of Sikaga Theoretical yield for reinforced system: 4 ness. A top coat at 80 sq.ft./gal to fully allowance must be made for surface pro <b>Typical Data</b> RESULTS MAY DIFFER BASED UPON STATIST	al coating system is two coa of substrate. In addition, al ckness, loss and waste. Sik ard 570. 40 sq.ft./gal for the base coa encapsulate the reinforceme ofile, unavoidable variation i	ats at a total dr llowance must b agard Elastic B t with reinforcen ent: 20 mils 'wet n applied film th PON MIXING METH	y film thickness of 16 mile be made for surface profile ase Coat can be used as nent: 40 mils 'wet' film thick ' film thickness. In addition ickness, loss and waste.
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	<sup>*</sup> After 2,000 hours             µ - value CO <sub>2</sub> (diffusion coefficient) = 214,000             R (equivalent air thickness) = 299 ft. (91 m)             Sc (Equivalent concrete thickness) = 9 inches (23 cm)          *accelerated weathering          Crack-Bridging (at 16 mils = 400 microns DFT)          Static (at -4°F/-20°C)            Joynamic>1000 cycles (at -4°F/-20°C)            Ja mils (0.75 mm)          Dynamic>1000 cycles (at -4°F/-20°C)            12 mils (0.3 mm)          Moisture Vapor Permeability (ASTM E-96)            14.5 Perms          Resistance to Wind Driven Rain (TT-C-555B)         No passage of water through the coating          Flame Spread and Smoke Development (ASTM E-84-94)          Flame Spread: 5       Smoke Development: 5         Class Rating: A         Weathering (ASTM G-23)       10,000 hours
Curing Mechanism	UV curing requires sunlight to harden the surface. This produces a tactile coating reflecting the composite nature of the coating film. In the complete absence of sunlight a softer surface will result although the product will dry cure.
How To Use Surface Preparation	Surface preparation: All surfaces to be coated must be dry, clean, sound, and frost free with curing compound residues and any other foreign matter removed. An open textured sandpaper like surface is ideal (CSP-3). Where necessary, surfaces should be prepared mechanically by blast cleaning or high speed pressure water jetting. Allow adequate time for drying. Bugholes, cracks or irregularities of substrate should be filled and leveled with SikaTop, SikaRepair, SikaQuick or acrylic surface fillers as appropriate
Mixing	<ul> <li>Priming: All porous areas or concrete with excessive porosity should be primed using Sikagard 552W Primer or SikaLatex R to allow easy application of Sikagard 570.</li> <li>Crack Treatment: Treatment of existing cracks and reinforcement Sikagard 570 is designed to accommodate existing cracks and those starting from "zero" up to defined limits. The product will fill and bridge minor static cracks up to 0.04" if applied more thickly on those areas. Static cracks larger than 0.04" should be filled with acrylic filler prior to being coated with Sikagard 570. Dynamic cracks can also be addressed this way as well, but should be filled prior with a flexible sealant. It is advisable to also embed Sika Flexitape for dynamic cracks over 0.04", as well as with construction, control, and expansion joints. Multi cracked or crazed surfaces should be either repaired beforehand or the Sikagard 570 system should be completely reinforced with Sika's Reemat Standard Glass Fiber Matt.</li> </ul>
Mixing Application	Stir the coating to ensure uniformity using a slow speed (400-600 rpm) drill and 1/2" jiffy style mixing paddle. To minimize color variation when using multiple units, blend two pails of Sikagard 570. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperatures (ambient and substrate) 45 - 95 F (7-35 C). Sikagard 570 can be applied by brush, roller, or spray over entire area moving in one direction. Allow a minimum of two hours prior to recoating. At lower temperatures and high humidity, waiting time will be prolonged. At higher temperatures, work carefully to maintain a wet edge. As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship, material and aesthetics. <b>NOTE:</b> To achieve a dry film thickness of 16 mils, two coats should be anticipated. For maximum adhesion, (especially on porous substrates) the use of Sikagard 552W is recommended. Sikagard 552W primer can be
Limitations	<ul> <li>applied by brush or roller. Brushing provides more even and pore free coats and better penetration.</li> <li>Not designed for use as a traffic bearing surface</li> <li>Substrates must be dry prior to application</li> <li>Minimum age of concrete prior to application is 14 days, depending on curing and drying conditions (moisture content must be below 5%)</li> <li>Minimum age of SikaTop, SikaRepair, or SikaQuick prior to application is three days, depending on curing and drying conditions (moisture content must be below 5%)</li> <li>Allow sufficient time for substrate to dry after rain or other inclement conditions</li> <li>Protect from freezing. If frozen, discard</li> <li>Sikagard 570 should not be applied at relative humidity greater than 90%, or if rain is forecast within the specified rain resistance period</li> <li>Maximum crack width 1/32"</li> <li>During application, regular monitoring of the wet film thickness and material consumption is advised to ensure that the correct layer thickness is achieved. When over-coating existing coatings, compatibility and adhesion testing is recommended</li> <li>When over-coating Sikaflex sealants, a prime coat of Sikagard 570 Accent Base Coat may be necessary over the sealant to minimize dirt pick up on cured coating.</li> <li>Do not store Sikagard 570 in direct sunlight for prolonged periods</li> <li>Strong winds can cause shrinkage if material is applied at lower temperatures</li> <li>Ensure that the primer is thoroughly dry before over-coating to prevent formation of bubbles and blisters, particularly in warmer weather</li> <li>Not recommended for roofing</li> </ul>
	RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA IEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION O READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- ENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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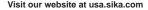
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

C.P. 76920 Phone: 52 442 2385800

Fax: 52 442 2250537



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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## Sikagard<sup>®</sup> 62 High-build, protective, solvent-free, colored epoxy coating

Description	High-build, protective, solvent-free, colored epoxy coating.
Where to Use	Use as a high build, corrosion-resistant, protective coating, as a protective lining for secondary containmen structures or as a seamless flooring system.
Advantages	<ul> <li>Exceptional tensile strength.</li> <li>Good chemical resistance for long-term protection.</li> <li>Convenient A:B = 1:1 mixing ratio.</li> <li>Easy, paint-like viscosity.</li> <li>Available in 3 standard colors: gray, red, and tan.</li> <li>Excellent bonding to all common structural substrates.</li> <li>Super abrasion resistance for long-term wear.</li> <li>Sikagard<sup>®</sup> 62 gray in ANSI/NSF 61 potable water compliant</li> <li>Material is USDA certifiable.</li> </ul>
Coverage	Approximately 150-250 ft. <sup>2</sup> /gal. depending on condition of substrate.
Packaging	4 gal. units; 1 qt. units, 12/case.
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life         2 vears in original, unopened containers.
	Shelf Life       2 years in original, unopened containers.         Storage Conditions       Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.
	Color Gray, red, tan.
	Mixing Ratio Component 'A' : Component 'B'=1:1 by volume.
	Viscosity (Mixed) Approximately 3,500 cps.
	Pot Life Approximately 35 to 40 minutes. (60 gram mass).
	Tack-Free Time         Approximately 4 hours.
	Open TimeLight foot traffic: 5-7 hours. Rubber-wheel traffic: 8-10 hours.
	Immersion and Chemical Exposure Minimum cure: 3 days
	Tensile Properties (ASTM D-638)         14 day       Tensile Strength       5,400 psi (37.3 MPa)         Elongation at Break       2.7 %
	Abrasion (ASTM D-1044) (Taber Abrader)7 dayWeight loss, 1,000 cycles (H-22 wheel, 1,000 gm weight)0.61 gm
	Abrasion Resistance (ASTM D-968)           14 day         Abrasion Coefficient         51 liters/mil.
	Adhesion (ASTM D-3359)1 dayAdhesion Classification4A
	Water Absorption(ASTM D-570)7 day(24 hour immersion)0.1%



0	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance grease, curing compounds, impregnations, waxes and any other contaminants. <b>Preparation Work: Concrete</b> - Should be cleaned and prepared to achieve a laitance and contaminant free open textured surface by blastcleaning or equivalent mechanical means. <b>Steel</b> - Should be cleaned and prepared thoroughly by blastcleaning.
	<b>Pre-mix each component.</b> Proportion equal parts by volume of Components 'A' and 'B' into a clean mixing container. Mix with a low-speed (400-600 rpm) drill using a Sika paddle for 3 minutes, until uniform in color.
s h D	Apply coating using high-quality roller, brush or spray. Two coats are recommended. Apply second coat a soon as the first coat is tack-free and the traffic of application will not damage the first coat. The second coar however, must be applied within 48 hours since a longer delay will require additional surface preparation. Do not spray with slip resistant granules mixed into the coating. For use as a seamless flooring system, consu Technical Service.
	<ul> <li>Minimum substrate and ambient temperature for application 50°F (10°C).</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMEx pert type concrete moisture meter is 4%.</li> <li>Do not apply over wet, glistening surface.</li> <li>Material is a vapor barrier after cure.</li> <li>Do not apply to porous surfaces exhibiting moisture-vapor transmission during the application. Consult Technical Service.</li> <li>Minimum age of concrete prior to application is 21-28 days, depending on curing and drying conditions.</li> <li>Do not apply to exterior, on-grade substrates.</li> <li>Use oven-dried aggregate only.</li> <li>Do not thin with solvents.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> <li>On 'green or 'damp' concrete, EpoCem can be used as a pore filler to reduce vapor drive and potential osmotic blistering.</li> </ul>

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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on SIKA warrains this product for one year from date of instantiation to be free from manufacturing defects and to meet the technical properties of the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINCE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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RESPONSIBLE CARE



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# Sikagard<sup>®</sup> 670W

### Water dispersed, acrylic, protective, anti-carbonation coating

Description		er dispersed colored, acrylic, vapor permeable and provid		•
Where to Use	•	blication on buildings or civil tect concrete and other mase	• •	•
Advantages	<ul> <li>Excellent UV resistance</li> <li>Excellent weathering responses of chlue</li> <li>Prevents ingress of chlue</li> <li>Cost effective protection</li> </ul>	carbon dioxide and other ag e. esistance. orides.		ì.
Coverage	Normal coating system is to is obviously dependent on in applied film thickness, los	) ft²/gal. Wet film thickness: 5 wo coats minimum at a total no substrate. In addition, allowar ss and waste. A third coat may n dense substrates or with ve	ominal dry film thicknes nce must be made for / be necessary where c	ss of 5 mils. Consumpti surface profile, variatio opacity is reduced throu
Packaging	5 gallon, re-closable plasti	ic pails.		
	Typical Data (Mater	ial and curing conditions a	. ,	
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is	PENDING UPON MIXING ME L SITE CONDITIONS AND CL ainer. Condition material to 60°-79 pr-matching available.	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo	PENDING UPON MIXING ME L SITE CONDITIONS AND CL ainer. Condition material to 60°-79 or-matching available. t taken in protecting the system ration.	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life Solids Content	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is	PENDING UPON MIXING ME L SITE CONDITIONS AND CL ainer. Condition material to 60°-79 pr-matching available.	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo	PENDING UPON MIXING ME L SITE CONDITIONS AND CL ainer. Condition material to 60°-74 or-matching available. taken in protecting the system tation. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life Solids Content Waiting and Drying Times	<ul> <li>ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo by weight: 60% Between Coats: 45°F (7°C) approx. 90 min. 68°F (20°C) approx. 30 min.</li> </ul>	PENDING UPON MIXING ME L SITE CONDITIONS AND CL ainer. Condition material to 60°-74 or-matching available. taken in protecting the sys- ration. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour approx. 40 min. ickness) fficient) = 3,140	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect stem from moisture, Final Drying approx. 24 hours approx. 4 hours
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life Solids Content Waiting and Drying Times Water Vapor Diffusion (at 5	<ul> <li>ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA</li> <li>year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard.</li> <li>463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo by weight: 60%</li> <li>Between Coats: 45°F (7°C) approx. 90 min. 68°F (20°C) approx. 30 min. 85°F (30°C) approx. 20 min.</li> <li>5 mils. = 120 microns dry film thi µ - value H<sub>2</sub>O (diffusion coef</li> </ul>	PENDING UPON MIXING ME L SITE CONDITIONS AND CU ainer. Condition material to 60°-75 or-matching available. It taken in protecting the sys- ration. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour approx. 40 min. ickness) ficient) = 3,140 less) = 1.3 ft. (0.4 m) h thickness) ficient) = 1,100,000 less) = 433 ft. (132 m.)	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect stem from moisture, Final Drying approx. 24 hours approx. 4 hours approx. 3 hours
	Typical Data (Mater RESULTS MAY DIFFER BASED TEMPERATURE, APPLICATION Shelf Life Storage Conditions Colors Pot Life Solids Content Waiting and Drying Times Water Vapor Diffusion (at 5	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo by weight: 60% Between Coats: 45°F (7°C) approx. 90 min. 68°F (20°C) approx. 90 min. 68°F (20°C) approx. 20 min. 5°F (30°C) approx. 20 min. 5°F (30°C) approx. 20 min. 5° mils. = 120 microns dry film thi µ - value H <sub>2</sub> O (diffusion coeff SdCO <sub>2</sub> (equivalent air thickn Equivalent concrete thickness	PENDING UPON MIXING ME L SITE CONDITIONS AND CU ainer. Condition material to 60°-75 or-matching available. It taken in protecting the sys- ration. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour approx. 40 min. ickness) ficient) = 3,140 less) = 1.3 ft. (0.4 m) h thickness) ficient) = 1,100,000 less) = 433 ft. (132 m.)	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect stem from moisture, Final Drying approx. 24 hours approx. 4 hours approx. 3 hours
	Typical Data (Mater         RESULTS MAY DIFFER BASED         TEMPERATURE, APPLICATION         Shelf Life         Storage Conditions         Colors         Pot Life         Solids Content         Waiting and Drying Times         Water Vapor Diffusion (at \$         Carbon Dioxide Diffusion (at \$	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo by weight: 60% Between Coats: 45°F (7°C) approx. 90 min. 68°F (20°C) approx. 90 min. 68°F (20°C) approx. 90 min. 68°F (30°C) approx. 20 min. 5 mils. = 120 microns dry film thi µ - value H <sub>2</sub> O (diffusion coeff SdH <sub>2</sub> O (equivalent air thickn Equivalent concrete thickness ty (ASTM E-96) Development (ASTM E-84-94)	PENDING UPON MIXING ME LI SITE CONDITIONS AND CU ainer. Condition material to 60°-75 or-matching available. It taken in protecting the systemation. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour approx. 40 min. itchness) ficient) = 3,140 less) = 1.3 ft. (0.4 m) n thickness) ficient) = 1,100,000 less) = 433 ft. (132 m.) ss (Sc) = approximately 13 17.9 Perms	THODS AND EQUIPMENT, JRING CONDITIONS. 5°F before using. Protect stem from moisture, Final Drying approx. 24 hours approx. 4 hours approx. 3 hours
	Typical Data (Mater         RESULTS MAY DIFFER BASED         TEMPERATURE, APPLICATION         Shelf Life         Storage Conditions         Colors         Pot Life         Solids Content         Waiting and Drying Times         Water Vapor Diffusion (at \$         Carbon Dioxide Diffusion (at \$	ial and curing conditions a UPON STATISTICAL VARIATIONS DE METHODS, TEST METHODS, ACTUA 1 year in original, unopened conta Store dry at 40°-95°F (4°-35°C). C from freezing. If frozen, discard. 463 standard colors. Custom colo Indefinite, provided proper care is freezing, contamination, or evapo by weight: 60% Between Coats: 45°F (7°C) approx. 90 min. 68°F (20°C) approx. 90 min. 68°F (20°C) approx. 90 min. 5 mils. = 120 microns dry film thi µ - value H <sub>2</sub> O (diffusion coeff SdH <sub>2</sub> O (equivalent air thickn (at 5 mils. = 120 microns dry film µ- value CO <sub>2</sub> (diffusion coeff SdCO <sub>2</sub> (equivalent air thickn Equivalent concrete thickness ty (ASTM E-96)	PENDING UPON MIXING ME L SITE CONDITIONS AND CU ainer. Condition material to 60°-74 br-matching available. t taken in protecting the sys- ration. by volume: 46% Rain Resistant After approx. 5 hours approx. 1 hour approx. 40 min. ickness) ficient) = 3,140 less) = 1.3 ft. (0.4 m) h thickness) ficient) = 1,100,000 less) = 433 ft. (132 m.) ss (Sc) = approximately 13	THODS AND EQUIPMENT, JRING CONDITIONS.         5°F before using. Protect         5°F before using. Protect         stem from moisture,         Final Drying approx. 24 hours approx. 4 hours approx. 3 hours         8 inches (33 cm.)         5 Class Rating: A



How to Use Surface preparation	All surfaces to be coated must be clean, dry, laitance free, sound and frost-free with curing compound residues and any other contaminants removed. An open textured sandpaper-like surface is ideal (CSP-3) Where necessary, surfaces should be prepared mechanically by blast cleaning or high pressure water jetting. Allow adequate time for drying. Bugholes, cracks or irregularities of substrate should be filled and leveled with SikaTop <sup>®</sup> , Sika <sup>®</sup> MonoTop <sup>®</sup> leveling mortar or Sikagard <sup>®</sup> Surface Fillers as appropriate. Priming All porous areas or concrete with excessive porosity should be primed using Sikagard <sup>®</sup> 552W Primer or SikaLatex <sup>®</sup> R to allow easy application of Sikagard <sup>®</sup> 670W.
Mixing	Stir thoroughly to ensure uniformity using a low speed (400-600 rpm) drill and Sika paddle. To minimize color variation when using multiple batches, blend two batches of Sikagard <sup>®</sup> 670W. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperature (ambient and substrate) 45°-95°F (5°-35°C). Sikagard <sup>®</sup> 670W can be applied by brush, roller, or spra over entire area moving in one direction. Allow a minimum of 20-90 minutes prior to re-coating. A lower temperatures and high humidity, waiting time will be prolonged. At higher temperatures, wor carefully to maintain a 'wet' edge. Sikagard <sup>®</sup> 670W is usually applied using a short nap lambs woo roller. Sikagard <sup>®</sup> 670W is particularly suitable for application by spray using the most standard spra painting equipment. As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship and material.
	<b>Note</b> : To achieve a dry film thickness of 4-6 mils., two uniform coats should be anticipated. On porous substrates, a third coat may be necessary and on particularly dense substrates, the first coat should be thinned 10% by volume with water. A third coat may then be needed for opacity.
Limitations	<ul> <li>Do not use over moving cracks.</li> <li>Substrate must be dry prior to the application.</li> <li>Minimum age of concrete prior to the application is 14 days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Minimum age of SikaTop® or Sika® MonoTop® thin layer renderings is 3 days prior to the application of 670W (moisture content must be below 5%).</li> <li>Sikagard® 670W should not be applied at relative humidities greater than 90%, or if rain is forecast within the specified rain resistance period.</li> <li>Allow sufficient time for the substrate to dry after rain or other inclement conditions.</li> <li>Product must be protected from freezing. If frozen, discard.</li> <li>Not designed for use as a vehicular traffic bearing surface.</li> <li>During application, regular monitoring of wet film thickness and material consumption is advised to ensure that the correct layer thickness is achieved.</li> <li>When over-coating existing coatings, compatibility and adhesion testing is recommended.</li> <li>Do not store Sikagard® 670W in direct sunlight for prolonged periods.</li> </ul>
IN: SH PA TC RE	RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA HEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- IRTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION O READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- ENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
	P CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.
actibef	further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the ual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Shee ore using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.
Dat mei for	or to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Produc a Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depar nt at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructio each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to duct use.
the Buy EXF SH/ THE SAI	A warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties o current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risk: yer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTLE PRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIK ALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FO E USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHER: LE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR B LLING 201-933-8800.
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Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





A460

## **Sikagard<sup>®</sup> 670W Clear** Water-based, 100% acrylic, protective coating

<b>-</b>	
Description	Sikagard 670W Clear is a clear, water-based acrylic protective coating. Sikagard 670W Clear pre- vents moisture ingress, is water vapor permeable, and provides an excellent carbonation barrier.
Where to Use	Protective coating for exposed aggregate surfaces, concrete, masonry and brick. Application on vertical, overhead and Horizontal (non-traffic bearing) surfaces.
Advantages	<ul> <li>Provides resistance to weathering, frost and de-icing salts.</li> <li>Improves look of structure without changing appearance.</li> <li>Excellent adhesion.</li> <li>High UV light resistance.</li> <li>Excellent resistance to carbon dioxide and other aggressive gas diffusion.</li> <li>Water vapor permeable (breathable).</li> <li>Easy application by brush, roller or spray.</li> <li>Resistant to dirt pick-up.</li> <li>Prevents ingress of chlorides.</li> <li>Cost-effective protection.</li> </ul>
Coverage	Theoretical per coat: 160 sq. ft./gal. Wet film thickness: 10 mils. Dry film thickness: 2.3 mils. All coverage is dependent on porosity of substrate. In addition, allowance must be made for surface profile. Unavoidable variation in application thickness, loss and waste. Normal coating system is one coat minimum at a total nominal dry film thickness of 2.3 mils. The to tal number of coats depends on the porosity of the substrate. On very porous substrates, two coats will typically be required.
Packaging	5 gallon, re-closable plastic pails.
	Typical Data (Material and curing conditions at 73°F (23°C) and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life 1 year in original, unopened container.
	Storage ConditionsStore dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using. Protect from freezing. If frozen, discard.
	Pot LifeIndefinite, provided proper care is taken in protecting the system from moisture, freezing, contamination, or evaporation.
	Solids Content 23% by volume
	Viscosity 117-123 ku
	VOC Content 193 g/L
	Waiting and Drying Times at 2.3 mils, DryBetween CoatsRain Resistant After/Final Drying45°F (7°C) approx. 70 min.approx. 3 hours68°F (20°C) approx. 60 min.approx. 1 hour and 15 min.85°F (30°C) approx. 15 min.approx. 1 hourWater Resistance (Cure Time = 1, 3, and 7 days) at 2.3 mils, Dry
	ASTM D-2247: very good resistance to whitening (ASTM score = 8, where 10 is perfect) ASTM D-714: No blisters (ASTM score = 10, where 10 is none)
	Moisture Vapor Permeability (ASTM D-1653) at 2.3 Mils, Dry 7.72 perms
	Water Spotting (Tested at 3 hr., 1, 2, 3, and 7 days) ASTM D-1848: Very good resistance to whitening (ASTM score = 8, where 10 is perfect)
	Water Vapor Transmission (at 2.3 mils=55.2 microns dry film thickness) $\mu$ - value H <sub>2</sub> O (diffusion coefficient) = 10,300 Sd H <sub>2</sub> O (equivalent air thickness) = 6 ft. (1.70 m.)
	<b>Carbon Dioxide Diffusion (at 2.3 mils=55.2 microns dry film thickness)</b> $\mu$ - value CO <sub>2</sub> (diffusion coefficient) = 631,000 Sd CO <sub>2</sub> (equivalent air thickness) = 226 ft. (69 m.) Sc (equivalent concrete thickness) = 7 in. (17 cm.)
	RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN ISTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DA' HEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE D ARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATI

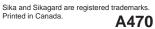
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RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

Surface Prepara	and any other for per ICRI guideling ing or high pressu	eign matter removed. Ar es). Where necessary, s ure waterjetting. Bughole	an, sound and frost-free with curing compound residu open textured sandpaper-like surface is ideal (CSP urfaces should be prepared mechanically by blast clust s, cracks or irregularities of substrate should be filled ng mortar as appropriate.	3 as ean-
Mixing	Stir thoroughly to	ensure uniformity using	a low speed (400-600 rpm) drill and Sika paddle.	
Application	(ambient and sub or spray over enti short nap roller. A humidity, waiting edge. <b>As with al</b> l	strate) 45°-95°F (5°-35°C ire area moving in one di Ilow a minimum of 60 mi time will be prolonged. <i>A</i>	Id be masked. Recommended application temperatu C). Sikagard 670W Clear can be applied by brush, re- rection. Sikagard 670W Clear is usually applied usin nutes prior to re-coating. At lower temperatures and at higher temperatures, work carefully to maintain a 'w <b>c-ups should always be completed to confirm acc</b> <b>isthetics.</b>	oller ıg a high vet'
Limitations	<ul> <li>Substrate murain or other develop if mu</li> <li>Minimum age drying condit achieving a s</li> <li>Sikagard 670 forecast with</li> <li>Do not thin.</li> <li>Do not apply temperature.</li> <li>Minimum age tion of Sikaga</li> <li>Do not use o</li> <li>Product mus</li> <li>During applic to ensure that</li> <li>When over-comparison</li> </ul>	inclement conditions, as bisture is trapped behind e of normal concrete prio ions. Substrate must be sandpaper-like surface (C DW Clear should not be a in the specified rain resis if the ambient and subst e of SikaTop or Sika Mon ard 670W Clear. ver moving cracks. t be protected from freez cation, regular monitoring at the correct layer thickn oating existing coatings,	blication. Allow sufficient time for the substrate to dry this could cause bonding problems. A white haze ma the coating. r to the application is 14 days, depending on curing a strong enough to properly prepare by mechanical me CSP 3 as per ICRI guidelines). upplied at relative humidities greater than 90%, or if ra tance period. rate temperature are within 5°F (3°C) of the dew poir oTop thin layer renderings is 3 days prior to the appli ing. If frozen, discard.	and eans ain is nt ca- dvise
Caution				
Warning	Avoid breathing v headaches.	apors. Use only with ade	equate ventilation. May cause respiratory irritation and	t
Irritant		spiratory irritant; avoid co ended. Remove contam	ntact. Use of safety goggles and chemical resistant inated clothing.	
First Aid	In case of eye contact, flush with water for 15 minutes, contact physician immediately. For skin contact, wash skin with soap water. For respiratory problems, remove person to fresh air. Wash clothing before re-use.			
Spill Clean Up	with current, appl		collect with absorbent material. Dispose of in accordate ederal regulations. Uncured material can be removed ad mechanically.	
	INSTRUCTIONS ON THE P SHEET WHICH ARE AVAIL PARTMENT AT 800.933.745 TO READ AND FOLLOW TH	RODUCT'S MOST CURREN ABLE ONLINE AT HTTP://US 2 NOTHING CONTAINED IN HE WARNINGS AND INSTRU	JSER MUST ALWAYS READ AND FOLLOW THE WARNING T PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY GA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVIC ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIG ICTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE SAFETY DATA SHEET PRIOR TO PRODUCT USE.	' da' Ce d Atic
	All information provided by Sika Co application and use of Sika product and applied under normal condition tions, actual site conditions and oth recommendations or instructions re recommendations or instructions re and purpose before proceeding wi All sales of Sika product(s) are sub	rporation ("Sika") concerning Sika p s, is given in good faith based on Sil s in accordance with Sika's instructi lated to its products, nor shall any le plated to its products. The user of ti th the full application of the produc oject to its current terms and condit	CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY roducts, including but not limited to, any recommendations and advice relati ia's current experience and knowledge of its products when properly stored, ons. In practice, the differences in materials, substrates, storage and handlin are such that Sika assumes no liability for the provision of such information gal relationship be created by or arise from the provision of such information ne Sika product(s) must test the product(s) for suitability for the intended ap (s). Sika reserves the right to change the properties of its products withou ions of sale which are available at <u>www.sikausa.com</u> or by calling 800-93	hand ng cor , advi n, advi plicat 1t noti 33-74
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ka	Regional Information and Sale Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225	es Centers. For the location of y Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792	our nearest Sika sales office, contact your regional center. Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920	A COMMAN

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Phone: 52 442 2385800 Fax: 52 442 2250537



# Sikagard<sup>®</sup> Elastic Base Coat

Elastic, crack-bridging, anti-carbonation base coat for Sikagard<sup>®</sup> 550W Elastocolor

eoretical per coat: mooth: Yield: 100 ft²/gal. xtured: Yield: 70 ft²/gal. cagard® 550W Elastocol ckness of 16 mils. All cc surface profile, unavoic gal. re closable plastic per Typical Data (Mate RESULTS MAY DIFFER BASE	weathering, fro parrier. g properties. e. sh, roller, or airly moving cracks . Wet film thickn lor coating syst overage depend dable variation i ail.	st and de-icing ess spray. 300 microns ness: 16 mils. ness: 23 mils. em is two coal dent on poros n application t	g salts. (12 mils) a Dry film th Dry film th ts, base c ity of subs	at 400 microns (16 mils) dft (smooth). hickness: 8 mils. hickness: 11 mils. coat and top coat, minimum at a total dry film strate. In addition, allowance must be made
Excellent carbonation b Dynamic crack-bridging Water vapor permeable Can be applied by brus Will bridge dynamically eoretical per coat: mooth: Yield: 100 ft²/gal. xtured: Yield: 70 ft²/gal. xtured: Yield: 70 ft²/gal. ckness of 16 mils. All co surface profile, unavoid gal. re closable plastic per Typical Data (Mate RESULTS MAY DIFFER BASE	parrier. g properties. e. sh, roller, or airle moving cracks wet film thickr lor coating syst overage depend dable variation i ail.	ess spray. 300 microns ness: 16 mils. ness: 23 mils. em is two coat dent on poros n application t	(12 mils) a Dry film th Dry film th ts, base c ity of subs	hickness: 8 mils. hickness: 11 mils. coat and top coat, minimum at a total dry film strate. In addition, allowance must be made
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kagard® 550W Elastocol ckness of 16 mils. All co surface profile, unavoio gal. re closable plastic p <b>Typical Data (Mate</b> RESULTS MAY DIFFER BASE	lor coating syst overage depend dable variation i ail. erial and curing	em is two coat dent on poros n application t	ts, base c ity of subs	oat and top coat, minimum at a total dry film strate. In addition, allowance must be made
Typical Data (Mate RESULTS MAY DIFFER BASE	erial and curing	g conditions		
RESULTS MAY DIFFER BASE		g conditions		
Shelf Life Storage Conditions Color Pot Life Curing Rate Solids Content	2 years in ori Store dry at 4 before using. Off White Indefinite, pro ture, freezing,	T METHODS, AC ginal, unopene 0°-95°F (4°-35 Protect from fi vided proper c contamination e time: 2 hours	rual site of ed contair reezing. If care is tak n, or evap	dition material to 65°-75°F (18°-24°C) f frozen, discard. ken in protecting the system from mois-
Smooth Textured	63% 64%	47% 49%		
7 days Tensile Elonga 30 days Tensile	e Strength ation at Break e Strength	165 psi (1. 370% 210 psi (1.4	,	
			)°F	1/2" Mandrel, 180° Bend - No Change
Moisture Vapor Perm	eability (ASTN	I <b>E-96</b> ) 1	0 Perms	
Flame spread and sm Flame Spread: 0		•	,	ass Rating: A
	Storage Conditions Color Pot Life Curing Rate Solids Content Smooth Textured Tensile Properties (A 7 days Tensile Elonga 30 days Tensile Elonga Low Temperature Flex Moisture Vapor Perm Flame spread and sm Flame Spread: 0 O EACH USE OF ANY S CTIONS ON THE PRODU VHICH ARE AVAILABLE	Storage Conditions       Store dry at 4 before using.         Color       Off White         Pot Life       Indefinite, proture, freezing,         Curing Rate       Initial tack-free         Solids Content       by weight         Smooth       63%         Textured       64%         Tensile Properties (ASTM D-412 model)       7 days         Tensile Properties (ASTM D-412 model)       7 days         Tensile Strength       Elongation at Break         30 days       Tensile Strength         Elongation at Break       Store dry at 4 before         Moisture Vapor Permeability (ASTM)       Flame spread and smoke developm         Flame Spread: 0       Smoke Developm         O EACH USE OF ANY SIKA PRODUCT, SMOST CUE       CUE         OTIONS ON THE PRODUCT'S MOST CUE       WHICH ARE AVAILABLE ONLINE AT HTT	Storage Conditions       Store dry at 40°-95°F (4°-35 before using. Protect from from the before using. Protect from the before using. Protect from the before using. Protect from from the before using. Protect from the before using the before using. Protect from the before using thetable. Protect from the before using the bef	Storage Conditions       Store dry at 40°-95°F (4°-35°C). Con before using. Protect from freezing. It color         Color       Off White         Pot Life       Indefinite, provided proper care is tak ture, freezing, contamination, or evap         Curing Rate       Initial tack-free time: 2 hours         Solids Content       by weight       by volume         Smooth       63%       47%         Textured       64%       49%         Tensile Properties (ASTM D-412 modified)       7 days       Tensile Strength       165 psi (1.1 MPa)         Elongation at Break       370%       30 days       Tensile Strength       210 psi (1.4 MPa)         Elongation at Break       345%       Low Temperature Flexibility (ASTM C-711)       0°F         Moisture Vapor Permeability (ASTM E-96)       10 Perms         Flame spread and smoke development (ASTM E-84-94)

TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

1	
How to Use	
Surface Preparation	All surfaces to be coated must be dry, clean, sound, and frost-free with curing compound residues and any other foreign matter removed. An open textured sandpaper-like surface is ideal (CSP-3). Where necessary, surfaces should be prepared mechanically by blast cleaning or high pressure water jetting. Allow adequate time for drying. Bug holes or irregularities of substrate should be leveled with SikaTop <sup>®</sup> , Sika <sup>®</sup> MonoTop <sup>®</sup> leveling mortar or surface fillers as appropriate.
	<b>Priming:</b> All porous areas or concrete with excessive porosity or chalky surfaces should be primed using Sikagard <sup>®</sup> 552W or SikaLatex <sup>®</sup> R to allow easy application of Sikagard <sup>®</sup> Elastic Base Coat.
Mixing	Stir all materials to ensure uniformity using a low speed (400-600 rpm) drill and Sika paddle.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperatures (ambient and substrate) 45°-100°F (7°-37°C). Apply by brush, roller, or spray over entire area moving in one direction. To obtain the proper coverage, a minimum of two coats are necessary. Allow a minimum of 2 hours prior to re-coating. Fill all visible hairline cracks and surface defects with appropriate Sika repair mortar, leveling mortar or sealer prior to applying Sikagard <sup>®</sup> Elastic Base Coat to entire surface. Consult Technical Service for spray application techniques.
	<b>Note:</b> Brushing provides more even and pore free coats with better penetration. Allow a minimum of 3 hours prior to re-coating. At lower temperatures and high humidity, the waiting time will be prolonged. As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship and material.
Limitations	<ul> <li>Not designed for use as a traffic bearing surface.</li> <li>Substrate must be dry prior to the application. Allow sufficient time for the substrate to dry after rain or other inclement conditions, as this could cause bonding problems.</li> <li>Minimum age of normal concrete prior to the application is 14 days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Minimum age of SikaTop® or Sika® MonoTop® prior to application is 3 days, depending on curing and drying conditions (moisture content must be below 5%).</li> <li>Do not thin.</li> <li>Crack bridging is dependent on dry film thickness.</li> <li>If liquid material is frozen it should not be used.</li> <li>During application, regular monitoring of wet film thickness and material consumption is advised to ensure that the correct layer thickness is achieved.</li> <li>Crack bridging abilities are reduced with textured grade.</li> <li>Crack bridging properties require that the minimum dry film thickness be maintained. In no circumstances should this be less than 200 microns (8 mils) total.</li> <li>Not for use as an aesthetic coating.</li> <li>Available in pastel base only.</li> </ul>

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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## Sikagard® FlexCoat - Cementitious Protective Coating

Two-component, polymer-modified, waterproof, cement-based coating system

-					
Description	Sikagard <sup>®</sup> FlexCoat is a polymerized cementitious prot liquid (Part A) mixed at the time of application with a c				
Where to Use	<ul> <li>Balcony deck surfacing.</li> <li>Concrete exterior restoration.</li> <li>Sidewalk resurfacing.</li> <li>Wall refinishing and installation coating.</li> <li>Stadium renovation.</li> <li>Swimming pool walkways.</li> </ul>				
Advantages	It can be applied over almost any clean, sound surface e.g. concrete, block, masonry, etc. for a number of different floor, wall and roof uses. Important characteristics of Sikagard <sup>®</sup> FlexCoat are its extraordinary adher sion coupled with its ability to withstand prolonged pedestrian and light vehicular traffic. In these respects, the material is far superior to conventional cementitious coatings. Sikagard <sup>®</sup> FlexCoat provides a waterproof coating which substantially reduces or prevents water penetration, freeze-thaw scaling and concrete carbonatior It is a "breathable" coating which releases normal entrapped vapor without loosening or blistering. Sikagard FlexCoat is available in natural cement color.				
	Sikalastic <sup>®</sup> Traffic Systems can be top coated with Sik the spec component of the Sikalastic <sup>®</sup> /Sikagard <sup>®</sup> Flex				
Packaging	55 lb. bag. and 2.5 gallon liquid (packaged in 3.5 gall	on pail) = 1	unit.		
Coverage	Sikagard <sup>®</sup> FlexCoat is applied in two coats. Each coat thickness is required. On-site results for coverage wil	t should be a I vary.	applied at 250 ft.²/unit. A total of 60 mils total		
		_			
	Typical Data (Material and curing conditions				
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATION TEMPERATURE, APPLICATION METHODS, TEST METHODS, A				
	Shelf Life         1 year in original, unopened packaging				
	<b>Storage Conditions</b> Store dry at 40°-95°F(4°-3	5°C). Condit	ion material to 65°-75°F before using.		
	Adhesion (ASTM C-882), Type I	515 psi			
	Absorption Weight gain by 4" coated concrete cube after 21 days water immersion	<2%			
	Weathering (ASTM G23) Weatherometer) Method 1 procedure, 60 cycles	No visible d	egradation		
	Hydrocarbon Substances Resistance (ASTM D-1: 21 days repeated reapplication of gasoline, motor oil SAE-10, jet fuel	308, Spot Op No softening			
	Resistance to Wind-Driven Rain Fed Spec. TT-C-558 (8 hrs.) & TT-P-0035 (24 hrs				
			dampness noted on back of test panels		
	Compressive Strength (ASTM C-109) Tensile Strength (ASTM C-190)	2,440 psi			
	Elongation (ASTM D-412)	430 psi 12%			
	Shore Hardness (ASTM D-2240)	Durometer '	<b>'Δ"</b> _ 82		
	Impact Resistance (MIL-D-3134, Para. 4.7.3.)		or detachment (2 lb. steel ball dropped		
			eight on to coated steel plate)		
	Trater vapor i crineability (E 50)				
	Flammable Properties (ASTM E-84 Steiner Tunr	nel Test)	Flame Spread - 4 Smoke Density - 0		



Surface Preparation	Prepare surfaces by removal of dirt, foreign matter plus patching in accordance with manufacturer's recommendations. An open textured surface ICRI CSP.3 is recommended. Deeper areas shall be patched with appropriate patch material like SikaQuick® or SikaRepair® products. The material is applied in multiple coats b brush, roller, trowel or spray to a typical thickness of 60 mils.
Mixing	Place the liquid component in appropriate mixing container. It is always recommended to start mixing with approximately 80% of the liquid. Add the powder while continuing to mix. Mix to a uniform consistency, maximum 3 minutes. Mechanically mix with a low-speed drill (400-600 rpm) and paddle.
Application	Pre-wet surface to SSD (Saturate Surface Dry). Insure good intimate contact with the substrate is achieved Sikagard® FlexCoat can be applied with brush, roller, trowel or spray application. Apply first coat of Sikagard® FlexCoat. Apply following coats (one or two depending on service conditional requirements) by brush, trowel roller or spray. Finish to specified texture. Color Finish (optional) – apply Sikagard® FlexCoat ATC acrylic top coat for color finish, when specified, in two coats by roller, brush or spray. <b>Caution:</b> Do not install Sikagard® FlexCoat in cold weather (i.e. below 50°F/10°C) or when rainfall can be expected prior to material setting.
Tooling & Finishing	Curing Protect newly applied Sikagard® FlexCoat from direct sunlight, wind, rain and freezing.
Limitations	<ul> <li>Apply product in temperatures &gt; 50°F (7°C) and rising.</li> <li>Minor shade variation may occur with natural cement color material.</li> <li>Not suitable for use in areas where acids or other aggressive chemicals are spilled.</li> <li>Top coats strongly recommended for color uniformity.</li> <li>Will reflect dynamic concrete cracks.</li> <li>Static and dynamic cracks can be detailed in accordance with accepted industry practices of using embedding mesh or other methods to reduce the reflecting of cracks.</li> <li>Sikagard<sup>®</sup> FlexCoat is a dense, cement-based waterproofing material that is vapor permeable. This product will not create a vapor barrier.</li> <li>Efflorescence in the existing substrate can result in the failure of the bond or discoloration of the surface if there are areas of concrete that are not protected from water ingress.</li> <li>Sikagard<sup>®</sup> FlexCoat has been tested with Sikagard<sup>®</sup> FlexcoatATC. Use of any other top coat needs to be tested for compatibility and performance.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur<sup>®</sup> 32 Hi-Mod.</li> </ul>
INST SHEI PAR <sup>-</sup> TO R	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN IRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DI TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUP IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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A490

## Sikagard® FlexCoat ATC (Acrylic Top Coat)

Single-component, water-based, acrylic top coat for Sikagard® FlexCoat

Description		a single component acrylic finish coating for two-coat application to Sikagard® Fl- . Important characteristics of Top Coat are its durability and excellent weathering	
Where to Use		be used as a top coat where uniformity is desired or colors other than Concrete FlexCoat is an acrylic coating that will require maintenance and recoat applica- s exposure to foot traffic.	
Advantages	<ul> <li>Tough, long-lasting finish.</li> <li>Weather-resistant.</li> <li>Excellent color retention.</li> <li>VOC compliant.</li> <li>No mess - self-mixing.</li> <li>Offers resistance to dirt p</li> <li>Cost effective protection.</li> <li>Vapor permeable - allows</li> </ul>		
Packaging	5 gallon pail.		
Coverage	ing system is two coats mini	ft./gal/coat. Wet film thickness: 5 mils. Dry film thickness: 2.5 mils. Normal coat- mum at a total nominal dry film thickness of 5 mils. Consumption is obviously addition, allowance must be made for surface profile, variations in applied film	
		No fading or visible deleterious effect under 10x magnification. Desert Sunshine Exposure Test, Inc., Phoenix, AZ "Procedure EMMA" (mirror-accelerated exposure).	



Chemical	Resistance
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Environment	Immersion	Splash & Spillage	Exterior Weathering
Weak Acid	NR	LR	R
Alkali	LR	R	R
Solvent	NR	NR	NR
Salts	R	R	R
Water	R	R	R
R - Recommend NR - Not recom			

LR - Limited recommendation

Surface Preparation	All surfaces to be coated must be clean, dry, laitance free, sound and frost-free with all residues and any other contaminants removed. An open textured sandpaper-like surface is ideal. Where necessary, surfaces should be prepared mechanically by blast cleaning or high pressure water blasting. Allow adequate time for drying.
Mixing	Stir thoroughly to ensure uniformity using a low speed (400-600) rpm drill and Sika Paddle. To minimize color variations when using multiple batches, blend tow batches of Sikagard <sup>®</sup> FlexCoat ATC. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
Application	Any areas of glass or other surfaces should be masked. Recommended application temperatures (ambient and substrate) 45°-95°F (5°-35°C). Sikagard® FlexCoat ATC can be applied by brush, roller, or spray over entire area moving in one direction. Allow a minimum of 20-90 minutes prior to recoating. At lower temperatures and high humidity, waiting time will be prolonged. At higher temperatures, work carefully to maintain a 'wet' edge. Sikagard® FlexCoat ATC is usually applied using a short nap lamb's wool roller. Sikagard® Flex- Coat ATC is particularly suitable for application by spray using the most standard spray painting equipment.
	As with all coatings, job site mock-ups should always be completed to confirm acceptability of workmanship and material. Apply first coat of Sikagard <sup>®</sup> FlexCoat ATC. Apply following coats (one or two depending on service conditions/requirements) by roller, brush or spray. Finish to specified texture.
	<b>Caution:</b> Do not install Sikagard <sup>®</sup> FlexCoat in cold weather (i.e. below 50°F/10°C) or when rainfall can be expected prior to material setting.
Over painting	Typically in normal 73°F and 50% relative humidity conditions, Sikagard <sup>®</sup> FlexCoat can be top coated with Sikagard <sup>®</sup> FlexCoat ATC after 24 hours.
Limitations	<ul> <li>Substrate must be dry prior to the application.</li> <li>Sikagard<sup>®</sup> FlexCoat ATC should not be applied at relative humidities greater than 90%, or if rain is forecast within the specified rain resistance period.</li> <li>Allow sufficient time for the substrate to dry after rain or other inclement conditions.</li> <li>Product must be protected from freezing. If frozen, discard.</li> <li>Not designed for use as a vehicular traffic bearing surface.</li> <li>During application, regular monitoring of wet film thickness and material consumption is advised to insure the period.</li> </ul>

How to Use

	be prepared mechanically by blast cleaning or high pressure water blasting. Allow adequate time for drying.
ng	Stir thoroughly to ensure uniformity using a low speed (400-600) rpm drill and Sika Paddle. To minimize color variations when using multiple batches, blend tow batches of Sikagard <sup>®</sup> FlexCoat ATC. Use one pail and maintain the second pail to repeat this procedure (boxing) for the entire application.
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	<ul> <li>Developed and tested as the topcoat for Sikagard<sup>®</sup> FlexCoat product. Use of this material in any other applications will require testing.</li> </ul>

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Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

C.P. 76920 Phone: 52 442 2385800

Fax: 52 442 2250537

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

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RESPONSIBLE CARE



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Product Data Sheet Edition 10.6.2014 SikaTop<sup>®</sup> 144

## SikaTop<sup>®</sup> 144 Polymer-modified portland-cement coating

Description	and masonry substrates. Easily app	2-component, cementitious coating. Designed for use on concrete, mortar, plied by brush, roller, or spray equipment. This fine-textured, abrasion- on against deicing salts and for damp-proofing/waterproofing.
Where To Use	<ul> <li>Use on grade, above, and below</li> </ul>	grade on concrete, masonry, and mortar.
		verhead surfaces, both interior and exterior.
	<ul> <li>Potable water tanks.</li> <li>Use as a coating over newly report</li> </ul>	aired concrete to provide a monolithic/uniform appearance.
	<b>o</b> , ,	duce the affect of deicing salt on concrete.
	<ul> <li>Use as a protective coating for w</li> </ul>	aterproofing, damp-proofing, and improved resistance to weathering.
	<ul> <li>Use on concrete and masonry sub traffic.</li> </ul>	strates to improve abrasion resistance to foot traffic and light pneumatic-tire
		tectural curtain wall panels to prevent water intrusion from the outside.
Advantages	<ul> <li>Bond strength ensures superior a</li> </ul>	
gee	<ul> <li>Increases resistance of substrate</li> </ul>	
	<ul> <li>Does not create a vapor barrier.</li> </ul>	shows a fair way and shall be a staff a superior for filling and a dark to use
	<ul> <li>No mix water needed, liquid co-p</li> <li>Superior abrasion resistance.</li> </ul>	olymer triggers special blend of cements, fillers, and admixtures.
	•	d unit ensures consistent composition and high quality. Non-flammable;
	low odor.	
	<ul> <li>Easily applied to clean, sound su</li> <li>Approved for use in contact with</li> </ul>	
	<ul> <li>USDA-approved for incidental for</li> </ul>	
	<ul> <li>May be overcoated with Sikagaro</li> </ul>	1 <sup>®</sup> protective coatings.
Coverage	First Coat 100-150 ft./gal.	
	Second Coat 150-200 ft./gal.	the fact time and a second to
	Coverage is dependent upon substr	
Packaging	5-gal. unit consisting of 3.5-gal. plas	tic pail of Component 'A' and a 45-lb. multi-wall bag of Component 'B'.
	RESULTS MAY DIFFER BASED U	I and curing conditions @ 73°F and 50% R.H.) PON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, IETHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life	1 year in original, unopened packaging.
	Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 60°-75°F before using. Component 'A' must be protected from freezing. If frozen, discard.
	Color	White and cement-gray.
	Mixing Ratio	Factory proportioned unit. Mix entire contents.
	Pot Life	Approximately 4 hours.
	Tack-Free Time	Approximately 30 minutes.
	Recoat Time	Allow 2 hours minimum between coats.
	Application Thickness	
	Abrasion Resistance (AS 7 day 55 liters/m	
	Bond Strength (Elcomet 7 day concrete s	er) substrate failure
	Water-Vapor Transmissio	on: (ASTM E-96)
	7 day 1 coat	27 grains/hr./ft. <sup>2</sup>
	2 coats	24 grains/hr./ft. <sup>2</sup>



How to Use	
Substrate	Concrete, mortar, and masonry.
Surface Preparation	All surfaces to be coated must be clean, sound, and saturated surface dry with no standing water at the time of application.
	Remove all dust, laitance, grease, oils, curing compounds, waxes, impregnations, and other contaminants. Should substrate require repair, patch with appropriate SikaTop® PLUS repair system. Preparation work must be done by mechanical equipment, i.e., blast cleaning, water blasting, or a combination of the two.
Mixing	All mixing must be done mechanically using a low-speed drill (400-600 rpm) and Sika paddle. Place approxi- mately 1/2 Component 'A' into a clean mixing container. While mixing, slowly add all of Component 'B' and continue to mix until you achieve a uniform paste with no lumps. Be sure to scrape down sides of the mixing container at this time. Add remainder of Component 'A' and continue to mix until uniformly blended.
Application	SikaTop® 144 should only be applied over properly prepared surfaces with high-quality brushes, rollers, or "hopper-type" spray equipment. Surface should be saturated surface dry prior to application. Two coats are recommended for maximum performance. Recommended thickness per coat is 8 to 16 mils. Apply thoroughly mixed coating generously with loaded brush or roller. Always finish off with light strokes blending back into coated area for uniform appearance. For application in direct sun or on a hot substrate, pre-wet surface and allow surface water to dissipate before coating.
Tooling & Finishing	Curing: Protect newly applied SikaTop® 144 from direct sunlight, wind, rain and freezing.
	<ul> <li>Maximum thickness of applications is 16 mils/coat, thicker application can result in cracking.</li> <li>Do not apply when rain is expected.</li> <li>Minimum ambient and substrate temperature is 45°F and rising at the time of application.</li> <li>For spray application, coating must be screened prior to loading of the spray hopper.</li> <li>Coating may chalk and show water marks due to weathering.</li> <li>For applications where coating will be subjected to immersion, a 3-day cure is recommended.</li> <li>Coating will slightly yellow with age and exposure to UV light.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and</li> </ul>

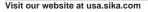
RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on SIKA warrains this product for one year from date of instantiation to be free from manufacturing defects and to meet the technical properties of the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINCE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800. 1-800-933-SIKA NATIONWIDE



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# **B** - Joint Sealing and Adhesive Systems

#### Building Sealants Polyurethanes

Folyulethalles	
Sikaflex-15 LM	B10
Sikaflex-1a	B20
Sikaflex-1a+	B30
Sikaflex-1c SL	B40
Sikaflex-2c NS	B50
Sikaflex-2c NS EZ Mix	B60
Sikaflex-2c NS TG	B70
Sikaflex-2c SL	B80
Sikaflex Textured Sealant	B90
Silicones	
Sikasil WS-290	B100
Sikasil WS-290 FPS	B110
Sikasil WS-295	B120
Sikasil WS-295 FPS	B130
Sika Silbridge-300	B140
Sikasil GP	B150
Sikasil N Plus	B160
Hybrid	
SikaHyflex 150 LM	B170

### **Control Joint Systems**

Sikaflex-1c SL	B40
Sika Loadflex 524 EZ	B180
Sikadur 51 NS	B190
Sikadur 51 SL	B200

### Runway / Roadway / DOT Sealants

Sikaflex-1c SL	B40
Sikaflex-2c NS	B50
Sikaflex-2c NS EZ Mix	B60
Sikaflex-2c NS TG	B70
Sikaflex-2c SL	B80
Sikasil-728 NS	B210
Sikasil-728 RCS	B220
Sikasil-728 SL	B230

### High Performance Joint System

Sikadur 31 Hi-Mod Gel (1:1 Mix Ratio) B240 Sikadur Combiflex SG System B250

### Pick-Proof and Tamper-Resistant Sealants

Sikadur 23 Lo-Mod GelB260Sikadur 31 Hi-Mod Gel (1:1 Mix Ratio)B240Sikadur 51 NSB190Sikadur 51 SLB200

### Multi-Purpose Adhesive Sealants

Sikaflex-11 FCB270SikaBond Construction AdhesiveB280

### **Sealant Primers**

Sikaflex Primer 260, 429, and 449 B290 Sikasil Primer-2100 B300

### Foam Sealants

Sika Boom	B310
	010

### Chemical Resistant Sealants

Sika Duoflex NS	B320
Sika Duoflex SL	B330
Sika Duoflex Primer 5050	B340

### Waterstop Systems

SikaSwell S-2	B350
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**Product Data Sheet** Edition 5.13.2016 Sikaflex-15 LM

# Sikaflex<sup>®</sup>-15 LM

SEALANT• WATERPROOFING & Restoration Institute ssued to: Sika Corporation Product: Sikaflex® 15LM C719: Pass 🖌 Ext:+100% Comp:-50% Substrate: Mortar, Aluminum, Glass [motar substrate primed with Sika Primer 429] Validation Date: 2/27/14 - 2/26/19

High-performance, low-modulus elastomeric sealant SEALANT VALIDATION

No. 214-SIK817 Copyright © 2014

	meric sealant. Meets	Federal Specifica e T, NT, G, A, O, N	tion TT-S-0023 I; Federal Spe	0C, Type II, Class A; cification for silicones	thane-based, non-sag elasto ASTM C-920, Type S, Grade s - TT-S-001543 A, Type non-
Where to use	reglets, flashing,	etween similar as ns include joints in common roofing d	well as dissimil concrete pane etail application	l and wall systems, a ns, etc.	round window and door fram high movement capability is
	<ul> <li>An effective seala</li> </ul>	nt for use in Exteri	or Insulation Fi	nish Systems (EIFS)	).
Advantages	<ul> <li>Low modulus of e</li> <li>Easy and ready to</li> <li>Eliminates time, e</li> <li>Cures to a durable</li> <li>Exceptional cut ar</li> <li>Stress relaxation p</li> </ul>	o use. ffort, waste, and e e, flexible consiste nd tear resistance.		I-up.	
	<ul> <li>Excellent adhesio</li> <li>Bonds to most cor</li> <li>Paintable with wat</li> </ul>	n. Instruction material			
	<ul> <li>Excellent resistant</li> <li>Jet fuel resistant.</li> <li>Proven in tough cl</li> </ul>	ce to aging, weath	ering.		
	<ul><li>Non-leaching.</li><li>Capable of +100%</li></ul>	% / -50% joint move	ement.	<b>e</b>	
homical Posistance	Two-hour UL fire r Good resistance to w				for fully immersed conditions
				callnes. Not normally	for fully infinersed conditions
Packaging	Consult Technical Se	rvice for specific d	ata.		al (197 L) in a 55 gal drum
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER	rvice for specific d 20 fl. oz. (591 mL laterial and curing BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pao 5 gal. pails	ata. ), 4.5 gal (17 L g conditions ( ICAL VARIATIONS ST METHODS, AC dges	in a 5 gal pail, 52 ga 73°F (23°C) and 5 DEPENDING UPON MIXI FUAL SITE CONDITIONS A 12 months 12 months 6 months	al (197 L) in a 55 gal drum
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC	rvice for specific d 20 fl. oz. (591 mL laterial and curing BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pad 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off-	ata. ), 4.5 gal (17 L) g conditions ( ICAL VARIATIONS ST METHODS, AC dges : sausages F. Condition mater White, Aluminum Gi White, Beige, Almo	in a 5 gal pail, 52 ga <b>73°F (23°C) and 5</b> DEPENDING UPON MIXIP TUAL SITE CONDITIONS A 12 months 12 months 6 months 6 months ial to 65°-75°F before usir ay, Limestone, Black, Dark	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions	Arvice for specific d 20 fl. oz. (591 mL Caterial and curing BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pac 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off- Tan, Hartford Gr 40° to 1	ata. ), 4.5 gal (17 L) g conditions ( ICAL VARIATIONS ST METHODS, AC dges : sausages F. Condition mater White, Aluminum Gr White, Beige, Almo een and Stone. Spe	<ul> <li>in a 5 gal pail, 52 ga</li> <li>73°F (23°C) and 5</li> <li>DEPENDING UPON MIXII TUAL SITE CONDITIONS A</li> <li>12 months 12 months 6 months</li> <li>6 months</li> <li>14 to 65°-75°F before usir ay, Limestone, Black, Dark nd, Coping Stone, Aluminur cial colors on request (min.</li> <li>d be installed when joint is</li> </ul>	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).
	Consult Technical Se 10.1 fl. oz. (300 mL), <b>Typical Data (</b> <i>M</i> RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions Colors	rvice for specific d 20 fl. oz. (591 mL BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pac 55 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off Tan, Hartford Gr 40° to 1 of its ar -40° to 170°F (-40° to 7 Tack-free time Tack-free to touch	ata. ), 4.5 gal (17 L) g conditions ( ICAL VARIATIONS ST METHODS, AC' dges : sausages F. Condition mater White, Aluminum G White, Alume, Alum een and Stone. Spe 00°F. Sealant shou ticipated movemen 5°C) 2 to 6 hour 3 hours	a in a 5 gal pail, 52 ga <b>2.73°F (23°C) and 5</b> <b>DEPENDING UPON MIXIP</b> <b>TUAL SITE CONDITIONS A</b> 12 months 6 months 6 months <b>ial to 65°-75°F before usir</b> ay, Limestone, Black, Dark d, Coping Stone, Aluminum cial colors on request (min. d be installed when joint is the s (TT-S-00230C)	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions Colors Application Temperature Service Range	rvice for specific d 20 fl. oz. (591 mL BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-par 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off- Tan, Hartford Gr 40° to 170°F (-40° to 7 Tack-free time Tack-free to touch Final cure	ata. ), 4.5 gal (17 L) (ICAL VARIATIONS ST METHODS, AC' dges : sausages F. Condition mater White, Beige, Almo een and Stone. Spr 00°F. Sealant shou ticipated movemen 5°C) 2 to 6 hour 3 hours 7 to 10 day	a in a 5 gal pail, 52 ga <b>2.73°F (23°C) and 5</b> <b>DEPENDING UPON MIXIP</b> <b>TUAL SITE CONDITIONS A</b> 12 months 6 months 6 months <b>ial to 65°-75°F before usir</b> ay, Limestone, Black, Dark d, Coping Stone, Aluminum cial colors on request (min. d be installed when joint is the s (TT-S-00230C)	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions Colors Application Temperature Service Range Curing Rate Recovery >809 Shore A Hardness (ASTM Tensile Properties (ASTM 21 day Tens Elon, Stres	rvice for specific d 20 fl. oz. (591 mL atterial and curing BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pad 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off- Tan, Hartford Gr 40° to 1 of its ar -40° to 170°F (-40° to 7 Tack-free time Tack-free to touch Final cure 6 M D-2240) M D-412) lie Stress gation at Break is at 100%	ata. ), 4.5 gal (17 L) g conditions ( ICAL VARIATIONS ST METHODS, AC' dges : sausages F. Condition mater White, Beige, Almo een and Stone. Spr 00°F. Sealant shou ticipated movemen 5°C) 2 to 6 hour 3 hours 7 to 10 day 21 day 125 p 700%	in a 5 gal pail, 52 ga <b>2.73°F (23°C) and 5</b> DEPENDING UPON MIXIP TUAL SITE CONDITIONS A 12 months 6 months 6 months ial to 65°-75°F before usir ay, Limestone, Black, Dark d, Coping Stone, Aluminur ticial colors on request (min. d be installed when joint is the the stalled when joint is the comparison of the stall of the stall s (TT-S-00230C) s 25 ± 5 si (.86 MPa)	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions Colors Application Temperature Service Range Curing Rate Recovery >809 Shore A Hardness (ASTM Tensile Properties (ASTM 21 day Tens Elom Strest Adhesion in Peel (TT-S-O Substrate Aluminum Glass	rvice for specific d 20 fl. oz. (591 mL <b>Raterial and curin</b> BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pad 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Offi- Tan, Hartford Gr e 40° to 1 of its ar -40° to 170°F (-40° to 7 Tack-free to touch Final cure 6 M D-2240) M D-412) lie Stress gation at Break is at 100% 10230C) Peel Strength 25 lb.	ata. ata.	in a 5 gal pail, 52 gal pail	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).
	Consult Technical Se 10.1 fl. oz. (300 mL), Typical Data (M RESULTS MAY DIFFER TEMPERATURE, APPLIC Shelf Life Storage Conditions Colors Application Temperature Service Range Curing Rate Recovery >80% Shore A Hardness (ASTM Tensile Properties (ASTM Tensile Properties (ASTM 21 day Tens Elon Stress Adhesion in Peel (TT-S-C Substrate Aluminum	rvice for specific d 20 fl. oz. (591 mL 20 fl. oz. (591 mL BASED UPON STATIST CATION METHODS, TE 10.1 fl. oz. cartri 20 fl. oz. uni-pac 5 gal. pails 55 gal. drums Store at 40°-95° White, Colonial Capitol Tan, Off- Tan, Hartford Gr 40° to 170°F (-40° to 7 Tack-free time Tack-free touch Final cure 6 M D-2240) M D-412) ile Stress gation at Break ss at 100% 10230C) Peel Strength 25 lb.	ata. ), 4.5 gal (17 L) g conditions ( ICAL VARIATIONS ST METHODS, AC' dges : sausages F. Condition mater White, Aluminum Gi White, Beige, Almo een and Stone. Spa 0°F. Sealant shou ticipated movemen 5°C) 2 to 6 hour 3 hours 7 to 10 day 21 day 125 p 700% 50 ps Adhesion Loss 0%	in a 5 gal pail, 52 gal pail	al (197 L) in a 55 gal drum 10% R.H.) NG METHODS AND EQUIPMENT, AND CURING CONDITIONS. 19. Bronze, n Stone, Medium Bronze, Redwood volume).



	10.1	1 oz Cartri	dge: Yield	l in Linear	feet		20 0	oz Sausag	e: Yield ir	Linear fe	et	1g	allon: Yiel	d in Linea	r feet	
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		1/4"	24.3			ļĺ		1/4"	48.1				1/4"	307.9		
		3/8"	16.2	10.8				3/8"	32.1	21.4			3/8"	205.3	136.8	
		1/2"	12.1	8.1	6.1	]	_	1/2"	24.1	16.0	12.0		1/2"	153.9	102.6	77.0
	Width	3/4"	8.1	5.4	4.0	]	Width	3/4"	16.0	10.7	8.0	Width	3/4"	102.6	68.4	51.3
	5	1"			3.0	1	>	1"	ĺ		6.0	>	1"	1		38.5
		1.25"		1	2.4	1		1.25"			4.8		1.25"	1		30.8
		1.5"			2.0	1		1.5"			4.0		1.5"			25.7
low to Use		1				] [			ļ				1.5			23.7
Surface Preparation	con	npound	l residu	les and	d any c	other for	eigi	n matte	ers mu	st be th	st-free, a loroughly o preven	remov	/ed. A r	ougher	ned sur	
Priming	to e con <b>Not</b> Wh Sika	excessi nplete i te: Mos en EIF	vely po nforma st Exter S mani 29 prim	prous s ation as rior Ins ufactur ner is re	ubstrat s to prin ulation er spe	te. Cons mer req Finish cifies a	sult luire Sys prir	Sikafle ements stems ( ner or i	ex Prim EIFS) if on-si	ier Tec manufa te bond	ire primin hnical Da acturers r d testing i ng is reco	ata She recomn indicate	et or Te nend th es a pri	echnica e use c mer is	I Servi of a prii necess	ce for mer. sary,
Application	mat	ely 70°l	F is rec	ommen	ided. Ö	nly apply	ý se	alant to	clean,	sound,	ither appli dry, and fi	rost-free	substra	ates.	0	
	tion stea	. Place	nozzle	of gun i	nto bot	tom of th	ne jo	oint filling	g entire	joint. K	d-point of i eep nozzl t. Avoid ov	e in thè	sealant	, and co	ontinue	on with
fooling and Finishing	inch	n minim	um and	1/2 inc	h maxi	mum ťhio	ckne	ess for s	sealant.	Prope	ntrapment r design is	s 2:1 wid	Ith to de	epth ratio	D.	
Removal	spill	ed or ex	xcess p	roduct	and pla	ent (chen ced in si mental r	uital	ble seal	ant glov ed cont	es/ gog ainer. [	gles/cloth Dispose of	ing). W excess	thout di produc	rect con t and co	itact, rei ontainei	move r in ac-
Over Painting		ow 1 we I prior t			andard	l conditi	ons	when	using	Sikafle	x-15 LM	in total	water i	mmers	ion situ	uations
		Do not bubblin Use of When Since White Light of The ul With jo	t apply ng with pened applyir system color te colors o timate pint sur	when in the cartride ng seal n is mo ends to can yel perforr faces p	moistu sealan ges an lant, av isture- o yellow low if e mance properl	re-vapo t. d uni-pa void air- cured, p v slightl exposed of Sika	or-tra entro perm y w I to flex ired	ansmis ausage rapmer nit suffi hen ex direct ( -15 LN and se	es the nt. icient e posed gas fire I deper ealed, i	same of exposu to ultra ed heat nds on movem	re to air. aviolet ray ing elem good joir nent of +1	ys. ents.	e substr	proper	applica	ation.
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Product Data Sheet Edition 5.13.2016 Sikaflex-1a

# **Sikaflex®-1a** One part polyurethane, elastomeric sealant/adhesive

SEALANT- WATERPROOFING & RESTORATION INSTITUTE Issued to: Sika Corporation Produet: Sikafter=1A C719: Pass \_ Ext:+35% Comp:-35% Substrate: Mortar, Aluminum, Glass [motar substate primed with Sika Primer 429] C661: Rating 40 Validation Date: 8/3/12 - 8/2/17 No. 0812-S11211 Copyright © 2012 SEALANT VALIDATION WWW.SWrionline.org

Description	
Description	Sikaflex-1a is a premium-grade, high-performance, moisture-cured, 1-component, polyurethane-based, non-sa elastomeric sealant. Meets Federal specification TT-S-00230C, Type II, Class A. Meets ASTM C-920, Type S, Grade NS, Class 35, use T, NT, O, M, G, I; Canadian standard CAN/CGSB 19.13-M87.
Where to Use	<ul> <li>Designed for all types of joints where maximum depth of sealant will not exceed 1/2 in.</li> <li>Excellent for small joints and fillets, windows, door frames, reglets, flashing, common roofing detail applications, and many construction adhesive applications.</li> <li>Suitable for vertical and horizontal joints; readily placeable at 40°F.</li> <li>Has many applications as an elastic adhesive between materials with dissimilar coefficients of expansion.</li> <li>Submerged conditions, such as canal and reservoir joints.</li> </ul>
Advantages	<ul> <li>Eliminates time, effort, and equipment for mixing, filling cartridges, pre-heating or thawing, and cleaning of equipment.</li> <li>Fast tack-free and final cure times.</li> <li>High elasticity - cures to a tough, durable, flexible consistency with exceptional cut and tear-resistance.</li> <li>Stress relaxation.</li> <li>Excellent adhesion - bonds to most construction materials without a primer.</li> <li>Excellent resistance to aging, weathering.</li> <li>Proven in tough climates around the world.</li> <li>Odorless, non-staining.</li> <li>et fuel resistant.</li> <li>Certified to the NSF/ANSI Standard 61 for potable water.</li> <li>Urethane-based; suggested by EPA for radon reduction.</li> <li>Paintable with water-, oil- and rubber-based paints.</li> <li>Capable of ±35% joint movement.</li> </ul>
Chamical Posistance	Good resistance to water, diluted acids, and diluted alkalines. Consult Technical Service for specific data.
Packaging	10.1 fl. oz. (300 mL), 20 fl. oz. (591 mL), 4.5 gal (17 L) in a 5 gal pail, 52 gal (197 L) in a 55 gal drum         Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life         10.1 fl. oz. cartridges       12 months         20 fl. oz. uni-pac sausages       12 months         C marking and sausages
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Shelf Life         10.1 fl. oz. cartridges       12 months



Coverage	10.1	oz Cartri	dge: Yield	in Linear	feet		20	oz Sausag	e: Yield in	Linear fe	et		1 ga	llon: Yield	d in Linea	r feet	
		Depth	1/4"	3/8"	1/2"			Depth	1/4"	3/8"	1/2"			)epth	1/4"	3/8"	1/2"
		1/4"	24.3					1/4"	48.1	Ì	Ì	1		1/4"	307.9	<u> </u>	
		3/8"	16.2	10.8		1		3/8"	32.1	21.4		1		3/8"	205.3	136.8	
		1/2"	12.1	8.1	6.1			1/2"	24.1	16.0	12.0	1		1/2"	153.9	102.6	77.0
	Width	3/4"	8.1	5.4	4.0	ĺ	Width	3/4"	16.0	10.7	8.0	1	Width	3/4"	102.6	68.4	51.3
	5	1"			3.0		5	1"			6.0	1	\$	1"		i —	38.5
		1.25"			2.4	1		1.25"			4.8	1		1.25"			30.8
		1.5"			2.0	ĺ		1.5"			4.0	1		1.5"			25.7
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Priming	Prin seal	ning is lant wil	not us I be su	ually n bjecteo	ecess d to wa	ary. N ter im	lost s imers	substration aft	tes onl er cure	y requ	ire prir	ning if	tes	ting ind	dicates	a nee	d or wh
			kaflex I								ervice f	for add	ditio	nal info	ormatio	n on p	riming.
Application	Rec	omme	nded a	pplicat	ion ter	npera	tures	: 40°-1	00°F.								
	Sika tion. on v	aflex-1a Place vith a s	a shoul nozzle	d be g e of gu low of	unned n into sealar	into jo pottor	oint w n of t	/hen jo he join	int slot t and fi	is at n Il entire	nid-poir e joint	nt of its Keep	s de the	signed nozzle	expar	nsion a sealai	erformar nd cont nt, conti of sealar
Tooling and Finishing	Tool for 1 For	seala 1/4 incl use in	nt to er n minin	nsure f num ar ntal joir	full con nd 1/2 nts in tr	nch r	naxin	num thi	ickness	s for se	alant.	Prope	r de	sign is	2:1 w	dth to	hould a depth ra closed
	spill	ed or e		produc	ct and p	laced	l in si	uitable	sealed								act, rem containe
		w 1-we ainting		e at sta	andard	condi	tions	when	using S	Sikaflex	-1a in	total w	ate	rimme	rsion s	ituatio	ns and p
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#### **Product Data Sheet**

Edition 5.11.2016 Sikaflex<sup>®</sup>-1a+

Instruct

# Sikaflex<sup>®</sup>-1a+

		moisture-cured, 1-component, polyurethane-based, non-sag and damp concrete applications. Meets Federal Specification S, Grade NS, Class 35, use T, NT, O, M, G, I.
Where to Use	<ul> <li>Designed for all types of joints where maximum dep</li> </ul>	pth of sealant will not exceed 1/2 in.
	<ul> <li>Excellent for small joints and fillets, windows, door applictions, and many construction adhesive applica</li> </ul>	
	<ul> <li>Suitable for vertical and horizontal joints; readily pla</li> </ul>	aceable at 40°F
	<ul> <li>Has many applications as an elastic adhesive b</li> <li>Submerged conditions, such as canal and reservoir j</li> </ul>	etween materials with dissimilar coefficients of expansion oints.
Advantages	<ul> <li>Eliminates time, effort, and equipment for mixing, of equipment.</li> </ul>	filling cartridges, pre-heating or thawing, and cleaning
	<ul> <li>Fast tack-free and final cure times.</li> </ul>	
	<ul> <li>High elasticity - cures to a tough, durable, flexible control</li> </ul>	onsistency with exceptional cut and tear -resistance.
	<ul> <li>Stress relaxation.</li> </ul>	
	<ul> <li>Excellent adhesion - bonds to most construction ma</li> </ul>	aterials without a primer.
	<ul> <li>Excellent resistance to aging, weathering.</li> </ul>	
	<ul> <li>Proven in tough climates around the world.</li> </ul>	
	<ul> <li>Can be applied to green concrete 24 hours after pour</li> </ul>	
	<ul> <li>Can be applied to damp concrete 1 hour after getting</li> <li>Odaylage non staining</li> </ul>	g wet
	<ul><li>Odorless, non-staining.</li><li>let fuel resistant.</li></ul>	
	<ul> <li>Certified to the NSF/ANSI Standard 61 for potable w</li> </ul>	ister
	<ul> <li>Urethane-based; suggested by EPA for radon reduct</li> </ul>	
	<ul> <li>Paintable with water-, oil- and rubber-based paints.</li> </ul>	
	<ul> <li>Capable of ±35% joint movement.</li> </ul>	
Chemical Resistance	Good resistance to water, diluted acids, and diluted alk	alines Consult Technical Service for specific data
Packaging	10.1 fl. oz. (300 mL) Cartridge	
	20 fl. oz. uni-pac Sausages	
	Typical Data (Material and curing conditions @ 75 RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEP TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL Shelf Life:	PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 12 months in original, unopened packaging.
	Typical Data (Material and curing conditions @ 75 RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL Shelf Life: Storage:	PENDING UPON MIXING METHODS AND EQUIPMENT, . SITE CONDITIONS AND CURING CONDITIONS. 12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:	PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.
	Typical Data (Material and curing conditions @ 75 RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEP TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL Shelf Life: Storage: Product Conditioning: Colors: Application Temperature:	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:	PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. White & Limestone 40° to 100°F. Sealant should be installed when joint is
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:	PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. White & Limestone 40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F Tack-free time 3 to 6 hours Tack-free to touch 3 hours 4 to 7 days
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEP         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, LSITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):         Shore A Hardness (ASTM C-661):	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using.</li> <li>White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> <li>-40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEP         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5 +/- 35%</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):         Shore A Hardness (ASTM C-661):         Movement Capability (ASTM C-719):	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using.</li> <li>White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> <li>-40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):         Shore A Hardness (ASTM C-661):         Movement Capability (ASTM C-719):         Tensile Properties (ASTM D-412):	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5 +/- 35%</li> </ul>
	Typical Data (Material and curing conditions @ 75         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF         TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL         Shelf Life:         Storage:         Product Conditioning:         Colors:         Application Temperature:         Service Range:         Curing Rate:         Final cure:         Tear Strength (ASTM D-624):         Shore A Hardness (ASTM C-661):         Movement Capability (ASTM C-719):         Tensile Properties (ASTM D-412):         21 day Tensile Stress	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, STITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> <li>-40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5</li> <li>+/- 35%</li> <li>175 psi (1.21 MPa)</li> </ul>
	Typical Data (Material and curing conditions @ 75 RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEF TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL Shelf Life: Storage: Product Conditioning: Colors: Application Temperature: Service Range: Curing Rate: Final cure: Tear Strength (ASTM D-624): Shore A Hardness (ASTM D-624): Shore A Hardness (ASTM C-661): Movement Capability (ASTM C-719): Tensile Properties (ASTM D-412): 21 day Tensile Stress Elongation @ Break	<ul> <li>PENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months in original, unopened packaging. Store at 40°-95°F (4°-35°C).</li> <li>Condition material to 65°-75°F before using. White &amp; Limestone</li> <li>40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> <li>-40° to 170°F</li> <li>Tack-free time 3 to 6 hours Tack-free to touch 3 hours</li> <li>4 to 7 days</li> <li>55 lb./in.</li> <li>21 day 45±5</li> <li>+/- 35%</li> <li>175 psi (1.21 MPa)</li> <li>550%</li> </ul>

10.1	oz Cartri	dge: Yield	in Linear	feet	20	oz Sausa	ge: Yield ir	n Linear fe	et
[	Depth	1/4"	3/8"	1/2"		Depth	1/4"	3/8"	1/2"
	1/4"	24.3				1/4"	48.1		
	3/8"	16.2	10.8			3/8"	32.1	21.4	
_	1/2"	12.1	8.1	6.1		1/2"	24.1	16.0	12.0
Width	3/4"	8.1	5.4	4.0	Width	3/4"	16.0	10.7	8.0
	1"			3.0		1"			6.0
	1.25"			2.4		1.25"			4.8
	1.5"			2.0		1.5"			4.0

#### How to Use Surface Preparation

n Clean all surfaces. Joint walls must be sound, clean, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter must be thoroughly removed. A roughened surface will also enhance bond. Install bond breaker tape or backer rod to prevent bond at base of joint. Priming is not usually necessary. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure.

For green concrete applications control joints must be cut 8 hours prior to sealant installation and in expansion joint forms must be removed 4 hours prior to sealant installation. For wet concrete applications all excess or standing water must be displaced and concrete must then dry for a minimum of 60 min prior to sealant installation. Consult Sikaflex Primer Technical Data Sheet or Technical Service for additional information on priming.

ApplicationRecommended application temperatures: 40°-100°F. For cold weather application, condition units at approximately 70°F;<br/>remove prior to using. For best performance, Sikaflex-1a+ should be gunned into joint when joint slot is at mid-point of<br/>its designed expansion and contraction. Place nozzle of gun into bottom of the joint and fill entire joint. Keep the nozzle<br/>in the sealant, continue on with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping<br/>of sealant to eliminate entrapment of air.Sikaflex-1a+ can be applied on green concrete after the concrete has cured for a minimum of 24 hours at 75°F.Control joints<br/>must be cut and open for min of 8 hours prior to application. Expansion joints must have forms removed a minimum<br/>of 4 hours prior to application. For damp concrete applications Sikaflex-1a+ can be applied 60 minutes after any and all<br/>water has been displaced.

 Tooling and Finishing
 Tool sealant to ensure full contact with joint walls and remove air entrapment. Joint dimension should allow for 1/4 inch minimum and 1/2 inch maximum thickness for sealant. Proper design is 2:1 width to depth ratio, For use in horizontal joints in traffic areas, the absolute minimum depth of the sealant is 1/2 in. and closed cell backer rod is recommended.

 Removal
 Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and placed in suitable sealed container. Dispose of excess product and container in accordance with applicable equipments.

 applicable environmental regulations.

 Over Painting
 Allow 1-week cure at standard conditions when using Sikaflex-1a+ in total water immersion situations and prior to painting.

 Limitations
 Allow 1 week cure at standard conditions when using Sikaflex-1a+ in total water immersion situations.

When overcoating with water, oil and rubber based paints, compatibility and adhesion testing is essential.

- Sealant should be allowed to cure for 7 days prior to overcoating
- Avoid exposure to high levels of chlorine. (Maximum continuous level is 5 ppm of chlorine.)
- Maximum depth of sealant must not exceed 1/2 in.; minimum depth is 1/4 in.
  - Maximum expansion and contraction should not exceed 35% of average joint width.
- Do not cure in the presence of curing silicone sealants.
- Avoid contact with alcohol and other solvent cleaners during cure.
- Do not apply when moisture-vapor-transmission condition exists from the substrate as this can cause bubbling within the sealant.
- Use opened cartridges and uni-pac sausages the same day.
- When applying sealant, avoid air-entrapment.
- Since system is moisture-cured, permit sufficient exposure to air.
- White color tends to yellow slightly when exposed to ultraviolet rays.
- Light colors can yellow if exposed to direct gas fired heating element.
- The ultimate performance of Sikaflex-1a+ depends on good joint design and proper application with joint surfaces properly prepared.
- The depth of sealant in horizontal joints subject to traffic is 1/2 in.
- Do not tool with detergent or soap solutions.
- Do not use in contact with bituminous/asphaltic materials.
- In green concrete applications sealing joints in poor or low strength concrete 24 hours after pour may impact ability of sealant to gain proper adhesion.
- In damp concrete applications all standing water and excess water must be eliminated prior to the 60 minute waiting time.



PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

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regional center.

RESPONSIBLE CARE®



B30

## **Sikaflex<sup>®</sup>-1c SL** High performance, self-leveling, 1-part polyurethane sealant

		eveling, premium-grade polyurethane sealant with an accelerated cu 0230C, Type I, Class A. Meets ASTM C-920, Type S, Grade P, Class 25, us
ere to Use	Sikaflex-1c SL is used to seal horizontal expa Sidewalks Balconies Pavements Terraces Warehouses Factories Civil Structures Plazas Pitch Pans Canals and Water Treatment	nsion joints in concrete and cementitious slabs such as:
antages	<ul> <li>1-component, no mixing</li> <li>Self-leveling, pourable</li> <li>Accelerated curing</li> <li>Can be applied to green concrete 24 hour</li> <li>Can be applied to damp concrete 1 hour a</li> <li>Extremely elastic</li> <li>High durability</li> <li>Resists aging, weathering</li> <li>Excellent adhesion</li> <li>Convenient, easy-to-use packaging</li> <li>Jet fuel resistant</li> <li>Water Immersion Applications</li> </ul>	
caging	10.1 fl. oz. moisture-proof composite cartridg 29 oz. moisture-proof composite cartridges, 4.5 gallon pails. 50 gallon drums.	
		conditions 73°F (23°C) and 50% R.H.) L VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	REŠŪLTS MAY DIFFER BASED UPON STATISTIČA TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Conditions: Color: VOC Content:	L VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 10.1 oz. cartridge 1 year in original unopened packaging. 29 oz. cartridge 1 year in original unopened packaging. 4.5 gallon pail 6 months. 50 gallon drum 6 months. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. Limestone 40 g/l
	REŠŪLTS MAY DIFFER BASED UPON STATISTIČA TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Conditions: Color: VOC Content: Application Temperature: Service Range: Curing Rate Tack-free Time: Recovery: Shore 'A' Hardness (ASTM D-2240):	L VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 10.1 oz. cartridge 1 year in original unopened packaging. 29 oz. cartridge 1 year in original unopened packaging. 4.5 gallon pail 6 months. 50 gallon drum 6 months. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. Limestone
	REŠŪLTS MAY DIFFER BASED UPON STATISTIČA TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Conditions: Color: VOC Content: Application Temperature: Service Range: Curing Rate Tack-free Time: Recovery:	LVARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND LURING CONDITIONS. 10.1 oz. cartridge 1 year in original unopened packaging. 29 oz. cartridge 1 year in original unopened packaging. 4.5 gallon pail 6 months. 50 gallon drum 6 months. Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. Limestone 40 g/l 40°-100°F. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F. 1 to 2 hours. Final Cure: 3 to 5 days >90%



Coverage	10.1	l oz Cartrio	dge: Yield	in Linear	feet		29 o	z Cartrid	ge: Yield i	n Linear f	eet		1 ga	llon: Yield	l in Linea	r feet	
		Depth	1/4"	3/8"	1/2"	1		)epth	1/4"	3/8"	1/2"	1		Depth	1/4"	3/8"	1/2"
		1/4"	24.3		i —	i		1/4"	69.8			1		1/4"	307.9		
		3/8"	16.2	10.8	1	1		3/8"	46.5	31.0		1		3/8"	205.3	136.8	
		1/2"	12.1	8.1	6.1			1/2"	34.9	23.3	17.4	1		1/2"	153.9	102.6	77.0
	Width	3/4"	8.1	5.4	4.0	1	Width	3/4"	23.3	15.5	11.6	1	Width	3/4"	102.6	68.4	51.
	8	1"		<u> </u>	3.0	1	∣≥	1"			8.7	1	∣≥	1"			38.
		1.25"			2.4	1		1.25"			7.0	1		1.25"			30.
		1.5"			2.0	1		1.5"			5.8	1		1.5"			25
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Sika Corporation and a Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# Sikaflex<sup>®</sup>-2c NS

### Two-component, non-sag, polyurethane elastomeric sealant

Description	Sikaflex-2c NS is a 2-component, premium-grade, polyurethane-based, elastomeric sealant. It is principally a chemical cure in a non-sag consistency. Meets ASTM C-920, Type M, Grade NS, Class 25, use T, NT, M, G, A, O, I and Federal Specification TT-S-00227E, Type II, Class A. Tested in accordance with ASTM C-1382 for use in EIFS systems.
Where to use	<ul> <li>Intended for use in all properly designed working joints with a minimum depth of 1/4 inch.</li> <li>Ideal for vertical and horizontal applications.</li> <li>Placeable at temperatures as low as 40°F.</li> <li>Adheres to most substrates commonly found in construction.</li> <li>An effective sealant for use in Exterior Insulation Finish Systems (EIFS).</li> <li>Submerged environments, such as canal and reservoir joints.</li> </ul>
Advantages	<ul> <li>Capable of ±50% joint movement.</li> <li>Chemical cure allows the sealant to be placed in joints exceeding 1/2 in. in depth.</li> <li>High elasticity with a tough, durable, flexible consistency.</li> <li>Exceptional cut and tear resistance.</li> <li>Exceptional adhesion to most substrates without priming.</li> <li>Available in 35 architectural colors.</li> <li>Color uniformity assured via Color-pak system.</li> <li>Available in pre-pigmented Limestone Gray (no Color-pak needed).</li> <li>Non-sag even in wide joints.</li> <li>Easy to mix.</li> <li>Paintable with water-, oil-, and rubber-base paints.</li> <li>Jet fuel resistant.</li> </ul>
Packaging	1.5 gal. unit. 3 gal units.

#### **Typical Data** (*Material and curing conditions 73°F (23°C) and 50% R.H.*) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf life	One year in original	, unopened containers.
Storage Conditions	Store dry at 40°-95° material to 65°-75°	°F (4°-35°C). Condition F before using.
Colors	0	hitectural colors are avail- available on request.
Application Temperature	· · · · · ·	t and substrate temperatures. stalled when joint is at mid- d movement.
Service Range	-40° to 170°F (-40°-	75°C).
Curing Rate (ASTM C-679)		
Tack-Free Time Final Cure	6-8 hrs.	
	3 days	
Application Life	3-4 hrs.	
Tear Strength	ASTM D-624	45 lb./in.
Shore A Hardness	ASTM D-2240	25 ± 5
Tensile Properties (ASTM D-412) Tensile Strength at Break Tensile Elongation Stress at 100%	95 psi 500% 70 psi	
Adhesion in Peel (Fed Spec. TT-S-00 Substrate Peel Strength	% Adhesion Loss	
Concrete 25 lb.	Zero	
Weathering Resistance	Excellent	
Chemical Resistance	lines, and residentia	water, diluted acids, diluted alka al sewage. Consult Technical Ser- IIKA for specific data.



Coverage	1 ga	llon: Yiel	d in Linea	r feet		
	[	Depth	1/4"	3/8"	1/2"	1
		1/4"	307.9		1	1
		3/8"	205.3	136.8	1	1
		1/2"	153.9	102.6	77.0	1
	Width	3/4"	102.6	68.4	51.3	1
	>	1"			38.5	1
		1.25"			30.8	1
		1.5"	İ		25.7	1
How to Use				•		
Surface Preparation	and tape Prim cure Serv Syst	any oth or bac ing is t . Testir vice or s tems (E	er foreig ker rod i ypically g shoul Sikaflex IFS) ma	n matte must be not nec d be do Primer nufactu	er that m e used i cessary. one, ho Technie irers rec	n, sound, and frost-free. Joint walls must be free of oils, grease, curing compound light prevent bond. Ideally this should be accomplished by mechanical means. Bon n bottom of joint to prevent bond. Most substrates only require priming if sealant will be subjected to water immer wever, on questionable substrates, to determine if priming is needed. Consult cal Data Sheet for additional information on priming. Note: Most Exterior Insulati commend the use of a primer. When EIFS manufacturer specifies a primer or if on- sary, Sikaflex 429 primer is recommended. On-site adhesion testing is recommer
Mixing	Pou low- dow mixi of th shou time	r entire speed o n sides ng pado e pail d uld reac and th	drill (400 of pail p dle to the uring the h the bo en mix f	s of Co -600 rp periodic e bottor e first m ttom of or an a	mpone om) and ally. Ave m of the inute of the pai dditiona	ob. nt 'B' into pail of Component 'A'. Add entire contents of Color-pak into pail and n Sikaflex paddle.* Mix for 3-5 minutes to achieve a uniform color and consistence oid entrapment of air during mixing. When mixing in cold weather (<50°F), do not pail. After adding Component 'B' and Color-pak into Component 'A', mix the top f mixing. After scraping down the sides of the pail, mix again for another minute. Th between the first and second minute of mixing. Scrape down the sides of the pail al 2-3 minutes until the sealant is well blended. Color-pak must be used with tint I st mix with low speed drill and Sikaflex paddle (no Color-pak needed).
Application	at ex App at m To p joint Also max	ktremes ly seala id-point lace, los lace, los . Keepin , avoid imum tl	. Move nt only of its d ad direct ng the n overlap	pre-con to clear esigned tly into t ozzle do oing of s for sea	nditione n, sound d expan bulk gur eep in tl sealant alant. F	ratures 40°-100°F. Pre-conditioning units to approximately 70°F is necessary whe d units to work areas just prior to application. d, dry, and frost-free substrates. Sikaflex-2c should be applied into joints when jo sion and contraction. nor use a follower plate loading system. Place nozzle of gun into bottom of joint and ne sealant, continue with a steady flow of sealant preceding nozzle to avoid air en since this also entraps air. Joint dimension should allow for 1/4 inch minimum an Proper design is 2:1 width to depth ratio. Tool sealant to ensure full contact with j
Limitations		Minimu Maximu Do not of Avoid c Allow 3 total wa Avoid e Do not of Avoid o White c Light co When c Rigid pa The dep	m depth im expa cure in t ontact w day cur iter imm xposure apply wh ver-mixi olor ten ilors car vercoat ints, co oth of se	in work nsion a he prese vith alcce e before ersion. to high nen mo ng seal ds to yee yellow ing: an atings co ealant ir	king joir nd cont sence of ohol and e subje n levels isture v lant. ellow slip r if expo on-site or prime n horizo	<ul> <li>sikaflex-2c NS depends on good joint design and proper application.</li> <li>it is 1/4 in.</li> <li>raction should not exceed 50% of average joint width.</li> <li>f curing silicones.</li> <li>I other solvent cleaners during cure.</li> <li>cting sealant to total water immersion. Primer is required if sealant will be subject</li> <li>of chlorine. (Maximum level is 5 ppm).</li> <li>apor transmission exists since this can cause bubbling within the sealant.</li> <li>ghtly when exposed to ultraviolet rays.</li> <li>sed to direct gas fired heating elements.</li> <li>test is recommended to determine actual compatibility.</li> <li>rs will crack when placed over elastomeric sealants experiencing expansion or con</li> <li>ntal joints subject to traffic is 1/2 inch.</li> <li>ry traffic either recess joint or use TG (Traffic Grade) Additive to increase durabiliti</li> </ul>
INS SHE PAR TO F REN KEEPC For fu	TRUC ET W TMEN READ IT PR CONTAIN Inther i I Safet	TIONS HICH A NT AT 8 AND F ODUCT NER TIGHT Informat y Data S	ON THI ARE AV/ 00.933. OLLOW DATA LY CLOSE ion and heets co	E PROI AILABL 7452 NG 7452 NG 7452 NG 752 NG 8HEET D. KEEP C advice r ntaining	DUCT'S E ONL OTHING WARNII , PROD DUT OF RE regardin physica	PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNING MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFET INE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERV 3 CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLI NGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN TH UCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. SACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL g transportation, handling, storage and disposal of chemical products, users should re al, ecological, toxicological and other safety related data. Read the current actual Safety D

current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

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1-800-933-SIKA NATIONWIDE

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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# Sikaflex<sup>®</sup>-2c NS EZ Mix

Two-component, non-sag, polyurethane elastomeric sealant

Description		ag consistency. Meets AST	M C-920, Type M, Grade NS, Class 25, us I, Class A. Meets CAN/CGSB 19.24 - M90
Where to Use	<ul> <li>Intended for use in all properly desideal for vertical and horizontal app</li> <li>Placeable at temperatures as low a</li> <li>Adheres to most substrates comm</li> <li>An effective sealant for use in External</li> </ul>	plications. as 40°F. only found in construction. rior Insulation Finish System	
Advantages	<ul> <li>Submerged environments, such as</li> <li>Capable of ±50% joint movement.</li> <li>Chemical cure allows the sealant to</li> <li>High elasticity with a tough, durable</li> <li>Exceptional cut and tear resistance</li> <li>Exceptional adhesion to most subs</li> <li>Available in 35 architectural colors.</li> <li>Color uniformity assured via Color-</li> <li>Available in pre-pigmented Limesto</li> <li>Non-sag even in wide joints.</li> <li>Certified to the NSF/ANSI Standard</li> <li>Easy to mix.</li> <li>Paintable with water-, oil-, and rubb</li> <li>Jet fuel resistant.</li> <li>Cold weather booster for initial tack</li> <li>Shore A hardness can be increased</li> </ul>	o be placed in joints exceed e, flexible consistency. e. strates without priming. pak system. one Gray (no Color-pak nee d 61 for potable water. ber-base paints. < (see reverse side for data	eded).
	cific details.		
Packaging		I STATISTICAL VARIATIONS DEPE	ENDING UPON MIXING METHODS AND EQUIPMENT,
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S	NDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9	NDING UPON MIXING METHODS AND EQUIPMENT,
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Shelf life	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7	NDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. Ial, unopened containers. 5°F (4°-35°C). Condition 5°F before using. rchitectural colors are available.
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Shelf life Storage Conditions	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7 A wide range of an Special colors ava 40° to 100°F, amb	ENDING UPON MIXING METHODS AND EQUIPMENT,         SITE CONDITIONS AND CURING CONDITIONS.         Ial, unopened containers.         15°F (4°-35°C). Condition <b>5°F before using.</b> rchitectural colors are available.         ailable on request.         bient and substrate temperatures.         e installed when joint is at mid-range of its
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Shelf life Storage Conditions Colors	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7' A wide range of an Special colors ava 40° to 100°F, amb Sealant should be	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 13°F (4°-35°C). Condition 5°F before using. rchitectural colors are available. ailable on request. bient and substrate temperatures. a installed when joint is at mid-range of its ment.
Packaging	Typical Data (Material and RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METHON         Shelf life         Storage Conditions         Colors         Application Temperature	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7' A wide range of an Special colors ava 40° to 100°F, amb Sealant should be anticipated mover	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 13°F (4°-35°C). Condition 5°F before using. rchitectural colors are available. ailable on request. bient and substrate temperatures. a installed when joint is at mid-range of its ment.
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH         Shelf life         Storage Conditions         Colors         Application Temperature         Service Range	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7 A wide range of ai Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time	ADDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 141, unopened containers. 5°F (4°-35°C). Condition 5°F before using. Trohitectural colors are available. ailable on request. bient and substrate temperatures. bient and bient and b
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH         Shelf life         Storage Conditions         Colors         Application Temperature         Service Range         Curing Rate (ASTM C-679)	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7 A wide range of ai Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time Final Cure	NDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 141, unopened containers. 5°F (4°-35°C). Condition 5°F before using. rchitectural colors are available. ailable on request. bient and substrate temperatures. bient and bient an
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH         Shelf life         Storage Conditions         Colors         Application Temperature         Service Range         Curing Rate (ASTM C-679)         Application Life	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7 A wide range of ai Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time Final Cure 4-6 hrs.	NDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. 15°F (4°-35°C). Condition 5°F before using. rchitectural colors are available. ailable on request. bient and substrate temperatures. e installed when joint is at mid-range of its ment. 1°-75°C). 8-10 hrs. 3 days
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH         Shelf life         Storage Conditions         Colors         Application Temperature         Service Range         Curing Rate (ASTM C-679)         Application Life         Tear Strength	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-7' A wide range of an Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time Final Cure 4-6 hrs. ASTM D-624 ASTM D-2240	ADDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS.  Ital, unopened containers. 15°F (4°-35°C). Condition 5°F before using. rchitectural colors are available. ailable on request. bient and substrate temperatures. a installed when joint is at mid-range of its ment. 1°-75°C). 8-10 hrs. 3 days 45 lb./in.
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH         Shelf life         Storage Conditions         Colors         Application Temperature         Service Range         Curing Rate (ASTM C-679)         Application Life         Teas Strength         Shore A Hardness         Tensile Strength at Break         Tensile Strength at Break	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-73 A wide range of ai Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time Final Cure 4-6 hrs. ASTM D-624 ASTM D-624 ASTM D-2240 2) 95 psi 300% 70 psi T-S-00227E) gth % Adhesion Loss	ENDING UPON MIXING METHODS AND EQUIPMENT,         SITE CONDITIONS AND CURING CONDITIONS.         ial, unopened containers.         '5°F (4°-35°C). Condition <b>5°F before using.</b> rchitectural colors are available.         aliable on request.         bient and substrate temperatures.         e installed when joint is at mid-range of its ment.         )°-75°C).         8-10 hrs.         3 days         45 lb./in.         25 ± 5
Packaging	Typical Data (Material an RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Shelf life Storage Conditions Colors Application Temperature Service Range Curing Rate (ASTM C-679) Application Life Tear Strength Shore A Hardness Tensile Properties (ASTM D-412 Tensile Strength at Break Tensile Elongation Stress at 100% Adhesion in Peel (Fed Spec. TT	I STATISTICAL VARIATIONS DEPE IODS, TEST METHODS, ACTUAL S One year in origin Store dry at 40°-9 material to 65°-73 A wide range of ai Special colors ava 40° to 100°F, amb Sealant should be anticipated mover -40° to 170°F (-40 Tack-Free Time Final Cure 4-6 hrs. ASTM D-624 ASTM D-624 ASTM D-2240 2) 95 psi 300% 70 psi T-S-00227E) gth % Adhesion Loss	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. tal, unopened containers. $5^{\circ}F$ (4°-35°C). Condition $5^{\circ}F$ before using. rchitectural colors are available. aliable on request. bient and substrate temperatures. e installed when joint is at mid-range of its ment. $9^{\circ}$ -75°C). 8-10 hrs. 3 days 45 lb./in. 25 ± 5



Coverage

1ga	1 gallon: Yield in Linear feet													
0	)epth	1/4"	3/8"	1/2"										
	1/4"	307.9												
	3/8"	205.3	136.8											
_	1/2"	153.9	102.6	77.0										
Width	3/4"	102.6	68.4	51.3										
	1"			38.5										
	1.25"			30.8										
	1.5"			25.7										

#### How to Use

Surface Preparation	Priming is typically not necessary. Most substrates only require priming if sealant will be subjected to water immersion after cure. Testing should be done, however, on questionable substrates, to determine if priming is needed. Consult Technical Service or Sikaflex Primer Technical Data Sheet for additional information on priming. Note: Most Exterior Insulation Finish Systems (EIFS) manufacturers recommend the use of a primer. When EIFS manufacturer specifies a primer or if on-site bond testing indicates a primer is necessary, Sikaflex 429 primer is recommended. On-site adhesion testing is recommended with final system prior to the start of a job.
Mixing	Pour entire contents of Component 'B' into pail of Component 'A'. Add entire contents of Color-pak into pail and mix with a low-speed drill (400-600 rpm) and Sikaflex paddle.* Mix for 3-5 minutes to achieve a uniform color and consistency. Scrape down sides of pail periodically. Avoid entrapment of air during mixing. When mixing in cold weather (<50°F), do not force the mixing paddle to the bottom of the pail. After adding Component 'B' and Color-pak into Component 'A', mix the top 1/2 to 3/4 of the pail during the first minute of mixing. After scraping down the sides of the pail, mix again for another minute. The paddle should reach the bottom of the pail between the first and second minute of mixing. Scrape down the sides of the pail a second time and then mix for an additional 2-3 minutes until the sealant is well blended. Color-pak must be used with tint base. For pre-pigmented Limestone base, just mix with low speed drill and Sikaflex paddle (no Color-pak needed).
Application	Recommended application temperatures 40°-100°F. Pre-conditioning units to 65-75°F is necessary when work- ing at extremes. Move pre-conditioned units to work areas just prior to application. Apply sealant only to clean, sound, dry, and frost-free substrates. Sikaflex-2c should be applied into joints when joint slot is at mid-point of its designed expansion and contraction. To place, load directly into bulk gun or use a follower plate loading system. Place nozzle of gun into bottom of joint and fill entire joint. Keeping the nozzle deep in the sealant, continue with a steady flow of sealant preceding nozzle to avoid air entrapment. Also, avoid overlapping of sealant since this also entraps air.
Tooling and Finishing	Tool sealant to ensure full contact with joint walls and remove air entrapment. Joint dimension should allow for 1/4 inch minimum and 1/2 inch maximum thickness for sealant. Proper design is 2:1 width to depth ratio. To accelerate the cure of Sikaflex-2c NS EZ Mix in cold weather temperatures, add Sikaflex-2c booster.
Removal	Uncured material can be removed with xylene. Strictly follow solvent manufacturer's warnings and instructions for use. Cured material can only be removed mechanically. For spillage, collect, absorb, and dispose of in accordance with current, applicable local, state, and federal regulations.

#### Sikaflex-2c NS EZ Mix Working Time, hours

	73°F	100°F	40°F
Sikaflex-2c NS	4-6 hrs.	3 hrs.	6 hrs.
w/ 1 booster	2 hrs.	1 hr.	2-3 hrs.
w/ 2 boosters	1 hr.	<1 hr.	1.5 hrs.



Limitations

- The ultimate performance of Sikaflex-2c NS EZ Mix, depends on good joint design and proper application.
   Minimum depth in working joint is 1/4 in.
- Maximum expansion and contraction should not exceed 50% of average joint width.
- When used in areas with heavy traffic either recess joint or use TG (Traffic Grade) Additive to increase durability.
- Do not cure in the presence of curing silicones.
- Avoid contact with alcohol and other solvent cleaners during cure.
- Allow 3 day cure before subjecting sealant to total water immersion. Primer is required if sealant will be subjected to total water immersion.
  - Avoid exposure to high levels of chlorine. (Maximum level is 5 ppm).
  - Do not apply when moisture vapor transmission exists since this can cause bubbling within the sealant.
     Avoid over-mixing sealant.
  - White color tends to yellow slightly when exposed to ultraviolet rays.
  - Light colors can yellow if exposed to direct gas fired heating elements.
- When overcoating, an on-site test is recommended to determine actual compatibility.
  - Rigid paints, coatings or primers will crack when placed over elastomeric sealants experiencing expansion or contraction
  - Do not use in contact with bituminous/asphaltic materials.

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Product Data Sheet Edition 6.8.2016 Sikaflex-2c NS TG

### **Sikaflex®-2c NS TG** Two-component, traffic-grade,

polyurethane elastomeric sealant

Description	1 0 1	olyurethane-based elastomeric sealant. It is principally a chemica 35 standard colors (>320 special colors) with a convenient Colorpal
	Also available as a pre-pigmented product	t in Limestone Gray. Meets ASTM C 920, Type M, Grade NS, use TT-S-00227E. Product developed by addition of Sikaflex 2c NS T
Where to Use	<ul> <li>pneumatic-tire traffic.</li> <li>Intended for horizontal joints with a mini</li> <li>Placeable at temperatures as low as 40</li> <li>Adheres to most substrates commonly f</li> </ul>	)°F.
Advantages	Capable of +25% joint movement.	placed in joints exceeding an inch in depth. s without priming. system or pre-pigmented Limestone Gray.
Chemical Resistance	Good resistance to water, diluted acids, a	Ind diluted alkalines. Consult Technical Service at 1-800-933-SIK
	for specific data.	
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16	
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16	L) component
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> RESULTS MAY DIFFER BASED UPON STATISTIC	L) component
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> , RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life:	L) component imestone Gray color available pre-pigmented. g conditions 73°F (23°C) and 50% R.H.) AL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, I METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened containers.
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST	L) component imestone Gray color available pre-pigmented. g conditions 73°F (23°C) and 50% R.H.) cal variations depending upon Mixing Methods and Equipment, r METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Condition:	L) component imestone Gray color available pre-pigmented. <b>g conditions 73°F (23°C) and 50% R.H.)</b> AL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened containers. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. A wide range of architectural colors are available. Special colors available on request. 40° to 100°F, ambient and substrate temperatures. Sealant should be installed when joint is at mid-range of
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> , RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Condition: Colors:	L) component imestone Gray color available pre-pigmented. <b>g conditions 73°F (23°C) and 50% R.H.)</b> AL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, I METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened containers. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. A wide range of architectural colors are available. Special colors available on request. 40° to 100°F, ambient and substrate temperatures.
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> , RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Condition: Colors: Application Temperature: Service Range: Shore A Hardness (ASTM D-2240): Tensile Properties (ASTM D-412): Tensile Stress: Elongation at Break: Stress at 100%: Adhesion in Peel (TT-S-00230C, AS	L) component imestone Gray color available pre-pigmented. <b>g conditions 73°F (23°C) and 50% R.H.)</b> AL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened containers. Store dry at 40°-95°F (4°-35°C). Condition material to $65^\circ$ - $75^\circ$ F before using. A wide range of architectural colors are available. Special colors available on request. $40^\circ$ to $100^\circ$ F, ambient and substrate temperatures. Sealant should be installed when joint is at mid-range of its anticipated movement. $-40^\circ$ to $170^\circ$ F ( $-40^\circ - 75^\circ$ C) 21 day $45 \pm 5$ 21 day 220 psi 300% 140 psi
Packaging	1.5 gal. unit (5.7 L) plus 5.25- fl. oz. (0.16 Color-pak is also purchased separately. Li <b>Typical Data</b> ( <i>Material and curin</i> , RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life: Storage Condition: Colors: Application Temperature: Service Range: Shore A Hardness (ASTM D-2240): Tensile Properties (ASTM D-412): Tensile Stress: Elongation at Break: Stress at 100%: Adhesion in Peel (TT-S-00230C, AS	L) component imestone Gray color available pre-pigmented. <b>g conditions 73°F (23°C) and 50% R.H.)</b> AL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, r METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. One year in original, unopened containers. Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using. A wide range of architectural colors are available. Special colors available on request. 40° to 100°F, ambient and substrate temperatures. Sealant should be installed when joint is at mid-range of its anticipated movement. -40° to 170°F (-40° - 75°C) 21 day 45 ± 5 21 day 220 psi 300% 140 psi TM C-794)



Coverage

1 ga	1 gallon: Yield in Linear feet				
Depth		1/4"	3/8"	1/2"	
	1/4"	307.9			
	3/8"	205.3	136.8		
	1/2"	153.9	102.6	77.0	
Width	3/4"	102.6	68.4	51.3	
>	1"			38.5	
	1.25"			30.8	
	1.5"			25.7	

How to Use

All joint-wall surfaces must be clean, sound, and frost-free. Joint walls must be free of oils, grease, curing Surface Preparation compound residues, and any other foreign matter that might prevent bond. Ideally, this should be accomplished by mechanical means. A roughened surface will also enhance bond. Bond breaker tape or backer rod must be used in bottom of joint to prevent bond. Priming Priming is typically not necessary. Most substrates only require priming if sealant will be subjected to water immersion after cure. Testing should be done, however, on questionable substrates, to determine if priming is needed. Consult Technical Service or Sikaflex Primer Technical Data Sheet for additional information on priming. Mixing Pour entire contents of Component 'B' and (1) 1/2 pint unit of Sikaflex-2c NS TG Component into pail of Component 'A'. For tint base: add entire contents of Color-pak into pail and mix with a low-speed drill (400-600 rpm) and Sikaflex paddle. \*Mix for 3-5 minutes to achieve a uniform color and consistency. Scrape down sides of pail periodically. Avoid entrapment of air during mixing. \*For pre-pigmented limestone base: just mix with low speed drill and Sikaflex paddle without Color-pak. Application Recommended application temperatures 40°-100°F. Pre-conditioning units to 65-75°F is necessary when working at extremes. Move pre-conditioned units to work areas just prior to application. Apply sealant only to clean, sound, dry, and frost-free substrates. Sikaflex-2c NS TG should be applied into joints when joint slot is at mid-point of its designed expansion and contraction. To place NS TG, load directly into bulk gun or use a follower plate loading system. Place nozzle of gun into bottom of joint and fill entire joint. Keeping the nozzle deep in the sealant, continue with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping of sealant to eliminate entrapment of air. Tool as required. Proper design is 2:1 width to depth ratio. Tooling and Finishing Tool as required. Proper design is 2:1 width to depth ratio. Uncured material can be removed with xylene. Strictly follow solvent manufacturer's warnings and instructions Removal for use. Cured material can only be removed mechanically. In case of spillage, wear suitable protective equipment, collect with absorbent materials and dispose of in accordance with current, applicable local, state, and federal regulations. Allow 3-day cure before subjecting sealant to total water immersion and prior to painting. **Over Painting** The ultimate performance of Sikaflex 2c NS TG depends on good joint design and proper application. Limitations Sealant depth for horizontal joint subject to traffic must be 1/2 in Maximum expansion and contraction should not exceed 25% of average joint width. Protect Sikaflex-2c NS TG Component from moisture. Use entire contents of container.

- Maximum addition rate of TG Component is (1) 1/2 pint container/unit of Sikaflex-2c NS.
- Do not cure in the presence of curing silicones.
- Avoid contact with alcohol and other solvent cleaners during cure.
- Allow 3 day cure before subjecting sealant to total water immersion. Primer is required if sealant will be subjected to total water immersion.
- Do not apply when moisture vapor transmission exists since this can cause bubbling within the sealant. Avoid over-mixing sealant.
- White color tends to yellow over time when exposed to ultraviolet rays.
- When over-coating: an on-site test is recommended to determine actual compatibility and adhesion.
- The depth of sealant in horizontal joints subject to traffic is 1/2 in.
- Avoid exposure to high levels of chlorine. (Maximum continuous level is 5 ppm).
- Do not tool with detergent or soap solutions.
- Do not use in contact with bituminous/asphaltic materials

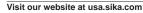
PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

LEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product us

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro **RESPONSIBLE CARE** C.P. 76920 Phone: 52 442 2385800



# Sikaflex<sup>®</sup>-2c SL

### Two-component, self-leveling, polyurethane elastomeric sealant

		t, premium-grade, polyurethane-based, elastomeric sealant. It is principally a consistency. Meets ASTM C-920, Type M, Grade P, Class 25, use T, NT, M, G, n TT-S-00227E, Type 1, Class A.
Where to use	<ul><li>Ideal for horizontal application</li><li>Placeable at temperatures as</li></ul>	s low as 40°F. commonly found in construction.
Advantages	<ul> <li>High elasticity with a tough, du</li> <li>Exceptional cut and tear resist</li> <li>Exceptional adhesion to most</li> <li>Available in 35 architectural co</li> <li>Color uniformity assured via C</li> </ul>	alant to be placed in non-moving joints exceeding 1/2 in. in depth. durable, flexible consistency. stance. it substrates without priming. colors. Color-pak system. imestone Gray (no Color-pak needed). sy to apply in horizontal joints.
Packaging	1.5 gal. unit. 3 gal. units. Color-pa	ak is purchased separately. Limestone Gray color available pre-pigmented.
	RESULTS MAY DIFFER BASED UPO	<ul> <li>and curing conditions 73°F (23°C) and 50% R.H.)</li> <li>ON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, ETHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>One year in original, unopened containers.</li> <li>Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F before using.</li> <li>A wide range of architectural colors are available. Special colors available on request.</li> <li>40° to 100°F, ambient and substrate temperatures. Sealant should be installed when joint is at mid-range of its anticipated movement.</li> <li>-40° to 170°F (-40°-75°C).</li> </ul>
	Curing Rate (ASTM C-679)	) Tack-free Time 6-8 hrs. Final Cure 3 days
	Concrete Weathering Resistance	4 100 lb./in. D-2240 40 ± 5 D412) eak 175 psi 650% 100 psi
		vage. Consult Technical Service for specific data.



Coverage	1 gall	lon: Yield in	Linear	feet		
-	De	epth 1	/4"	3/8"	1/2"	
		<u> </u>	07.9	-,-	.,=	
	-		05.3	136.8		
			53.9	102.6	77.0	
	Width		) )2.6	68.4	51.3	
	Š	3/4 IU 1"	J2.6	68.4		
		1.25"			38.5	
					30.8	
Have to Halo		1.5"			25.7	
	poun mech used Prim imme	nd residu hanical n d in botto ing is typersion af eeded. C	es, a nean m of picall ter c	ind any is. A ro joint to ly not i ure. Te	y other oughen o preve necess esting s	an, sound, and frost-free. Joint walls must be free of oils, grease, curing com- foreign matter that might prevent bond. Ideally this should be accomplished by ed surface will also enhance bond. Bond breaker tape or backer rod must be ent bond. ary. Most substrates only require priming if sealant will be subjected to water should be done, however, on questionable substrates, to determine if priming Service or Sikaflex Primer Technical Data Sheet for additional information on
Mixing	Pour mix v consi with t	entire co with a low istency. S tint base.	/-spe Scrap . Note	ed drill be dow e: Whe	400-6) n sides n mixi	nent 'B' into pail of Component 'A'. Add entire contents of Color-pak into pail and 00 rpm) and Sikaflex paddle. * Mix for 3-5 minutes to achieve a uniform color and of pail periodically. Avoid entrapment of air during mixing. Color-pak must be used ng 3 gal. unit, two containers of Component B and two color-paks must be used. base, just mix with low speed drill and Sikaflex paddle (no Color-pak needed).
	ing a soun its de flow a syste conti	at extreme ad, dry, and esigned e and leve em. Place	es. Ń nd fro expa l as r e no: n a st	love p ost-fre nsion a necess zzle of teady f	re-cone e subs and con ary. If e f gun ir flow of	peratures 40°-100°F. Pre-conditioning units to 65-75°F is necessary when work- ditioned units to work areas just prior to application. Apply sealant only to clean, trates. Sikaflex-2c should be applied into joints when joint slot is at mid-point of ntraction. To place, pour or extrude the SL grade in one direction and allow it to extruding, load mixed sealant directly into bulk gun or use follower plate loading to bottom of joint and fill entire joint. Keeping the nozzle deep in the sealant, sealant preceding nozzle to avoid air entrapment. Also, avoid overlapping of air.
						nsion should allow for 1/4 inch minimum and 1/2 inch maximum thickness for ridth to depth ratio.
1	for u	ise. Cure	ed ma	aterial	can or	ved with xylene. Strictly follow solvent manufacturer's warnings and instructions hly be removed mechanically. For spillage, collect, absorb, and dispose of in cable local, state, and federal regulations.
	<ul> <li>M</li> <li>M</li> <li>M</li> <li>M</li> <li>A</li> <li>A&lt;</li></ul>	linimum o laximum o not cur void coni llow 3 da ubjected void expr o not app void ove /hite color /hen ove igid pain ion or co he minim	depth expa re in tact v to to osure ply w r-mix or ten rs ca rcoa ts, co ntrac	h in wo ansion the pro- with all re before tal wa e to hig when m king se nds to y hads to y hads to y hads to y hads to y the ting: a catings ction.	orking j and co esence cohol a ore sub ter imn gh leve alant. yellow w if ex s or pri of seal	f Sikaflex-2c, depends on good joint design and proper application. oint is 1/4 in. ontraction should not exceed 25% of average joint width. of curing silicones. ind other solvent cleaners during cure. jecting sealant to total water immersion. Primer is required if sealant will be nersion. Is of chlorine. (Maximum level is 5 ppm). e vapor transmission exists since this can cause bubbling within the sealant. slightly when exposed to ultraviolet rays. posed to direct gas fired heating elements. te test is recommended to determine actual compatibility. mers will crack when placed over elastomeric sealants experiencing expan- ant in horizontal joints subject to traffic is 1/2 inch. r soap solution.
INSTRU SHEET PARTMI TO REA <u>RENT P</u> KEEPCOI For furti	UCTIC WHICENT AD AN PROD WITAINE	ONS ON T CH ARE A AT 800.93 ND FOLLO OUCT DAT ER TIGHTLY C Information Data Sheet	THE F AVAIL 33.745 OW T A SH CLOSED and a ts con	PRODU LABLE 52 NOT THE WA IEET, P D. KEEP O Indvice re Intaining	CT'S N ONLIN HING C RNING RODUC UT OF RE/ egarding physical	CODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND IOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA E AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION S AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- CT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. ACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY. transportation, handling, storage and disposal of chemical products, users should refer to the ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet
before u Prior to Data Sh ment at for each product SIKA wa the curr Buyer's EXPRES SHALLI THE USI	each n eeet, pr 800-93 n Sika t use. arrants sole r SS OR NOT B E OF T	the product use of any product lab 33-7452. No product as control of the roduct Data remedy sha R IMPLIED S BE LIABLE THIS PROD	ct. In c Sika p el and othing s set f luct fo a Shee all be l SHALI UNDE UCT IN	case of e product, I Safety I g contain orth in t or one ye tif usec imited to L APPLY R ANY L N A MAN	the user Data She ned in an the curre ar from d as direc o the pur INCLUE EGAL T NER TO	cy, call CHEMTREC at 1-800-424-9300, International 703-527-3887. must always read and follow the warnings and instructions on the product's most current Product tet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart- y Sika materials relieves the user of the obligation to read and follow the warnings and instruction nt Product Data Sheet, product label and Safety Data Sheet prior to date of installation to be free from manufacturing defects and to meet the technical properties on ted within shelf life. User determines suitability of product for intended use and assumes all risks. ING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, SIKA HEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR NFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.
R CALLIN Visit ou Region	IG 201 ur wel nal Inf	-933-8800. bsite at us ormation orporation	sa.sik and S	a.com Sales Ce	enters. F Sika Ca	SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY  1-800-933-SIKA NATIONWIDE For the location of your nearest Sika sales office, contact your regional center.  nada Inc. nar Avenue Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

# **Sikaflex® Textured Sealant**

One-component, all purpose, polyurethane sealant

Description	Cilcoflay, Tayturad Capiant i	a presidure sured 1 component relyungthere based non-
	elastomeric sealant capabl	s a moisture-cured, 1-component, polyurethane-based, non-sag e of ±25% joint movement. Meets Federal specification TT-S- leets ASTM C-920, Type S, Grade NS, Class 25.
Where to Use	<ul> <li>Suitable for vertical and</li> <li>Has many applications a cients of expansion.</li> <li>Ideal for:         <ul> <li>Weatherproofing of j crete or metal frame:</li> </ul> </li> </ul>	f joints where maximum depth of sealant will not exceed ½ inch. horizontal joints; readily placeable at 40°F (4°C). as an elastic sealant between materials with dissimilar coeffi- oints between brickwork, blockwork, masonry, wood and con- s. nies, around window or door frames.
Advantages	<ul> <li>Textured appearance ble</li> <li>Hides imperfections from</li> <li>Excellent resistance to a</li> <li>Non-staining.</li> <li>Paintable with water-, oi</li> <li>High elasticity – cures to tear-resistance.</li> <li>Stress relaxation.</li> </ul>	nds to most construction materials without a primer. ends well to rough or stucco type surfaces. In tooling that a smooth sealant does not. aging, weathering. I- and rubber-based paints. I- and rubber-based paints. I- a tough, durable, flexible consistency with exceptional cut and sted by EPA for radon reduction.
Packaging	Disposable 10.1 fl. oz., mo	isture-proof composite cartridges, 24/case.
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPC	isture-proof composite cartridges, 24/case.
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPC	I and curing conditions @ 73°F (23°C) and 50% R.H.)
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET	<b>I and curing conditions @ 73°F (23°C) and 50% R.H.)</b> ON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET Shelf Life	<b>I and curing conditions @ 73°F (23°C) and 50% R.H.)</b> ON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, FHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 12 months Store at 40°-95°F (4°-35°C). <b>Condition material to 65°-75°F</b>
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET Shelf Life Storage Conditions	<b>I and curing conditions @ 73°F (23°C) and 50% R.H.)</b> DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 12 months Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET Shelf Life Storage Conditions VOC Content Standard Colors	<b>I and curing conditions @ 73°F (23°C) and 50% R.H.)</b> DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 12 months Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using. 40 g/L
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET Shelf Life Storage Conditions VOC Content Standard Colors	<ul> <li>I and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, ITHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months</li> <li>Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> <li>40 g/L</li> <li>White, aluminum gray, limestone, dark bronze, buff and stone.</li> <li>40° to 100°F (4°-38°C). Sealant should be installed when</li> </ul>
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION MET Shelf Life Storage Conditions VOC Content Standard Colors Application Temperature	<ul> <li>I and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months</li> <li>Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> <li>40 g/L</li> <li>White, aluminum gray, limestone, dark bronze, buff and stone.</li> <li>40° to 100°F (4°-38°C). Sealant should be installed when joint is at midrange of its anticipated movement.</li> </ul>
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION METShelf Life Storage ConditionsVOC Content Standard Colors Application Temperature Service Range	<ul> <li>I and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months</li> <li>Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> <li>40 g/L</li> <li>White, aluminum gray, limestone, dark bronze, buff and stone.</li> <li>40° to 100°F (4°-38°C). Sealant should be installed when joint is at midrange of its anticipated movement.</li> <li>-40° to 170°F (-40°-77°C)</li> </ul>
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION METShelf LifeStorage ConditionsVOC Content Standard ColorsApplication TemperatureService Range Curing RateShore A HardnessAdhesion in Peel (ASTM)	<ul> <li>I and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months</li> <li>Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> <li>40 g/L</li> <li>White, aluminum gray, limestone, dark bronze, buff and stone.</li> <li>40° to 100°F (4°-38°C). Sealant should be installed when joint is at midrange of its anticipated movement.</li> <li>-40° to 170°F (-40°-77°C)</li> <li>Tack-free time: &lt;6 hrs. Final cure: 7 days 35±5</li> </ul>
Packaging	Typical Data (Materia RESULTS MAY DIFFER BASED UPO TEMPERATURE, APPLICATION METShelf LifeStorage ConditionsVOC Content Standard ColorsApplication TemperatureService Range Curing RateShore A HardnessAdhesion in Peel (ASTM)	<ul> <li>J and curing conditions @ 73°F (23°C) and 50% R.H.)</li> <li>DN STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.</li> <li>12 months</li> <li>Store at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> <li>40 g/L</li> <li>White, aluminum gray, limestone, dark bronze, buff and stone.</li> <li>40° to 100°F (4°-38°C). Sealant should be installed when joint is at midrange of its anticipated movement.</li> <li>-40° to 170°F (-40°-77°C)</li> <li>Tack-free time: &lt;6 hrs. Final cure: 7 days</li> <li>35±5</li> <li>C-794)</li> <li>20. Aluminum: Meets ASTM C-920. Glass: Meets ASTM C-920</li> </ul>



Coverage	10.1	l oz Cartridge	: Yield	in Linear	feet						
-		Depth	1/4"	3/8"	1/2"						
		1/4"	24.3								
		3/8"	16.2	10.8							
		1/2"	12.1	8.1	6.1						
	Width	3/4"	8.1	5.4	4.0						
	[-	1"			3.0						
		1.25"			2.4						
		1.5"			2.0						
How to Use											
Surface Preparat	othe		ninan	ts. A re	oughene	urface	ind, clean, dry, will also enhan				
Priming	whe	ere sealai	nt wil	l be su	ibjected	vater in	bstrates only r nmersion after formation on p	cure. Consu			
Application	unit ant Plac on v	s at appro should be ce nozzle	oxima e gun e of gi eady	ately 70 ined in un into flow o	0°F (21° to joint v bottom f sealar	emove n joint s he joint ecedin	10°-100°F (4°-3 prior to using. I lot is at mid-po and fill entire ju g the nozzle to	For best per int of its des pint. Keep th	formance, igned expa ne nozzle i	Sikaflex Te ansion and n the seal	extured Seal I contraction ant, continue
Fooling and Finis	shing Too allo	l sealant	to er	nsure f	ull conta	vith joir	t walls and rer aximum thickn				
Removal	Unc	cured mat	llage,	collec			oved solvent. C				
		Avoid ex Maximum Do not ci Avoid co Do not a this can o Use opei When ap Since sy White co Light colu the forma The ultim and propp Do not to Do not u USE OF Do not tu Do not u	posu m dep m expure irrinitact pply 'r cause ned c opplyin stem er ap ool wi se in ANY PROC ABL	re to h bth of s bansion h the p with a when r e bubb cartridg g seal. is moi ends to an yell of initia perform perform perform perform pouct's E ONLO	igh leves sealant in and coresence loohol a moisture ling with ges the s ant, avo sture-co yellow ow sligh al skin. nance o on with ergent o ct with b PROST MOST CONTA	f chlorir t not exaction s curing s other sc por-tran- ne seal e day. ir-entra , permin tily whe f expos caflex T s surfac ap solu ninous/a <b>HE USE</b> <b>RENT P</b> <b>:</b> (/USA. D IN AN TRUCT	pment. t sufficient exposed to u ed to direct gas extured Sealar es properly pre- tions. <b>R MUST ALWA</b> <b>RODUCT DATA</b> SIKA.COM/ OR I (SIKA MATERIA IONS FOR EACI	continuous I inimum dep ed 25% of a s. during cure ition exists f osure to air. ultraviolet ra s fired heati tt depends of pared. ials. YS READ AN SHEET, PRO SY CALLING LLS RELIEVE I SIKA PROI	The second secon	L. nt width. ubstrate as ts prior to nt design V THE WAI SEL AND S CHNICAL S CHNICH S CHNICAL S CHNICAL S CHNICH S CHNICAL S CHNICH S CHNICH S CHNICAL S CHNICH S CHNICH S CHNICH S CHNICAL S	RNINGS AND AFETY DATA SERVICE DE OBLIGATION
	KEEP CONTAINER TIGHT										SIONAL USE ONL
	For further informat actual Safety Data S before using the pro	heets conta	aining	physica	l, ecologio	xicologi	cal and other safety	related data.	Read the curi		
	Prior to each use of a Data Sheet, product ment at 800-933-745 for each Sika produc product use.	label and S 2. Nothing o	afety l	Data She ned in ar	eet which vy Sika ma	vailable o Is relieve	online at http://usa s the user of the ol	sika.com/ or b oligation to rea	y calling Sika d and follow f	's Technical	Service Depar
	SIKA warrants this p the current Product i Buyer's sole remedy EXPRESS OR IMPLI SHALL NOT BE LIAE THE USE OF THIS PR SALE OF SIKA PR CALLING 201-933-86	Data Sheet shall be lin ED SHALL / BLE UNDER CODUCT IN / ODUCTS A 800.	if used nited to APPLY ANY L A MAN RE SU	as dire the pur INCLUI EGAL T NER TO	cted withi chase pri DING ANY HEORY F INFRINGE	If life. Us replacen RANTY ( PECIAL C ANY PATE	er determines suita ent of product exc DF MERCHANTABI R CONSEQUENTIA ENT OR ANY OTHEF	ability of produ lusive of labor LITY OR FITNE AL DAMAGES. INTELLECTU	ct for intende or cost of lab SS FOR A PA SIKA SHALL AL PROPERT	d use and as or. NO OTHEI RTICULAR F NOT BE RES Y RIGHTS HE	Sumes all risks R WARRANTIE PURPOSE. SIK PONSIBLE FO LD BY OTHERS
	Visit our website a			ontor-		of	noorost Sike ante		00-933-SIKA		DE
ka	Regional Informati Sika Corporat 201 Polito Aver Lyndhurst, NJ ( Phone: 800-93	<b>ion</b> nue 07071		<b>Sika Ca</b> 601 Deli Pointe C	<b>nada Inc</b> mar Aven	n of your	nearest Sika sales Sika Mexicana S Carretera Libre O Fracc. Industrial Corregidora, Que	<b>S.A. de C.V.</b> Celaya Km. 8.5 Balvanera		BSI Center.	

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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Product Data Sheet Edition 5.11.2016 Sikasil WS-290

# Sikasil<sup>®</sup> WS-290

SEALANT-WATERPROOFING & RESTORATION INSTITUTE Issued to: Sike Corporation Product: Sikesi" WS-200 C719: Pass \_ Ext:+100% Comp:-50% Substrate: Mortar, Aluminum, Glass C661: Rating 12 Validation Date: 3/28/12 – 3/27/17 No. 312-SiK317 Copyright © 2012 SEALANT VALIDATION www.swrionline.org

Ultra low modulus, neutral cure silicone sealant

Description	Sikasil WS-290 is a one-part, neutral-curing, ultra low-mo durable, flexible building sealant Sikasil WS-290 perform its ultra-low modulus, high extension/compression, recov materials. Sikasil WS-290 accommodates long-term mov particularly well suited for use in Exterior Insulation Finis C-920, Type S, Grade NS, Class 100/50, Use NT, M, G, A Class A; CAN/CGSB-1 9.1 3-M87, AAMA 808.3	s exceptionally well under dynamic conditions due to very properties and strong adhesion to most building ement of +100-50% in properly designed joints and is h Systems (EIFS). Meets the requirements of ASTM
Where to Use	<ul> <li>Sealing expansion and control joints in precast conce</li> <li>As a weatherseal in glass to glass butt joint glazing.</li> <li>As a weatherseal in both conventional glazing and st and heel beads.</li> <li>Exterior Insulation Finish Systems (EIFS) and numer ant.</li> </ul>	tructural glazing* applications, including cap, toe
Advantages	<ul> <li>Unaffected by most atmospheric conditions</li> <li>Non-staining</li> <li>Joint movement +100/-50%</li> <li>Excellent adhesion</li> <li>One-component</li> <li>Excellent gunnability in all temperatures</li> <li>Ultra low Modulus</li> </ul>	
Packaging	10.1 fl.oz. (.300 ml) plastic cartridges, 20 fl.oz. (.592 ml) sat	usages, 2 gal. (7.57 L) pails
	TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTURNATION         Shelf Life       12 months in original unopener         Storage Conditions       Store in unopened containers         VOC Content       29 g/l         Uncured Properties at 77°F (25°C), 50% R.H.         Tool Time (Initial Skin)         Cure Time         Flow, Sag, Slump         Full Adhesion         Tack Free Time	
	Cured Properties after 7 days at 77°F (25°C), 50% I Dynamic Movement Capability (ASTM C-719) Elongation (ASTM D-412) Shore A Hardness (ASTM C-661) Ozone/UV Resistance (weatherometer) Peel Strength (ASTM C-794) Staining, Color Change Staining on Porous Substrates (ASTM C1248) Stress @ 100% (ASTM D-412)	R.H. +100%, -50% 1000% 12 Excellent 20-40 pli none no staining 42 psi (0.29 MPa)



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Nothing contained in any Sika materials relieves the uth Sika product for one year from date of installation to be free trent Product Data Sheet if used as directed within shelf incluser the uth Sika product as set forth in the current Product Data Sheet, product SALL APPLY INCLUDING ANY WARRANTY OF MEL.</li> <li>NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR COD SE OF THIS PRODUCT SARE SUBJECT SIKA'S TERMSAND CONDITIONS OF SUC.</li> </ul>	<ul> <li>Not recommended for horizontal vehicular traffic.</li> <li>Do not apply to surfaces that will be painted as sealant su</li> <li>Do not apply to damp or wet substrates.</li> <li>Lower temperature and humidity will extend tack free and</li> <li>Allow treated wood to age six months before application.</li> <li>Brass and copper may be discolored. 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User determines suitability of pros sole remedy shall be limited to the purchase price or replacement of product exclusive of labes SS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FIT.</li> <li>NOT BE LLABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGE SE OF THIS PRODUCT SARE SUBJECT SIKA'S TERMSAND CONDIT</li></ul>	<ul> <li>Not recommended for horizontal vehicular traffic.</li> <li>Do not apply to surfaces that will be painted as sealant surface will not ho</li> <li>Do not apply to damp or wet substrates.</li> <li>Lower temperature and humidity will extend tack free and cure rates.</li> <li>Allow treated wood to age six months before application.</li> <li>Brass and copper may be discolored. 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Read the current actual Saf t 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions on the product's most c heet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical S t 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings as instructions on the product's most c heet, product label and Safety Data Sheet prior to product use.</li> </ul>



201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537

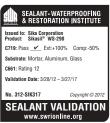
Ŷ RESPONSIBLE CARE



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**B100** 

Product Data Sheet Edition 5.12.2016 Sikasil WS-290 FPS



# Sikasil<sup>®</sup> WS-290 FPS

Ultra low modulus, neutral cure, field pigmentable silicone sealant

Description	non-sag, elastomeric, ne dynamic conditions due t adhesion to most buildin in properly designed join Meets the requirements o Type II, Class A; TT-S-00	eutral cure silicone sealant. Sika to its ultra-low modulus, high exter g materials. Sikasil WS-290 FPS ts and is particularly well suited f of ASTM C-920, Type S, Grade N 01543A, Class A; CAN/CGSB-19					
Where to Use	<ul> <li>As a weatherseal in g</li> <li>As a weatherseal in</li> <li>Exterior Insulation Fisealant.</li> </ul>	nish Systems (EIFS) and numer	panels and metal curtain walls. s, including cap, toe and heel beads ous other areas requiring a high-performance				
Application	<ul> <li>Field pigmentable se</li> <li>Unaffected by most a</li> <li>Non-staining</li> <li>Joint movement +10</li> <li>Excellent adhesion</li> <li>One-component, plu</li> <li>Excellent gunnability</li> <li>Ultra low modulus</li> </ul>	atmospheric conditions )0/-50% s color pack					
Packaging	10.1 fl.oz. (.300 ml) plastic	c cartridges, 20 fl.oz. (.592 ml) sau	isages, 2 gal. (7.57 L) pails				
			EPENDING UPON MIXING METHODS AND EQUIPMENT, AL SITE CONDITIONS AND CURING CONDITIONS.				
	Shelf Life	12 months in original unopene	d cartridges.				
	Storage Conditions	Store in unopened containers	at temperatures lower than 80°F (27°C).				
	Colors	White, Colonial White, Aluminu Custom colors available on rec	um, Limestone, Black, Bronze, Medium Bronze. quest.				
	VOC Content	29 g/L					
	Uncured Properties	at 77°F (25°C), 50% R.H.					
	Tool Time (Initial Ski	n)	30 minutes (higher temperatures and/or humidity will shorten this time)				
	Cure Time		7-14 days				
	Flow, Sag, Slump		no sag				
	Full Adhesion		7-14 days				
	Tack Free Time		50 min.				
	Cured Properties aft	er 7 days at 77°F (25°C), 50% R	<u>х.н.</u>				
	Dynamic Movement	Capability (ASTM C-719)	+100%, -50%				
	Elongation (ASTM D	-412)	1000%				
	Shore A Hardness (A	STM C-661)	12				
	Ozone/UV Resistanc	e (weatherometer)	Excellent				
	Peel Strength (ASTM	l C-794)	20-40 pli				
	Staining, Color Chan	ige (ASTM C-510)	none				
	Staining on Porous S	Substrates (ASTM C-1248)	no staining				
	Stress @ 100% (AS	TM D-412)	42 psi (0.29 MPa)				
	Service Temperature	Range	-80°F to 350°F				
	Tensile Strength (AS	TM D-412)	165 psi (1.14 MPa)				



Coverage	10.1	oz Cartrio	lge: Yield	in Linear	feet		20 0	oz Sausag	e: Yield ir	Linear f	et	l	1 ga	lon: Yiel	d in Linea	r feet	
	[	Depth	1/4"	3/8"	1/2"			)epth	1/4"	3/8"	1/2"	Ī	D	epth	1/4"	3/8"	1/2"
		1/4"	24.3					1/4"	48.1			Ì		1/4"	307.9		
		3/8"	16.2	10.8				3/8"	32.1	21.4				3/8"	205.3	136.8	
		1/2"	12.1	8.1	6.1	]	_	1/2"	24.1	16.0	12.0			1/2"	153.9	102.6	77.0
	Width	3/4"	8.1	5.4	4.0	]	Width	3/4"	16.0	10.7	8.0		Width	3/4"	102.6	68.4	51.3
		1"			3.0	]	<b>_</b>	1"			6.0		>	1"			38.5
		1.25"			2.4	]		1.25"			4.8			1.25"			30.8
		1.5"			2.0	]		1.5"			4.0			1.5"			25.7
How to Use Surface Preparation	coat POF NON	ings tha ROUS S N-POR	at may SUBSTF DUS S	interfe RATES UBSTF	re with – clear RATES	adhesio by mec – for cle	on. chan eani	ical mei ng non	thods to -porous	expos s subst	ny oils, g e a sound rates, us o sealant	d surfa e two	ace f rag	ree of o wipe r	contami	nation a	and lait
Priming	Sika may prop	sil WS requir	-290 F e a pri applica	PS is o mer. Te tion me	design est by ethods	ed to ol applyin . Refer	btair g th	n adhe e seala	sion wi ant and	ithout t d/or pri	he use o mer sea et for Sik	of a p alant o	rime	er; hov binatio	on to co	onfirm	results
	is 1/ non- poly than rod as s mov not I Rea been to c	2 inch gassin ethyler joint w in horiz pring c rement be affe dy to u n comp reate a	(13mn g polyme bond vidth; d contal cor fall, a before cted. se, app leted. conca	n) and olefin o d break o not c on grac and in e cure, oly usin Apply s ave joir	the mi or oper cer tap compre de join joints may c ng profe sealan nt shap	nimum a cell po e to pre ss more t or with designe ause ac essiona t using be and	is 1 olyun e tha n E.I ed fo esth al can	/4 inch rethand t three an 40% I.F.S. V or mov etic iss ulking g sistent	i (6mm e backe -sided 5. Oper Vhen ir ement sues su gun. De , positi	i). To c er rod. adhesi n cell sl nstallin greate uch as o not o ve pres	e 1/2 the ontrol jo If joint d on. Clos nould be g during er than ± ripples i pen proc ssure to y tooling	int de lepth ed ce comp time 25 % in the duct c force	epth doe ell ba pres of l %, b sea sea	, use of s not a acker r ssed 40 arge to a ava alant s ainer u alant ir	closed allow fo od sho 0%. Do empera re of th urface. ntil pre	cell po or back uld be not us ature s be sign Perfor paratic joint. T	lyethyl er rod 25% la e oper wings ificant mance on work ool se
Tooling & Finishing	All jo nozz in th	zle of th e seala	nould b e gun i int, cor	e mas into bot ntinue v	ked to ttom of vith a s	ensure joint an teady fl	nd fill Iow (	entire	joint m ant pree	aking o ceding	l prevent complete the nozz vith soap	e conta zle to	act v avo	with joi id air e	nt sides ntrapm	s. Keep ient. To	o the no
		Not inte Sealan clean. ( Do not Not inte Not rec Do not Do not Lower 1 Allow tr Brass a	ended f t may t Contac apply t ended f omme apply f apply f emper reated and cop	for imn be app to Techn when s for strunded for to surfato dam to dam to	nersior lied be nical S substra ictural or horiz aces th p or w and hu to age ay be	n. low free ervice f te temp glazing zontal v hat will b et subs midity v six mor discolor	ezin for n pera vehic be p trate will e nths red.	g temp nore in tures a cular tra ainted es. extend before Test a	perature format are belo affic. as sea tack fro applic pply pr	es if su ion. ow -20 Ilant su ee and cation. ior to a	rethane : ibstrates °F or abo urface wi cure rat applicatio mpatibilit	s are o ove 1 ill not tes. on.	com 30°	pletel <u>y</u> F. d pain	y dry, fr	ost fre	e and
INS SHE PAF TO REP KEEP For fr actua befor Data ment for ea SIKA the c Buye EXPF	TRUCI EET WI READ NT PRC CONTAIN urther in Safety e using to each Sheet, p at 800-5 ach Sika warrani urrent P r's sole RESS OI	FIONS ( HICH A IT AT 80 AND F( DDUCT ER TIGHTI formati v Data Sh the prod use of a product I 933-7452 a product ts this pr roduct B remedy s R IMPLIE	DN THE RE AVA 00.933.7 DLLOW DATA S Y CLOSE on and a eets cor duct. In o ny Sika p abel and Nothing t as set i roduct fo cata Shee shall be i D SHAL	PROE AILABL 7452 NC 7452 NC 74	DUCT'S E ONLI DTHING VARNIN PROD UT OF RE egarding physica emergen the user Data Sha ned in ar the curre ear from d as direco o the pur INCLUD	MOST NE AT I CONTA GS ANI UCT LA ACHOFCH I transpo I, ecologi cy, call C must alv eet which by Sika m ent Produ date of in the with chase pro JING ANY	CUR HTTH AINE D IN: BEL IILDRE rtatic iccal, t HEM vays a are a ateria ict Da nstall in shi ice on ( WAI	RENT P://USA D IN AN STRUC AND S N.NOTFC m, hand oxicolog TREC at read and available als relieved ation to elf life. U replace RRANTY	PRODU .SIKA.C NY SIKA TIONS AFETY RINTERN ling, sto jical and 1-800-4: I follow t t, product be free f ser dete ment of f O F MEF	JCT DA COM/ C A MATE FOR E. DATA S IAL CONS rage and other sa 24-9300, he warning thetro of the ct label s rom mai rom mai rom couct cCHANT	WAYS RE TA SHEE R BY CA RIALS RI ACH SIKK SHEET P UMPTION.FC d disposal fafety relate Internatio ings and in usa.sika.cc e obligatio and Safety nufacturin, uitability o exclusive o ABILITY O WTIAL DAM	ET, PR ALLING ELIEV A PRC RIOR RIOR OR INDU I of che ad data onal 700 hstruct om to re o Data s g defee of prod of labo R FITN	CODU G SI /ES DDU TO JSTRI/ emic: Rea 3-527 ions by c: add al Shee cts a luct f r or o VESS	UCT L/ KA'S 1 THE US CT AS PRODU AL USE O al produ ad the cu 7-3887. on the p alling Si nd follov t prior to mor inten cost of la FOR A	ABEL A FECHNIC SER OF SET FC JCT US NLY.FOR P lots, use urrent ac: broduct's ka's Tecl w the wal o produc et the te ded use e ubor. NO	ND SA CAL SE THE O DRTH IN SE. ROFESSI rrs shout tual Safe most cu hnical Safe t use. echnical and assu OTHER N	FETY I ERVICE BLIGAT N THE ( DNAL USE Id refer to the propertion properti Imes all WARRAI RPOSE.
THE U SALE	JSE OF OF SIK/ our we	THIS PRO A PRODU bsite at	DDUCT II CTS ARE usa.sik	N A MAN SUBJEC	NER TO T SIKA'S	INFRINGI	E ON	ANY PAT	ENT OR	ANY OT	HER INTEL ABLE AT H	LECTU	JAL I JSA.S	PROPER SIKA.CON	RTY RIGH	ITS HELI	DBYOTH 201-933

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Fracc. Industrial Balvane Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





Product Data Sheet Edition 5.13.2016 Sikasil WS-295

# Sikasil<sup>®</sup> WS-295

SEALANT- WATERPROOFING & RESTORATION INSTITUTE Issued to: Sila Corporation Product: Silasai" WS-295 C719: Pass 🖌 Ext:s50% Comp::50% Substrate: Mortar, Aluminum, Glass C661: Rating 25 Validation Date: 4/3/12 – 4/2/17 No. 412-SIK417 Capyright © 2012

SEALANT VALIDATION

Neutral cure, weather sealing silicone sealant

Description	Sikasil-WS 295 sealant is a one part, neutral cure for use in on a wide variety of materials. Meets the requirements of AS NT, M, G, A, O; TT-S-00230C, Type II, Class A; CAN/CGSB AAMA 805.2, AAMA 808.3	TM C-920, Type S, Grade NS, Class 50, Use
Where to Use	<ul> <li>Sikasil WS-295 silicone sealant has been specifically design</li> <li>As a weatherseal in both conventional glazing and structure heel beads</li> <li>As a weatherseal in glass to glass butt joint glazing</li> <li>Sealing expansion and control joints in precast concrete p</li> <li>Perimeter sealing of doors, windows and other building control stiffeners to building panels</li> <li>Excellent for use in unitized curtain wall systems</li> </ul>	aral glazing* applications, including cap, toe and banels and metal curtain walls.
Advantages	<ul> <li>Versatile medium modulus</li> <li>Unaffected by most atmospheric conditions</li> <li>Non-staining</li> <li>Joint movement ±50%</li> <li>Excellent adhesion</li> <li>One-component</li> <li>Excellent gunnability in all temperatures</li> </ul>	
Packaging	10.0 fl.oz. (295 ml) cartridge, 20 fl.oz. (600 ml) sausage	
	Typical Data	
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPERTEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL S Shelf Life 12 months in original unopened co	ITE CONDITIONS AND CURING CONDITIONS.
	Storage Conditions Store in unopened containers at to	emperatures lower than 80°F (27°C).
	Colors White, Colonial White, Aluminum,	Limestone, Black, Bronze, Medium Bronze
	VOC Content 37 g/L	
	Uncured Properties at 77°F (25°C), 50% R.H.	
	Tool/Work Time (Initial Skin)	20-30 minutes
	Cure Time (ASTM C-679)	7-14 days
	Flow, Sag, Slump (ASTM C-639)	no sag
	Full Adhesion (ASTM C-679)	7-14 days
	Tack Free Time (ASTM C-679)	50 min.
	Cured Properties after 7 days at 77°F (25°C), 50% R.H.	
	Dynamic Movement Capability (ASTM C-719)	+/-50%
	Elongation (ASTM D-412)	700%
	Shore A Hardness (ASTM C-661)	25
	Ozone/UV Resistance (ASTM D-1149)	Excellent
	Peel Strength (ASTM C-794) on aluminum, glass and concrete	30 pli
	Staining, Color Change (ASTM C-510)	None
	Staining on Porous Substrates (ASTM C-1248)	No staining
	Stress at 100% (ASTM D-412)	55 psi (0.38 MPa)
	Service Temperature Range	-80°F to 350°F
	Tensile Strength (ASTM D-412)	200 psi (1.38 MPa)
	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST A RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT D	



Coverage	10.1	oz Cartrio	dge: Yield	in Linear	feet	1	20 0	oz Sausag	e: Yield ir	n Linear fe	eet	
	[	Depth	1/4"	3/8"	1/2"	]	[	Depth	1/4"	3/8"	1/2"	
		1/4"	24.3					1/4"	48.1			
		3/8"	16.2	10.8	ļ			3/8"	32.1	21.4		
	÷	1/2"	12.1	8.1	6.1		문	1/2"	24.1	16.0	12.0	
	Width	3/4"	8.1	5.4	4.0		Width	3/4"	16.0	10.7	8.0	
		1"			3.0			1"			6.0	
		1.25" 1.5"			2.4 2.0			1.25" 1.5"			4.8 4.0	
How to Use Surface Preparation	coat POF laita NOI	tings that ROUS & nce. N-POR(	at may SUBST OUS S	interfe RATES UBSTF	re with S – clea RATES	adhesio an by m – for cl	on. Iech eani	anical r	nethod -porou	ls to ex s subsi	pose a trates, ι	greases or incompatible sealers, paints sound surface free of contamination and use two rag wipe method using xylene o
Priming	Sika may prop	asil WS requir	-295 is e a prii applica	desig mer. Te tion me	ned to est by a ethods	obtain applying	adh g the to T	esion v e seala echnic	vithout	the us /or prir	se of a   ner sea	alant application. primer; however, certain substrates alant combination to confirm results an imers Sikasil 2100 primer and contact
Application	widt dep ylen rod, 25% use ing g	th at tin th is 1/2 use po larger open c gun. Do sistent,	ne of in 2 inch o gassir olyethy than jo chan	istallati (13mm Ig poly lene be oint wi in hor pen pr /e pres	ion. Th olefin o ond bre dth; do izontal oduct o ssure to	e depth the min or open eaker ta not co on grae contain o force	n of imu cel ape mpr de ju er u sea	the sea m is 1/ l polyur to prevo ress mo oints of ntil pre lant int	alant sl 4 inch rethand rent thr ore tha r with E paratic o the jo	hould k (6mm) e back ree-sid n 40% E.I.F.S. on work pint. To	be 1/2 t . To col er rod. ed adh . Open Ready < has b ool seal	aximum of ±25% movement of joint he width of the joint. The maximum ntrol joint depth, use closed cell polyet If joint depth does not allow for backer esion. Closed cell backer rod should b cell should be compressed 40%. Do r / to use, apply using professional cault een completed. Apply sealant using ant to create a concave joint shape an apy water or other liquids when tooling
Removal	Foll		ent ma									sealant from substrate and equipment cured material can only ne removed
		Do not Not inte Sealan clean. ( Do not Not rec Do not Do not Lower Allow ti Brass a	allow sended a t may b Contact apply to comme apply to apply to apply to temper reated and cop	sealant for imn be app to Tech when s nded f nded f nded f to subs to subs to dam ature a wood f oper m	t to cornersion lied be nical S substra or strue or horiz aces th strates p or we and hu to age ay be	n. low free ervice f te temp ctural g zontal v hat will t that ble et subs midity v six mor discoloo	onta ezin for r pera lazin vehic be p eed strate will e nths red.	act with ag temp nore in itures a ng app cular tr bainted oil, pla es. extend before Test a	curing peratur format ire belo lication affic. as sea sticized tack fr applic pply pr	polyun es if su ion. ow -20 ns alant su rs or so ee and cation. ior to a	rethane ubstrate °F or al urface v olvent. I cure ra applicat	e sealants during cure. es are completely dry, frost free and bove 130°F. will not hold paint. ates.
INS SH PA TO	IOR TO STRUCT EET W RTMEN READ	D EACH TIONS ( HICH A IT AT 80 AND F(	USE C ON THE RE AVA 00.933.7 OLLOW	OF ANY E PROE AILABL 7452 NG	SIKA DUCT'S E ONLI DTHING	PRODUC MOST NE AT I CONTA	CT, CUF HTTI AINE D IN	THE US RENT P://USA D IN AN STRUC	ER MU PRODU .SIKA.( IY SIKA TIONS	IST AL JCT DA COM/ O A MATE FOR E/	WAYS F TA SHE OR BY C RIALS I ACH SII	READ AND FOLLOW THE WARNINGS AN EET, PRODUCT LABEL AND SAFETY DA SALLING SIKA'S TECHNICAL SERVICE D RELIEVES THE USER OF THE OBLIGATIC KA PRODUCT AS SET FORTH IN THE CU PRIOR TO PRODUCT USE.
appil and a tions recov and All s: Priov Data Depp instr LIMI techu use FOR FOR	formation ication ar applied u , actual s mmenda mmenda purpose ales of S r to each Sheet, 1 artment ruction fc TED WA nical pro and assu DTHER W POSE.SI THE USI	n provide nd use of i nder norr site condit tions or ir before pr ika produ use of al product i at 800-93 or each S ARRANT (ARRANT (ARRANT (ARRANT)	d by Sika Sika productions and indicond internations and struction struction occeeding tot(s) are abel and 33-7452. ika prod Y: Sika von the currisks. But TESEXPI LNOTBE FRODUCT	Corpora lucts, is g tions in a o ther fa s related subject product, d Materia Nothing uct as se warrants urrent Te yer's sol RESSOF ELIABLE CTINAM	tion ("Sik jiven in g ccordance ctors out to its pro- to its pro- to its cur- the user al Safety g contain et forth in- this pro- cchnical l e remeder RIMPLIEL UNDERA ANNER	a") conce cod faith b se with Sik side of Sil ducts, no oducts. T fication of cent terms must alw Data She ned in an othe curre duct for t Data She y shall be DSHALLA NYLEGA	erning based ka's ir ka's c r shal he us f the us f the us f the us f the us <b>r shal</b> <b>r shal <b>shal</b> <b>r shal</b> <b>r shal</b> <b></b></b>	Sika pro don Sika' nstruction control arr ll any legg ser of the product(s l condition read and which are ka mater echnical year from used as ted to th Y INCLUI EORYFO	ducts, ind s current s. In pra- e such tha al relation Sika pro ). Sika rens follow th available ials relie Data Shun n date o directed e purcha DING AN RSPECIA	cluding bi experier ctice, the at Sika a siship be c duct(s) m serves t e which a e online wes the eet, prod f installa I within s se price YWARRA LORCO	ut not limi nce and kr difference issumes r reated by nust test thare availa ngs and in at <u>www.</u> user of t luct label tion to b shelf life. or replac NTY OFF NSEQUE	L CONSUMPTION • FOR INDUSTRIAL USE ONLY ted to, any recommendations and advice relating to nowledge of its products when properly stored, hand es in materials, substrates, storage and handling cor no liability for the provision of such information, advi y or arise from the provision of such information, advi he product(s) for suitability for the intended applicat o change the properties of its products without not ble at <u>www.sikausa.com</u> or by calling 800-933-74 nstructions on the product's most current Techni <u>sikausa.com</u> or by calling Sika's Technical Serv the obligation to read and follow the warnings a and Material Safety Data Sheet prior to product u e free from manufacturing defects and to meet i USer determines suitability of product for intenor ement of product exclusive of labor or cost of lat MERCHANTABILITY OR FITNESS FOR APARTICUL INTIALDAMAGES. SIKA SHALLNOTBERESPONSIB TELLECTUAL PROPERTY RIGHTS HELDBY OTHEF 1-800-933-SIKA NATIONWIDE
(R)	ional In Sika Co 201 Pol Lyndhu		on and S on ue 7071	Sales Co	enters. I Sika Ca	<b>nada Inc</b> mar Aven Claire	:. nue	on of you	Sika Carre	Mexicar etera Lib	na S.A. o	ce, contact your regional center. de C.V. a Km. 8.5

Product Data Sheet Edition 5.13.2016 Sikasil WS-295 FPS

# Sikasil<sup>®</sup> WS-295 FPS



Neutral cure, field pigmentable silicone sealant

Description	tomeric, neutral cure silic of materials. Meets the re	cone sealant for use in most con equirements of ASTM C-920, Ty	eed, one component plus color pack, non-sag elas- mon weatherproofing applications on a wide variety rpe S, Grade NS, Class 50, Use NT, M, G, A, O; TT- MA 802.3 Type II, AAMA 803.3, AAMA 805.2, AAMA
Where to Use	Sikasil-WS 295 FPS silic	one sealant has been specifical	ly designed for:
			s including gap, toe and heel beads
		lass to glass butt joint glazing. d control joints in precast concre	ato panels and motal
	curtain walls.	d control joints in precast concre	
	<ul> <li>Perimeter sealing of d</li> </ul>	loors, windows and other buildir	ig components.
	<ul> <li>Adhering stiffeners to</li> </ul>		
Advantages	<ul> <li>Excellent for use in un</li> <li>One-part plus color part</li> </ul>	nitized curtain wall systems.	
Auvanages	<ul> <li>Unaffected by most at</li> </ul>		
	<ul> <li>Non-staining</li> </ul>		
	<ul> <li>Joint movement ±50%</li> <li>Excellent adhesion</li> </ul>	D	
	<ul> <li>Excellent adhesion</li> <li>Excellent gunnability i</li> </ul>	n all temperatures	
Packaging		ne color packs sold separately.	
		···· ···· p-···· ··· ··p-····.	
	Typical Data		
			DEPENDING UPON MIXING METHODS AND EQUIPMENT, IAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life	12 months in original unopene	ed cartridges.
	Storage Conditions	Store in unopened containers	at temperatures lower than 80°F (27°C).
	Colors	White, Colonial White, Alumin Custom colors available on re	um, Limestone, Black, Bronze, Medium Bronze. quest.
	VOC Content	37 g/l	
	Uncured Properties a	at 77°F (25°C), 50% R.H.	
	Tool/Work Time (Initi	al Skin)	20-30 minutes
	Cure Time (ASTM C-	679)	7-14 days
	Flow, Sag, Slump (AS	STM C-639)	no sag
	Full Adhesion (ASTN	1 C-679)	7-14 days
	Tack Free Time (AST	M C-679)	50 min.
	Cured Properties after	<u>er 7 days at 77°F (25°C), 50% l</u>	<u>R.H.</u>
	Dynamic Movement	Capability (ASTM C-719)	+/-50%
	Elongation (ASTM D-	-412)	700%
	Shore A Hardness (A	STM C-661)	25
	Ozone/UV Resistance	e (ASTM D-1149)	Excellent
	Peel Strength (ASTM on aluminum, glass a		30 pli
	Staining, Color Chan		None
		Substrates (ASTM C-1248)	No staining
	Stress at 100% (AST	· · · · ·	55 psi (0.38 MPa)
			-80°F to 350°F
	Service Temperature		
	Service Temperature Tensile Strength (AS	•	200 psi (1.38 MPa)



Coverage	1 ga	llon: Yiel	l in Linea	r feet					
	[	Depth	1/4"	3/8"	1/2"				
		1/4"	307.9						
		3/8"	205.3	136.8					
		1/2"	153.9	102.6	77.0				
	Width	3/4"	102.6	68.4	51.3				
	>	1"			38.5				
		1.25"			30.8				
		1.5"			25.7				
How to Use									
Mixing	Cut	open S	ikasil®	color p	ak and	into pail. Mi	x using a slow spe	ed drill (400	-600 rpm) and a conventional s
	anti	mixing	paddle	to disp	erse the		no more then three		eing sure to scrape down the si
Surface Preparation							nd and free of any	oils, greases	s or incompatible sealers, paint
					re with S – clea		I methods to expo	se a sound	surface free of contamination
	laita	nce.							
	an a	approve	ed com	mercia	l solve		to evaporate prio		o rag wipe method using xylene application. Strictly follow solv
Priming	Sika	asil WS	-295 F	PS is	designe	obtain adh	esion without the	use of a pri	imer; however, certain substra
	prop Tecl	bosed a	applica Service	tion m for ac	ethods Iditiona	fer to Techi prmation.	nical Data Sheet	for primers	ombination to confirm results a Sikasil Primer-2100 and con
Application	The	numbe	er of joi	nts and	d the jo	idth should	be designed for a r	maximum o	f ±25% movement of joint widt nt. The maximum depth is 1/2 i
	(13r	nm) ar	id the r	ninimu	m is 1/	ch (6mm). To	control joint dept	h, use close	ed cell polyethylene, non-gass
									/ for backer rod, use polyethyle
	widt	h; do r	not con	press	more f	40%. Open			d should be 25% larger than j 40%. Do not use open cell ro
			-	-	t or wit				
	Rea	idy to u	se, app	oly usir Annly	ng profe sealant	onal caulking	gun. Do not open	product co	ntainer until preparation work sealant into the joint. Tool seal
	to c	reate a	conca	ve join	it shape	d maximum	adhesion. Dry to	oling is rec	commended. DO NOT use so
					hen too		h h t - h		
Limitations							h solvent during c h curing polyureth		nts during cure.
		Not inte	ended	for imr	nersior		01 7		C C
						reezing ten		rates are c	ompletely dry, frost free and
		Do not	apply	when s	substra	mperatures	are below -20°F of	or above 13	80°F.
						I glazing ap al vehicular			
		Do not	apply	to surfa	aces th	ill be painte	d as sealant surfa		nold paint.
						bleed oll, pl lbstrates.	asticizers or solve	ent.	
		Lower	temper	ature a	and hu	ty will extend	d tack free and cu	re rates.	
							e application. apply prior to app	lication	
		Test se	nsitive	subst	rates, s	as mirror ba	ckings, for compa	atibility befo	ore use.
						<u>v</u>	ade joint or with E		ND FOLLOW THE WARNINGS A
									DUCT LABEL AND SAFETY DA
									SIKA'S TECHNICAL SERVICE I
									DUCT AS SET FORTH IN THE CU
									O PRODUCT USE.
									TRIAL USE ONLY. FOR PROFESSIONAL USE C
actu befo	al Safety re using	/ Data Sł j the pro	eets cor duct. In d	ntaining case of e	physical emergen	ogical, toxicol	ogical and other safety at 1-800-424-9300, Inte	related data. ernational 703-	
Data	Sheet,	product	abel and	I Safety	Data She	hich are availab	le online at http://usa.	sika.com/ or b	ons on the product's most current Pro y calling Sika's Technical Service Dep
for e		a produc					eves the user of the ob eet, product label and		d and follow the warnings and instruc heet prior to
the c	urrent F	Product [	Data She	et if used	d as direo	ithin shelf life.	User determines suita	bility of produ	is and to meet the technical propertie ict for intended use and assumes all ri or cost of labor. NO OTHER WARRAN
EXP	RESS O	R IMPLIE	D SHAL	L APPL)	INCLUE	ANY WARRAN	Y OF MERCHANTABI	ITY OR FITNE	ESS FOR A PARTICULAR PURPOSE. S SIKA SHALL NOT BE RESPONSIBLE
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CAL	LING 20	1-933-88 ebsite at	00.						00-933-SIKA NATIONWIDE
	ional In	formati	on and S	Sales C				office, contac	ct your regional center.
va		orporati lito Aven			Sika Ca 601 Delr		Sika Mexicana S Carretera Libre C		
	Lyndhu	rst, NJ 0 800-933	7071		Pointe C Quebec		Fracc. Industrial E Corregidora, Que	Balvanera	
		1-933-6			Phone: 5	97-2610	C.P. 76920		RESPONSIBLE CARE CONCOMMENTATION SUITAINAMENT CONCOMMENTATION SUITAINA
					Fax: 514	-2792	Phone: 52 442 23	385800	Sika and Sikasil are registered trademark

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#### Product Data Sheet Edition 5.4.2011 Sika Silbridge-300

Sika<sup>®</sup> Silbridge-300

Pre-formed, elastomeric silicone profile

Description	ally bonded to	Sika Silbridge-300 products are extruded ultra low modulus elastomeric silicone profile that are usu- ally bonded to substrates using Sikasil WS-295 sealant as an adhesive. Sika Silbridge-300 comes in a variety of standard shapes, colors and sizes and is successfully used in various applications.										usu- nes in						
Where to Use	including but • Expansion • Window p • Roofing se • Fillet bead • EIFS syste	Sika Silbridge-300 extruded profiles are specifically designed for numerous applications including but not limited to: • Expansion joint seals (new & remedial construction) • Window perimeter joint seals • Roofing seals • Fillet beads, coping joints and window seals (custom design) • EIFS systems renovation • Metail curtain wall																
Advantages	<ul> <li>Ease of in</li> <li>Color fast</li> <li>Wide oper</li> <li>Non corros</li> <li>Resistant</li> <li>Capable o</li> <li>Reduces s</li> <li>Rapid cure</li> </ul>	<ul> <li>High tear resistance</li> <li>Ease of installation</li> <li>Color fast formulation</li> <li>Wide operational temperature range</li> <li>Non corrosive and corrosion resistant</li> <li>Resistant to ultraviolet exposure and weathering</li> <li>Capable of sealing high movement joints</li> <li>Reduces stress at bond-line making it well suited for soft and sensitive substrates such as EIFS</li> <li>Rapid cure of thin adhesive layer allows for early movement of substrates</li> <li>Economical alternative to cutting out existing failed sealant</li> </ul>																
Surface Finis		Standard profiles have a matte surface. Coarse and fine textures to match building substrates a also available on a special order basis.										а						
Packages	Standard th	ickne	ess ap	prox	imate	ely 2 r	nm.											
	Extrusion Width (in.)	rusion Width (in.) 1 1.5 2 2.5 3 3.5 4 4.5 5 5.5 6 7 8 9 10 11 12									12							
	Roll Length (ft.)	100	Roll Length (ft.)         100								100	100	100	100	100	50	50	50

#### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

TEMI ERATORE, ATTEIOATIC		E CONDITIONS AND CONING CONDITIONS.
Hardness, Shore A (A	STM D-2240)	25 ± -5
Tensile Strength (AS	TM D-412)	425 psi (2.93 MPa)
Tear Strength (ASTM	D-624) (Die B)	70 lb/in + (12.2 N/mm +)
Elongation at Break (	ASTM D-412)	950% +
Joint Movement Capa	ability (ASTM C-1518-02)	200% Elongation
		75% Compression
<b>Operational Tempera</b>	ture	-60°F to 300°F (-50°F to 150°C)
Colors	White, Black, Limestone, Alumir Bronze, and Medium Bronze. C	um Gray, Colonial White, and ustom colors available upon request.
UV Resistance	Unaffected	
Ozone Resistance	Unaffected	
Radiation	Unaffected	
Tear Propagation (AS	STM C-1518-02)	Pass
		Movement Class: 200% E
		Tear Class: PT (Knotty Tear)



How To Use Surface Preparation	Porous surfaces should be cleaned with dry, oil free compressed air. Grinding or abrasion may be necessary to remove materials that may interfere with the sealant adhesive. If the substrate is cleaned with pressurized water, use caution to prevent water from entering the structure through the open joint. Ensure that all cleaning agents are completely removed and allow the substrate to adequately dry before applying the Sikasil WS-295 and the Sika Silbridge-300 pro- file. Make sure to follow sealant adhesion guidelines of Sikasil WS-295 product data sheet. Non porous surfaces should be cleaned with an appropriate solvent using the two-cloth method.
Application	Apply a bead of Sikasil WS-295 in a straight line near the outside edge to be covered by Sika Silbridge-300. Allow enough space for the sealant adhesive to squeeze out to the edge of the extrusion and then stop. The bead should be approximately 1/8" to 1/4" in diameter depending on the uniformity of the substrate. Non porous surfaces such as glass or aluminum require less sealant adhesive, porous substrates such as grout or EIFS require more. Next, unroll the appropriate length of Sika Silbridge-300 strip and place it uniformly spaced over the joint to be sealed. To ensure uniform appearance, a flat piece of styro-foam can be used to press the extrusion firmly into place. If the application is on a smooth surface, a roller may be used to ensure a uniform wet-out of Sika Silbridge-300 along with the Sikasil WS-295. Clean or tool-off any excess sealant adhesive from the edges of the extrusion and substrate. Trim ends and terminate with a bead of sealant. Always apply horizontal joints before vertical joints. At intersections simply overlap the vertical Sika Silbridge-300 strip over the horizontal and ensure a proper seal by applying enough sealant adhesive.
	Sika Silbridge-300
	Masking Tape Sikasil W-295
	Joint design for failed
l imitations	<ul> <li>Sika Silbridge-300 profile should not be used under the following conditions</li> <li>Below grade or below water line applications</li> <li>Joints where physical abrasion and abuse may occur, such as traffic joint</li> <li>In association with building materials that bleed oils, plasticizers or other material.</li> <li>Do not coat with non silicone based coatings.</li> <li>Should not be bonded with low modulus silicone sealant.</li> </ul>
Caution	For Sikasil W-295 Material Safety Data Sheets are available upon request from Sika Corporation. Similar informa- tion for solvents and other chemicals used with Sika products should be obtained from your suppliers. When solvents are used, proper safety precautions must be observed.
Clean Up	Uncured material can be removed with approved solvent. Cured material can only be removed mechanically. For spillage, collect, absorb, and dispose of in accordance with current, applicable local, state, and federal regulations.
	PRIOR TO EACH USE OF ANY SIKA PRODUCT. THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
For fi	CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE O urther information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to al Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sh re using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.
Data ment for ea	to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Prod Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Dep (at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruc ach Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to uct use.
the ci Buye EXPF SHAL THE C SALE	warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties urrent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all ri ry's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANT RESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. S LL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE I USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHI E OF SIKA PRODUCT SARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OF LING 201-933-8800.
R Visit	our website at usa.sika.com         1-800-933-SIKA NATIONWIDE           ional Information and Sales Centers. For the location of your nearest Sika sales office contact your regional center.
L L F	Sika Corporation 201 Polito Avenue yndhurst, NJ 07071 Phone: 800-933-7452 =ax: 201-933-6225Sika Canada Inc. 601 Delmar Avenue Pointe Claire Ulebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Frace. Industrial Balvanera Corregidora, Queretaro C.P. 76920Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Frace. Industrial Balvanera Corregidora, Queretaro Phone: 52 442 2385800 Sika and Sikagard are registered trademark

# Sikasil<sup>®</sup>-GP / GP High Temp. Red

General Purpose Acetoxy Cure Silicone

Technical Product Data (typical values) \*Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

		Sikasil <sup>®</sup> -GP	Sikasil <sup>®</sup> -GP Hi Temp Red
Chemical Base		1-C silicone	1-C silicone
Color		Multiple	Red
Cure mechanism		Moisture	Moisture
Cure type		Acetoxy	Acetoxy
Density (uncured)		8.18 lb/gal	8.8 lb./gal.
VOC		36 g/L	36 g/L
Non-sag properties	(ASTM C-639)	Non-sag	Non-sag
Skin Time	(MNA Method)	20 minutes	20 minutes
Tack free time <sup>2</sup>	(ASTM D-679)	30 minutes	30 minutes
Curing speed	(MNA Method)	1/8 inch 24 hours	1/8 inch 24 hours
Shrinkage		nil	nil
Shore A-hardness	(ASTM C-661)	25 +/-5	25 +/-5
Tensile strength	(ASTM D-412)	220 psi	350 psi
Elongation at break	(ASTM D-412)	350 %	400 %
Peel Strength	(ASTM C-794)	20	) pli
Movement capability	(ASTM C-719)	+/	-25
Application Temperature <sup>1</sup>	product only	-35° to 140°F	- (-32 to 40°C)
Service temperature	permanent	- 40° to 275°F (-40° to 135°C)	- 80° to 500°F (-62° to 260°C)
	intermittent	325°F (163°C)	550°F (287°C)
Weathering Resistance		Excellent	Excellent
Shelf life (storage below 90°F (32°C))		24 months	24 months

<sup>1)</sup> Substrate and Air Temperature must be between 15° - 120°F (-26 - 49°C). See "Application" Section for details.

#### <sup>2)</sup> 77°F (25°C) / 50% r.h. **Description**

Sikasil®-GP products are general purpose, one-component, non-sag, elastomeric, 100% RTV acetoxy silicone sealants. Meets the requirements of ASTM C-920, Type S, Grade NS, Class 25, Use NT, G, A, O. Recognized under UL QMFZ2, ANSI/NSF Standard 51 for direct food contact and California Air Resources Board 2003 requirements for Volatile Organic Compound content. Sikasil®-GP maintains elastomeric properties up to 275° F continuous, 325°F intermittent, and Sikasil<sup>®</sup>-GP HT (High Temperature) red up to 500°F continuous, 550°F intermittent. Sikasil®-GP HT Red also meets federal specification TT-S-005143A, Class A, and MIL-A-46106.

#### **Product Benefits**

- One-component ready to use
- Excellent for dynamic joint movement & dissimilar materials, Joint movement
- ±25%
- Excellent adhesion, bonds to many substrates without priming
- Fast Cure Move assembled or sealed
- parts quickly
- Wide service temperature / durability
- Superior gunning & tooling
- High temperature red for temperature resistance up to 550°F
- Contains Anti-microbial additive for mold resistance

#### Areas of Application

- Sealing & glazing of windows, doors and skylights
- Conventional glazing and Storefronts
  Kitchen and bath countertops, Sanitary
- seals
- HVAC, Plumbing, Roofing
- Sealing trucks, trailers and RVs
- Marine applications
- Appliance Assembly

#### **Typical Substrates**

 Glass, aluminum, tile, fiberglass, plastic, ceramic, wood, steel and painted metals

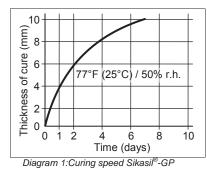


#### Coverage

Cartridge: Approximately 12.2 linear ft. (3.7 lin. m) for  $\frac{1}{2} \times \frac{1}{4}$  in (13 x 6 mm) bead.

#### **Cure Mechanism**

Sikasil<sup>®</sup>-GP cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly (see diagram below).



#### **Chemical Resistance**

Sikasil<sup>®</sup>-GP is resistant to UV radiation, fresh water, seawater and proprietary aqueous cleaning agents; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; no resistance to organic acids, concentrated mineral acids, caustic solutions and solvents. The above information is offered for general guidance only. Advice on specific applications will be given on request. Contact Technical Service at (tsmh@sika-corp.com).

#### Method of Application

Surface preparation

The substrate must be clean, dry, frost free, sound and free of any oils, greases or incompatible sealers, paints or coatings that may interfere with adhesion.

**POROUS SUBSTRATES** - clean by mechanical methods to expose a sound surface free of contamination.

#### NON-POROUS SUBSTRATES - for

cleaning non-porous substrates, use two cloth cleaning method using xylene, isopropyl alcohol or an approved, clean, pure non-diluted industrial grade solvent. Allow solvent to evaporate completely prior to sealant application. Strictly follow solvent manufacturer's warnings and instructions for use.

**PRIMING** Sikasil<sup>®</sup>-GP is designed to obtain adhesion without the use of a primer; however, certain substrates may require a primer. Test by applying the

primer sealant and/or sealant combination to confirm results and proposed application methods. Refer to Technical Data Sheet for primers Sika® Aktivator<sup>®</sup>-205. Sikasil<sup>®</sup>-2100. or Sikasil<sup>®</sup>-2300 available at www.sikausa.com or contact Technical Service for additional information at (tsmh@sika-corp.com).

#### Application

In all cases, make sure the joint design is correct. Proper joint design minimizes stresses on the sealant. Use masking tape if desired for areas adjacent to the joint to be sealed to prevent surface contamination. Apply sealant to dry, clean surfaces. An air operated or hand operated cartridge gun may be used. Do not break cartridge seal until just before Surfaces should be dried before use the sealant is applied. Normally sealant skins in 10 minutes, dries to touch in 1 hour, bonds in 24 hours and fully cures in 7 days dependant on temperature and humidity.

This product is suitable for bulk dispensing straight from drums or pails by means of a pneumatic or hydraulic pump system. For recommendations on selecting and setting up a suitable pump system please contact our Technical Service Department at (tsmh@sikacorp.com).

#### **Expansion Joint**

Apply using caulking gun, dispensing equipment or trowel. Use sufficient quantity of adhesive to one or both substrates to provide designed contact area.

#### Adhesive Joint

Apply using professional caulking gun. Do not open product container until preparation work has been completed. Apply sealant using consistent, positive pressure to force sealant into the joint. Tool sealant to create a concave joint shape and ensure maximum adhesion. Dry tooling is recommended.

#### Tooling and finishing

Tool joint, if necessary, and remove masking tape. Tooling should be completed in one continuous stroke. Tool immediately after sealant is applied and before a skin begins to form. Dry tool - do not use soap, water or oil as a tooling aid. Remove masking tape immediately after tooling is completed. Complete Tooling of product within 5 minutes of sealant application.

Further information available at: www.sikausa.com

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#### Removal

Uncured Sikasil®-GP may be removed from tools and equipment with solvents such as isopropyl alcohol or xylene if cleaned before sealant has begun to cure. Strictly follow solvent manufacturer's instructions for use and warning statements. Once cured, the only be material can removed mechanically. Hands and exposed skin should be washed with soap and water immediately after use. Do not use solvents on skin!

#### Overpainting

Sikasil<sup>®</sup>-GP cannot be overpainted.

#### Limitations

- Certain substrates may require a primer.
- Do not allow sealant to come in contact with solvent during cure.
- Not intended for long term water immersion.
- Sealant may be applied below freezing temperatures if substrates are completely dry, frost free and clean.
- Maximum depth of sealant must not exceed 1/2 inch; minimum depth 1/8 inch.
- Do not apply to surfaces that will be painted.
- Do not apply to substrates that bleed oil, plasticizers or solvent.
- May stain porous substrates such as natural stone. Test before use.Do not apply to damp or wet
- Do not apply to surfaces sensitive to
- corrosion by acetic acid or vapors.
- Lower temperature and humidity will extend tack free and cure rates.
- Allow treated wood to age 6 months before application.
- Not intended for structural glazing
- Not for use in sealing insulating glass
- Test sensitive substrates, such as
- mirror backings for compatibility before use.
- Translucent product does not contain anti microbial additive.

WARNING: IRRITANT, SENSITIZER. Contains Ethyltriacetoxysilane (CAS: 17689-77-9) and Methyltriacetoxysilane (CAS: 4253-34-3). Direct eye contact may cause irritation. May cause skin and respiratory irritation. Mav cause drowsiness. May cause vomiting. When heated, product can form formaldehyde vapors. Formaldehyde is a potential cancer hazard, a known skin and respiratory sensitizer, and an irritant to the eyes, nose, throat, skin and digestive system. c





HMIS	
Health	2
Flammability	1
Reactivity	0
Personal Protection	С

#### FIRST AID

Inhalation – Remove to fresh air. Eyes -Rinse with tepid water for 15 minutes. Call physician. Skin – Wash thoroughly with soap and tepid water. Remove contaminated clothing. Ingestion – Do not induce vomiting. Dilute with water. Call physician.

#### **Further Information**

Copies of the following publications are available on our website <u>www.sikausa.com</u> or by contacting (tsmh@sika-corp.com).

- Material Safety Data Sheet
- Product Data Sheet

#### In case of emergency call: Chemtrec: 800-424-9300 International: 703-527-3887

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- KEEP CONTAINER TIGHTLY CLOSED
- FOR PROFESSIONAL USE ONLY

#### **Packaging Information**

Cartridge	10 fl. oz. (295ml)
Drum	52 gal.

#### Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

#### Handling and Storage

Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.

#### **Clean Up**

Observe personal protective equipment recommendations described in MSDS. Disposal of collected product, residues, and cleanup materials may be governmentally regulated. Observe all applicable local, state and federal waste management regulations. Ventilate area. Contain spill. Evacuate unprotected personnel from hazard area. Wipe up and contain for disposal. Cover with absorbent, place in approved drum. Clean area as appropriate since spilled materials, even in small quantities, may present a slip hazard.

#### **Limited Material Warranty**

Sika warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE **RESPONSIBLE FOR THE USE OF THIS** PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY **RIGHTS HELD BY OTHERS.** 

#### Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling

conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at <u>www.sikausa.com</u> or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at <u>www.sikausa.com</u>. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at: www.sikausa.com

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PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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## Sikasil<sup>®</sup>-N Plus US Neutral Cure Silicone Assembly Sealant

Technical Product Data (typical values)

Chemical Base		1-C silicone		
		Pigmented	Translucent	
Cure mechanism		Moisture	Moisture	
Cure type		Oxime	Oxime	
Density (uncured)		11.6 lbs./gal.	8.4 lb/gal	
VOC		37 g/L (0.31 lb./gal.)	36 g/L, 0.30 lbs/gal	
Non-sag properties	(ASTM C-639)	Non-sag	Non-sag	
Slump		Nil	Nil	
Skin Time	(MNA Method)	15 minutes	20 minutes	
Tack free time <sup>2</sup>	(ASTM D-679)	30 minutes	30 minutes	
Extrusion Rate g/min (ASTM C-1183 mod	ified) 1/8" orifice @ 90 psi	230	360	
Curing speed	(MNA Method)	1/8 inch 24 hours	1/8 inch 24 hours	
Shrinkage		Nil	Nil	
Shore A-hardness	(ASTM C-661)	30 ± 5	15 ±5	
Tensile strength psi (mpa)	(ASTM D-412)	300 psi (2.07)	190 psi (1.31)	
Elongation at break	(ASTM D-412)	430%	430 %	
Bond durability - glass/ aluminum / concre	te (ASTM-C793)	± 25 %	± 25 %	
Movement capability	(ASTM C-719)	± 25 %	± 25 %	
Application Temperature <sup>1</sup>	product only	-35° to 140	°F (-32 to 40°C)	
Service temperature		- 80° to 350°F (-62° to 176°C)		
Weathering Resistance		Ex	cellent	
Shelf life (storage below 90°F (32°C))	Cartridge and Unipac	12 months	12 months	
	Drum and Pail	12 months	12 months	

<sup>1</sup> Substrate and Air Temperature must be between 40° - 105°F (5 - 40°C). See "Application" Section for details. <sup>2)</sup> 77°F (25°C) / 50% r.h.

#### Description

Sikasil<sup>®</sup>-N Plus US is a general purpose, one-component, non-sag, elastomeric, 100% RTV neutral cure silicone sealant. Meets the requirements of ASTM C-920, Type S, Grade NS, Class 25, Use NT, T, M, G, A, O; TT-S-00230C, Type II, Class A; TT-S-001543A, Class A; CAN/CGSB-19.13-M87, AAMA 802.3 Type II, AAMA 803.3, AAMA 805.2, AAMA 808.3 and California Air Resources Board 2003 requirements for Volatile Organic Compound content.

#### **Product Benefits**

- Extremely long service life
- Excellent flexibility for dynamic joint movement
- Bonds to most substrates without
- priming
  - Ready to use, no mixing required
  - AAMA Certified component for window
  - backbedding / glazing
- All season ease of application
- Fungicide additive for mildew
- resistance

#### Areas of Application

- Window and door fabrication
- Conventional glazing
- Back bedding and cap, toe and heel beads
- Perimeter sealing of windows, doors and skylights
- Expansion and control joints
- HVAC, White goods assembly
- Kitchen and bath countertops/solid surfaces, Sanitary Seals
   Marine cabins
- Truck/trailer/auto/RV

#### **Typical Substrates**

- Glass, aluminum, tile, fiberglass, plastic, ceramic, masonry, concrete, brick and wood

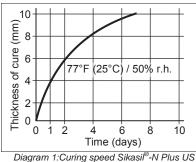


#### Coverage

Cartridge: Approximately 12.2 linear ft. (3.7 lin. m) for  $\frac{1}{2} \times \frac{1}{4}$  in (13 x 6 mm) bead.

#### Cure Mechanism

Sikasil<sup>®</sup>-N Plus US cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly (see diagram below).



Chemical Resistance

Sikasil<sup>®</sup>-N Plus US is resistant to UV radiation, fresh water, seawater and proprietary aqueous cleaning agents; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; no resistance to organic acids, concentrated mineral acids, caustic solutions and solvents. The above information is offered for general guidance only. Advice on specific applications will be given on request. Contact Technical Service at (tsmh@sika-corp.com).

#### Method of Application Surface preparation

The substrate must be clean, dry, frost free, sound and free of any oils, greases or incompatible sealers, paints or coatings that may interfere with adhesion.

**POROUS SUBSTRATES** – clean by mechanical methods to expose a sound surface free of contamination.

**NON-POROUS SUBSTRATES** – for cleaning non-porous substrates, use two cloth cleaning method using isopropyl alcohol, xylene or an approved, clean, pure non-diluted industrial grade solvent. Allow solvent to evaporate completely prior to sealant application. Strictly follow solvent manufacturer's instructions for safe handling.

**PRIMING** Sikasil<sup>®</sup>-N Plus US is designed to obtain adhesion without the use of a primer; however, certain substrates may require a primer. Test by applying the

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sealant and/or primer sealant combination to confirm results and proposed application methods. Refer to Product Data Sheet for primers Sikasil<sup>®</sup> 2100, or Sikasil<sup>®</sup> 2300 available at www.sikausa.com or by contacting Technical Service for additional information and recommendations at (tsmh@sika-corp.com).

#### Application

In all cases, make sure the joint design is correct. Proper joint design minimizes stresses on the sealant. Use masking tape if desired for areas adjacent to the joint to be sealed to prevent surface contamination. Apply sealant to dry, clean surfaces. An air operated or hand operated cartridge gun may be used. Do not break cartridge seal until just before use. Surfaces should be dried before the sealant is applied. Normally sealant skins in 8 minutes, dries to touch in 1 hour, and bonds in 24 hours.

This product is suitable for bulk dispensing straight from drums or pails by means of a pneumatic or hydraulic pump system. For recommendations on selecting and setting up a suitable pump system please contact our Technical Service Department at (tsmh@sikacorp.com).

#### **Expansion Joint**

Apply using professional caulking gun. Do not open product container until preparation work has been completed. Apply sealant using consistent, positive pressure to force sealant into the joint. Tool sealant to create a concave joint shape and ensure maximum adhesion. Dry tooling is recommended.

#### Adhesive Joint

Apply using professional caulking gun, dispensing equipment or trowel. Use sufficient quantity of adhesive to one or both substrates to provide designed contact area. Surfaces may be moved up to one hour after application without loss of adhesive strength.

#### Tooling and finishing

Tool joint, if necessary, and remove masking tape. Tooling should be completed in one continuous stroke. Tool immediately after sealant is applied and before a skin begins to form. Dry tool -DO NOT use soap, water or oil as a tooling aid. Remove masking tape immediately after tooling is completed. Complete tooling of product within 5 minutes of sealant application. Removal

Uncured sealant may be removed from tools and equipment with solvents such as isopropyl alcohol or xylene, if cleaned before sealant has begun to cure. Strictly follow solvent manufacturer's instructions for use and warning statements. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed with soap and water immediately after use. Do not use solvents on skin!

#### Overpainting

Sikasil<sup>®</sup>-N Plus US cannot be overpainted.

#### Limitations

- Do not allow sealant to come in contact with solvent during cure.
- Do not allow sealant to come in contact with curing polyurethane sealants during cure.
- Not intended for immersion.
- Not intended for structural glazing.
- Sealant may be applied below freezing temperatures if substrates are completely dry, frost free and clean. Contact Technical Service for more information.
- Not recommended for horizontal traffic.Not recommended for absorptive
- surfaces such as natural stone, particularly limestone or marble where staining may occur. Test before use. - Do not apply to surfaces that will be
- painted. Do not apply to substrates that bleed
- oil, plasticizers or solvent. - Do not apply to damp or wet
- substrates. - Lower temperature and humidity will
- extend tack free and cure rates.
- Allow treated wood to age six months before application.
- Brass and copper may be discolored. Test prior to application.
- Test sensitive substrates, such as
- mirror backings for compatibility before use.

WARNING: IRRITANT, SENSITIZER. Contains Methyl ethyl ketoxime (CAS: 96-29-7), Oximino Silane (Trade Secret). Direct eye contact may cause irritation. Eye contact may cause conjunctivitis, corneal damage, or severe chemical burns. May cause skin irritation and sensitization. May be absorbed through the skin. May cause irritation to system. respiratory May cause drowsiness. May be harmful if swallowed. heated silicones can form If formaldehyde vapors. Formaldehyde is a potential cancer hazard, a known skin and respiratory sensitizer, and an irritant





to the eyes, nose, throat, skin, and digestive system. Product contains oximes, possible skin sensitizers.

HMIS	
Health	*1
Flammability	1
Reactivity	0
Personal Protection	С

#### **FIRST AID**

In case of eye contact, flush thoroughly with water for at least 15 minutes. In case of skin contact, remove from skin and flush with water for 15 minutes. wash contaminated Remove and clothing. If inhalation causes physical discomfort, remove to fresh air. Get medical attention if irritation develops or ill effcts persist. Treat according to persons condition and specifics of exposure.

#### Further Information

Copies of the following publications are available website on our www.sikausa.com or by contacting (tsmh@sika-corp.com)

- Material Safety Data Sheet

- Product Data Sheet

#### In case of emergency call: Chemtrec: 800-424-9300 International: 703-527-3887

For further information and advice transportation, handling, regarding storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- KEEP CONTAINER TIGHTLY CLOSED
- FOR PROFESSIONAL USE ONLY

#### **Packaging Information**

Cartridge	10 fl. oz. (295ml)
Pail	4.5 gal (17 L) in a 5 gal pail
Drum	52 gal (197 L) in 55 gal drum
Value Basis	

All technical data stated on this Product Legal Notes/Disclaimer Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

#### Handling and Storage

Use with adequate ventilation. Product evolves Methyl ethyl ketoxime (MEKO) and methanol when exposed to water or humid air. Provide adequate ventilation to control MEKO within exposure guidelines. Keep container closed and store away from water or moisture or oxidizing materials.

Storage: When stored in the original, unopened containers at or below 90°F (32°C), shelf life is one year. A product skin may form in pails and drums, remove prior to use.

#### Clean Up

Observe personal protective equipment recommendations described in MSDS. Disposal of collected product, residues, and cleanup materials may be governmentally regulated. Observe all applicable local, state and federal waste management regulations. Wipe up and contain for disposal. Final cleaning may require use of steam, solvents, or detergents.

#### Limited Material Warranty

Manufacturer / Distributor warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY OR ΔΝΥ OTHER PATENT INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.

ΔII information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikausa.com or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at www.sikausa.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at: www.sikausa.com

Sika Corporation Industry Products 30800 Stephenson Highway Madison Heights, MI 48071 MADE IN USA



3 /



# SikaHyflex<sup>®</sup>-150 LM

One part, low modulus, hybrid sealant

12.1

8.1

1/2"

1"

1.25"

1.5"

4tpi 3/4"

8.1

5.4

6.1

4.0

3.0

2.4

2.0

Description		SikaHyflex®-150 LM is a premium-grade, high movement, fast curing, one component, non-sag, elastomeric, hybrid sealant. Meets ASTM C-920, Type S, Grade NS, Class 50, use NT, M, A, G, O												
Where to Use	<ul> <li>Windot</li> <li>Expar</li> <li>Curtai</li> <li>For ap</li> </ul>	<ul> <li>Window Perimeter</li> <li>Expansion joints</li> </ul>												
Advantages	<ul> <li>Multi-s</li> <li>Super</li> <li>Color</li> <li>Can b</li> <li>Very b</li> </ul>	<ul> <li>Multi-substrate adhesion</li> <li>Superior UV resistance and weathering</li> <li>Color retention – white stays white</li> <li>Can be over-painted soon after application (once skin has formed)</li> <li>Very low VOC &lt; 12g/L</li> </ul>												
Packaging	10.1 fl. oz 20 fl. oz.		•	age										
	RESULT	S MAY D RATURE, ife: e Condi ation Te e range: ree Tim ent cap at 100% tion (A A Hardr nd colo on in p	e (AST bability (ASTI bability (ASTI STM D- bess (A br changeel (AS	ASED U ATION N URCE (ASTM A D-412 412): STM C6 ge (AST TM C75	PON ST. IETHOD (C719): (): (): (): (): (): (): (): (): (): (	ATIS S, TE	TICAL VA	RIATIO	1 year 40°F (5 40° - 1	5°C) - 8( - 75°F 00°F. S nge of it 170°F %	UPON NDITIC	MIXING MI DNS AND C 7°C), 50% e using t should b	6 RH. Conc be installed to novement	DEQUIPMENT, IDITIONS. dition Material when joint is at
Coverage	10.1 oz Cartri	dge: Yield	in Linear	feet		20 (	oz Sausag	e: Yield i	n Linear fe	eet	1			
	Depth	1/4"	3/8"	1/2"	1	[	Depth	1/4"	3/8"	1/2"	1			
	1/4"	24.3	İ		ĺ		1/4"	48.1	İ	İ	1			
	3/8"	16.2	10.8				3/8"	32.1	21.4	İ	1			



PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

1/2"

3/4"

1"

1.25"

1.5"

Width

24.1

16.0

16.0

10.7

12.0

8.0

6.0

4.8

4.0

	How To Use	
	Surface Preparation	The substrate must be clean, dry, frost free, sound and free of any oils, greases or incompatible sealers, paints or coatings that may interfere with adhesion.
		<b>POROUS SUBSTRATES</b> – clean by mechanical methods to expose a sound surface free of contamination and laitance.
		<b>NON-POROUS SUBSTRATES</b> – for cleaning non-porous substrates, use two rag wipe method using al- cohol, xylene or an approved commercial solvent. Allow solvent to evaporate prior to sealant application.
	Priming	SikaHyflex <sup>®</sup> -150 LM is designed to obtain adhesion without the use of a primer; however, certain substrates may require a primer. Test by applying the sealant and/or primer sealant combination to confirm results and proposed application methods. *In the situation where primer is needed on porous surfaces use Sika Primer 429. For non-porous surfaces contact Technical Services for proper recommendation.
	Application	The number of joints and the joint width should be designed for a maximum of ±25% movement of joint width at time of installation. The depth of the sealant should be 1/2 the width of the joint. The maximum depth is 1/2 inch (13mm) and the minimum is 1/4 inch (6mm). To control joint depth, use closed cell polyethylene, non-gassing polyolefin or open cell polyurethane backer rod. If joint depth does not allow for backer rod, use polyethylene bond breaker tape to prevent three-sided adhesion. Closed cell backer rod should be 25% larger than joint width; do not compress more than 40%. Open cell should be compressed 40%. Do not use open cell rod in horizontal on grade joints or with E.I.F.S. Ready to use, apply using professional caulking gun. Do not open product container until preparation work has been completed. Apply sealant using consistent, positive pressure to force sealant into the joint. Tool sealant to create a concave joint shape and achieve maximum adhesion. Dry tooling is recommended. DO NOT use soapy water or other liquids when tooling.
	Limitations	<ul> <li>SikaHyflex<sup>®</sup>-150 LM can be overpainted after a skin forms on the sealant</li> <li>When overcoating with water, oil and rubber based paints, compatibility and adhesion testing is essential. Rigid paints and coatings may lose adhesion to elastomeric sealants due to their inability to accommodate joint movement.</li> <li>Maximum depth of sealant must not exceed 1/2 in.; minimum depth is 1/4 in.</li> <li>Do not cure in the presence of curing silicone or polyurethane sealants.</li> <li>Use opened cartridges and uni-pac sausages the same day.</li> <li>When applying sealant, avoid air-entrapment.</li> <li>Since system is moisture-cured, permit sufficient exposure to air.</li> <li>Light colors can yellow if exposed to direct gas fired heating element.</li> <li>Do not use in contact with bituminous/asphaltic materials.</li> <li>Not intended for immersion.</li> <li>Not intended for structural glazing applications</li> <li>Sealant may be applied below freezing temperatures if substrates are completely dry, frost free and clean. Contact Technical Service for more information.</li> <li>Do not apply when substrate temperatures are below -20°F or above 130°F.</li> <li>Not recommended for horizontal vehicular traffic.</li> <li>Do not apply to damp or wet substrates.</li> <li>Lower temperature and humidity will extend tack free and cure rates.</li> <li>Allow treated wood to age six months before application.</li> <li>The ultimate performance of SikaHyflex-150 LM depends on good joint design and proper application with joint surfaces properly prepared.</li> </ul>
7	Regional Sika Q Quint Rest Rest Rest Rest Rest Rest Rest Res	OCEACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND CITONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET, PRODUCT LABEL ONLINE AT HITTP://USA.SIKA.COW/ OR BY CALLING SIKA'S TECHNICAL SERVICE DENTATA 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION DAND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURDOUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.         NRR TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.         Information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the ty Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet go the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.         h use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet prior to a.         nts this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Teremoduct as set forth in the current Product AC

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Product Data Sheet

Edition 1.21.2016 Identification no. Sika® Loadflex®-524 EZ

### Sika<sup>®</sup> Loadflex<sup>®</sup>-524 EZ

Two Component, Semi Rigid, Polyurea Control Joint Filler

Description			9 -524 EZ is If-levelling			iced, two-co	omponent, o	quick-setting, semi-rigid,
Where to Use	pr ■ Ty su ■ Sil	eformed co pically inst bject to loa ka® Loadfle	ontrol and co alled in facil ad-bearing c	onstruction lities such a conditions ir is also usec	joints. s warehous wolving wea	es and indu ar and impa	strial plants ict.	rior, horizontal saw cuts or , where such joints are is that have experienced
Advantages	<ul> <li>M:</li> <li>73</li> <li>Cu</li> <li>Ha</li> <li>Pri<ul> <li>un</li> <li>Tw</li> <li>Im</li> <li>Se</li> </ul></li></ul>	aterial can °F (23°C). ures at tem ard, load-be ovides ever oder traffic. vo compone oproved cor eals joints f	peratures d earing filler n load trans ents, easy t nsistency to	off smooth a own to -13° designed to fer across fl o use, 1:1 mi allow easie ng dirt, dus	as early as 5 F (-25°C). Withstand loor joints, t X ratio.	industrial tr hereby prot g and reduc	raffic. .ecting joint	4 hours after placement at edges from breaking dowr of equipment.
Packaging	10 US	S gallon un	it (Part A 5	gal, Part B S	ā gal)			
	N T S		ETHODS A HODS, AC	ND EQUIP TUAL SITE 12 mon Store b	MENT, TE CONDITIO	MPERATU INS AND C	RE, APPLI URING CO ed packaging	NS DEPENDING UPON CATION METHODS, NDITIONS. g. duct between 65 and
		Colors	Yield				on unit. Sik depth of the	a® Loadflex®-524 EZ 9 joint.
		Cove	erage for	10 gallo	n kit at jo	oint widt	h of:	
	ľ	Joint	Depth	1/8 in. (3mm)		1/4 in. (6mm)		
		inches	mm	ft	m	ft	m	
	-	1	25	1,540	497	770	248	
		11/4	32	1,232	397	616	199	
	F	44/2	20	4 0 0 7	1 224	E42	1 400	
		11/2	38	1,027	331	513	166	
	-	11/2 13/4 2	38 44 51	1,027 880 770	331 284 248	513 440 385	166 142 124	

Note: The above chart is a theoretical guide only. Allowance must be made for surface profile, wastage, etc.



Properties at 23°C (73°F) and 50% R.H.       Disc:       Disc:       Disc:         Working time       Disc:       Disc:       Disc:       Disc:         Working time       Disc:       Disc:       Disc:       Disc:         Working time       Disc:       Disc:       Disc:       Disc:       Disc:         Working time       Disc:       Disc: <th></th> <th>Mix Ratio</th> <th>A:B = 1:1 by volume</th> <th></th>		Mix Ratio	A:B = 1:1 by volume	
Working time       10 sec.         How how the sector strength ASTM 0538       652 ppi         Density       238 ppi         Absorbtion ASTM 0570       0.33% bits         Short Bond strength       >238 ppi         Density       Part A       110 g/mL         Part A       110 g/mL       Part A       110 g/mL         Part A       100 g/mL       Part A       110 g/mL         Part A       100 g/mL       Part A       110 g/mL         Part A       100 g/mL       Part A       110 g/mL         Part A       100 g/mL       Part A       100 g/mL         Part A       100 g/mL       Part A       Part A         Sufface Preparation       • Part B       Part A       Part A         * Sufface Preparation       • Sufface Market A       Part A       Part A       Part A         Sufface Preparation       • Sufface Market A       Part A       Part A       Part A       Part A       Part A       Part A       Part A       Part A       Part A		•		
Module of Elasticity ASTM D638       6525 pci Elongation at Break ASTM D638       6525 pci Elongation at Break ASTM D638         Bond strength       >.218 pci Absorbtion ASTM D570       0.30%         Shore A Hardness ASTM D628       0.03%         Bond strength       >.218 pci Absorbtion ASTM D570       0.30%         Bond strength       >.218 pci Absorbtion ASTM D570       0.30%         Bond strength       Deformation MIL-D 24613 mod. Viscosity       Port A       118 g/mL Bond at 375 FC 237. Fold strength Assorbtion MIL-D 24613 mod. Viscosity         Deformation MIL-D 24613 mod. Viscosity       Fond A 2000-1600 pci Bond at 375 FC 237. Fold strength Assorbtion MIL-D 24613 mod. Viscosity       Fond A 2000-2500 pci Bond at 375 FC 237. Fold strength Assorbtion MIL-D 24613 mod. Viscosity         Product properties are typically assages.thilated index inde				
Tensile strength ASTM 058       652 psi         Dend strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       > 218 psi         Bond strength       Bond strength         Bond strength       Bond stren				
Elongation a Tenedit ASTM 0508         110%           Absorbtion ASTM 0500         0.30%           Shore Al Hardness ASTM 02200         0.37%           Density         Part All         111 g/mL           Part All         110 g/mL           Part All         110 g/mL           Part All         110 g/mL           Part All         100 g/mL           Mixing         Part All to portion at 227 FL (25)           Product properties are typically average, straited function to provide marking to min at 237 FL (25)           Product properties are typically average, straited function to provide marking to min at 237 FL (25)           Product properties are typically average, straited function to provide marking				
Bond strength         > 28 ppi           Short Win STM 0570         0.30%           Short Win Artiness ASTM 0520         30-32           Short B Hardness ASTM 0520         30-32           Bond strength         Pert A         1.11 g/mL           Pert A         1.10 g/mL           Pert A         1.10 g/mL           Pert A         1.10 g/mL           Pert A         1.10 g/mL           Pert A         1.00 g/mL           Pert B         1.00 g/mL      <		5		
Absorbtion <sup>4</sup> STM 0570 0.30% Shore A Hardness ASTM 0220 80-85 Shore A Hardness ASTM 0220 80-85 Shore A Hardness ASTM 0220 80-85 Bensity Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 1100 1600 cps Light raffic 80 model of application Cure time Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 80 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffic 97 model as 9% Part B 1000 1600 cps Light raffer 15 model as 9% Part B 1000 1600 cps Light raffer 15 model as 9% Part B 1000 1600 cps Light raffer 15 seconds D 100 cp		-		
Shore A Hardness ASTEM 02240 Bensity Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A 110 g/mL Part A B		Bond strength	> 218 psi	
Shore A Hardness ASTEM D2240 Bensity Bergenetic Market States (110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 110 g/mL Part B 100 0 FB0 43.9% Cure time Cure		Absorbtion ASTM D570	0.30%	
Density     Part A 110 g/mL     Part A 110 g/mL     Part A 110 g/mL     Part A B 110 g/mL     Part A B 110 g/mL     Part A B 110 g/mL     Part A B 110 g/mL     Part A B 110 g/mL     Part A B 1000-1500 cps     Part A 2000-2500 cps     Part A		Shore D Hardness ASTM D2240	30-32	
Part B       11.0 g/mL         Deformation MiL-D-24613 mod.       Part A + B       11.g/mL         Sufficient Curve time       Part B 1000 ps) 43.93%         Euro time       Part B 1000 ps) 43.93%         Full traffic       By in rafficient 2000 ps)         Full traffic       By in rafficient 2000 ps)         Full traffic       By in rafficient 2000 ps)         Method of Application       The max each component thoroughly before using. Sik@ Loadflex" 524 EZ must be machine mice of dispersed using a 10 to 1100 pinul component purp and 30 clearing in nozzle. Note: Sik@ Loadflex" 524 EZ sets too quickly to allow hand mkmg.         Surface Preparation <ul> <li>Pre-mix each component thoroughly before using. Sik@ Loadflex" 524 EZ must be machine mice displant displa</li></ul>		Shore A Hardness ASTEM D2240	80-85	
Part B       11.0 g/mL         Deformation MiL-D-24613 mod.       Part A + B       11.g/mL         Sufficient Curve time       Part A 2000 2500 cps         Part B 1000 1600 cps       Limit A 2007 2500 cps         Part B 1000 1600 cps       Limit A 2007 2500 cps         Part B 1000 1600 cps       Limit A 217 E (237)         Full traffic       Spring 126 cps         Mixing       - Pre-mix each component thoroughly before using. Sike <sup>2</sup> Loadflex <sup>4</sup> . S24 EZ must be machine mixed () dispensed using a 100 ratio plural component arunn para d30 cells methods.         Surface Preparation       - Pre-mix each component thoroughly before using. Sike <sup>2</sup> Loadflex <sup>4</sup> . S24 EZ must be machine mixed () dispensed using a 100 ratio plural component arunn para d30 cells prevent tool. Prevent bool. Prev		Density	Part A 1.11 g/mL	
Deformation MIL-D-24613 mod. Viscosity         6: 5 MP3 (1000 pc) 14.39 mice           Viscosity         Cure time         Fight A 2000-2500 cps           Light traffic         15 min at 73°F (23°)           Light traffic         15 min at 73°F (23°)           Part A 2000-2500 cps         30 min at 73°F (23°)           Light traffic         15 min at 73°F (23°)           Part A 2000-2500 cps         30 min at 73°F (23°)           Sufface Preparation         • Pre-mix each component thoroughly before using. Sika* Loadflex* - 524 EZ must be machine mixed (dispersed units at 10 traff) plural component pump and 30 element statist mem pozzle. Note: Sika* Loadflex* - 524 EZ must be machine mixed (dispersed units at 10 traff) plural component pump and 30 element statist in pozzle. Note: Sika* Loadflex* - 524 EZ must be machine mixing a dustises saw with diamond blade, with blade slightly wider than the joint to both sides of joint ac eleaned os and basting. If unsusal conditions are present contact Sika Technical Services.           Application         • Dispense Sika* Loadflex* - 524 EZ directly from the static mixing nozzle into both sides of joint cleaning include using a dustises saw with diamond blade, withe cure dir 73°F (23°). Cartridge: Podulut gets in static mixe to 24 hours after placing, when cure dir 73°F (23°). Cartridge: Podulut gets in static mixe at 24 hours after placing, when cure dir 73°F (23°). Cartridge: Podulut gets in static mixe at 24 hours after placing, when cure dir 73°F (23°). Cartridge: Podulut gets in static mixe are 24 hours after placing, when cure dir 73°F (23°). Cartridge: Podulut gets in static mixe are 24 hours after placing, when cure dir 73°F (23°). Cartridge: Podul			Part B 1.10 g/mL	
Viscosity         Part A 2000-2500 cps           Lure time         Part B 1000-1600 cos           Light traffic         19 min at 72 F (23)           Full traffic         19 min at 72 F (23)           It is at 137 F (23)         21 mis at 137 F (23)           It is at 137 F (23)         21 mis at 137 F (23)           It is at 137 F (23)         21 mis at 137 F (23)           Surface Preparation         - Pre-mix each component thoroughly before using, 51ka* Loadflex* -524 EZ must be machine mixed / dispensed using at 10 ratio, plural component pump and 30 element static mixing nozzle. Note Sika* Loadflex* -524 EZ must be dean, sound and drv, Remove all surface contaminants including without limita- and disintegrated materials that might prevent bond. Prefered methods of puint cleaning include using a dustes save with diarond black, with biade silpht wider than the pint so both 31 mis may adjacent joint are cleaned or sand blasting. If unusual conditions are present contact Sika Technical Services.           Application         - Dispense Sika* Loadflex* -524 EZ directly from the static mixing nozzle into joints or cracks until metric wide so far pint as teaky flow of material to eliminate orderapping as this may adjacent joint adjets of tareflex* -524 EZ directly for onte static mixing and adjott on training the sing at 10 mis at a static file file on the relevant (SA 23) or ACI 302 I standards.           Application         - Dispense Sika* Loadflex* -524 EZ directly from the static mixing nozzle into joints are static. Refere to the relevant (SA 23) or ACI 302 I standards.           Application         - Dispense Sika* Loadflex* -524			Part A+B 1.1 g/mL	
Cure time     Parts 18:1000-1600 trps     Light traffic     Spring at 73°F (23°)     Spring at 73°F (23°F)     Spring at 7		Deformation MIL-D-24613 mod.	6.9 NPa (1000 psi) 43.9%	
Cure time     Parts 18:1000-1600 trps     Light traffic     Spring at 73°F (23°)     Spring at 73°F (23°F)     Spring at 7		Viscosity	Part A 2000-2500 cps	
Full traffic       Put traffic       Put signification         Mixing       Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, prevancino, application, using and test methods.         Method of Application       Pre-mix each component throughly before using. Sike* Loadflex* - 524 EZ must be machine mixed / dispensed using a 1 to 1 ratio, plural component pump and 30 element static mixing nozzle. Noz: Sike* Loadflex* - 524 EZ sets too quickly to allow hand mixing.         Surface Preparation       • Surface must be clean, sound and dry. Remove all surface contaminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials that might prevent bood. Prefered methods of joint cleaning include using a dustless saw with diamond Bide, with bide slightly wider than the joints to cracks until the clean sound basening. In unusual contabilitons are present contact Sike leandflex* - 524 EZ incertly from the static mixing nozzle indig site site and particles and present contact Sike leandflex* - 524 EZ incertly from the static mixing nozzle indig site mixer are available from your supplier. If needed.         Limitations       • Or best results, Sike* Loadflex* - 524 EZ isould be site site. Additional static mixers are available from your supplier. If needed.         Limitations       • Or best results, Sike* Loadflex* - 524 EZ isould be installed 120 days or longer after initial con crete placement, when the relevant CS-123 List andrads.         • Substate temperature should not be less than -13*F (25*C) and rising at time of application.			Part B 1000-1600 cps	
Full traffic       Dring at 72F (425)         Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, cuing and test methods.         Method of Application       • Per-mix each component throughly before using. Sike* Loadflex* - 524 EZ must be machine mixed / dispensed using at 10 tratic, plural component pump and 30 element static mixing nozzle. Note: Sike* Loadflex* - 524 EZ sets too quickly to allow hand mixing.         Surface Preparation       • Surface must be clean, sound and dry. Remove all surface contaminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials that might prevent boot. Prefered methods of joint cleant of unit act cleand or sand basting; in unusual continons are present contact. Sike Loadflex* - 524 EZ directly from the static mixing nozzle indical Services.         Application       • Dispense Sika* Loadflex* - 524 EZ directly from the static mixing nozzle indical Services.         Application       • Dispense Sika* Loadflex* - 524 EZ directly from the static mixer save and the site indicate or relation of the adjacent joint dispense of facilitate a stanoth appearance. For best results, shave the over lift between 15 minutes to 24 hours after placing, when cured at 73+ C32-C3. Cartridge: Product gels in static mixer available from your supplier, if needed.         Limitations       • Or best results, Sika* Loadflex* - 524 EZ stould be installed 120 days or longer after initial con crete placement, when the reajority of concrete shinkage has occurred and control joints are static. Refer to the relevant C321 standad		Cure time	Light traffic $15 \text{ min at } 73^\circ \text{F}(23^\circ)$	
Preduct apperties are typically userge, channel under laboratory conditions. Reasonable variations can be expected on on-sted due to local factors, including environment, preparation, application, cung and test methods.         Method of Application Mixing          • Pre-mix each component throughly before using. Sike® Loadflex® -524 EZ must be machine mixing nozzle. Note: Sika® Loadflex® -524 EZ sets too quickly to allow hand mixing.         Surface Preparation          • Surface must be clean, sound and dry. Remove all surface contraminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waves, forelenp particles and isoline grated materials that might prevent bood. Preferred methods of joint cleaning including via dustless saw with diamond blade, with blade slightly wider than the joints or cracks until the entire voil is filled. Maintain a steady flow of material to eliminate over lib between the out of using a dustless saw with a laborable loss should be slightly over libel and shavef level with the adjacent joint edges to facilitate a smooth appearance. For best results, shave the over-fill between the single over libel so that and the particle dust and trained index of 247 EG 23-C). Carindge: Product gels in static mixer a fire 15 seconds. One statict, 247 EG 24 C) and rsing at time of application.         Limitations          • For best results, Sika® Loadflex® -524 EZ isolub be installed 120 days or longer after initial concrete placement, when the majority of concrete shinkage has occurred and control joints are static. Refer to the relevant EG 24 Z should be installed 120 days or longer after initial concrete placement.         Limitations          • For best results, Sika® Loadflex® -524 EJ is a vapor barine after stoth results of normal shaw for the relevant			60 min at -13°F (-25°)	)
Method of Application Mixing <ul> <li>Pre-mix each component thoroughly before using. Sike® Loadflex® -524 EZ must be machine. Note: Sike® Loadflex® -524 EZ must be machine. Note: Sike® Loadflex® -524 EZ must be machine. Note: Sike® Loadflex® -524 EZ must be machine. Note: Sike® Loadflex® -524 EZ sets too quickly to allow hand mixing.</li> </ul> Surface Preparation <ul> <li>Pre-mix each component pump and 30 element static mixing nozzle. Note: Sike® Loadflex® -524 EZ sets too quickly to allow hand mixing.</li> </ul> Surface Dreparation <ul> <li>Surface Mixing Additional Surface most be clean, sound and drv. Remove all surface containing including without limitation contaminants such as dust, grease, curing compounds: impregnations, waxes, foreign particles and plant act cleaned or sand blasting. If unusual contallors are present contact Sike Technical Services.</li> </ul> Application <ul> <li>Dispense Sike® Loadflex® -524 EZ directly from the static mixing nozzle into joints or cracks until the entire woild is filled. Maintain a steady flow of material to eliminate over-fille between 15 minutes to 24 hours after placing, when cured a 174 F (23*C). Carringe: Product gets in static mixer after 15 seconds. Once started, do not stop the extrusion process. Additional static mixers are available from your supplies. If needed.</li> </ul> Limitations <ul> <li>For best results, Sike® Loadflex® -524 EZ is a vagor barring and size as static. Refer to the relevant for AC13021 standards.</li> <li>Substrate temperature should not be less than -376 (25*C) and rsing at time of application.</li></ul>			Full traffic 30 min at 73°F, (23°)	
Method of Application         Pre-mix such component thoroughly before using. Sika* Loadflex*. 524 EZ must be machine mixed / dispensed using at 10 Tratto, plural component pump and 30 element static mixing nozzle. Not: Sika* Loadflex*. 524 EZ stoo quickly to allow hand mixing.           Surface Preparation         • Surface must be clean, sound and dry. Remove alls surface contaminants including without limitation contaminants such as duss; grease, curing compounds, impreparations, waxes, foreign particles and disintegrated materials that might prevent bond. Prefered methods of ploint cleaning include using a dustless saw with diamont black with blade slightly with dust limitate overlapping as this may cause bubbling within the material, ploints should be slightly with filed and showed level with there and the static mixing nozzle into joints or cracks until the event to so and the should are static ploint. Carridge: Product get in static mixer after 15 seconds. Once started, do not stop the extrusion process. Additional static mixers are astatic. Refer to the relevant (SA A231 or AC1 3021 standards.           Unitations         • For best results. Sika* Loadflex* SA EZ should be installed T20 days or longer after initial contred placement. When the material to elimitate overlapping as this may cause bubbling within the material. Joints struct placement. When the material to elimitate overlapping as the struct mixer are astatic. Refer to the relevant (SA A231 or AC1 3021 strandards.           Unitations         • For best results. Sika* Loadflex* SA EZ should be installed T20 days or longer after initial contred placement. How place at plant the ording or under phylomer floating. Contact with the sealing cracks under hydrostatic pressure.           Unitations         • For bestresults. Sika* Loadflex* SA EZ should be conditioned to between 6				
Mixing       • Pre-mik each component throughly before using. Sika* Loadflex* -524 EZ must be machine mixed / dispensed using a it to 1 ratio, plural component pump and 30 element static mixing nozzle. Note: Sika* Loadflex* -524 EZ sets too quickly to allow hand mixing.         Surface Preparation       • Surface must be clean, sound and dy. Remove all surface contaminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles using a dustees saw with diamond blade, with blade slightly wider than the joint so both sides of disintegrated materials that implet prevent bod. Preference methods of learning to company the on sand blasting. If unusual conditions are present contact Sika Technical Services.         Application       • Dispense Sika* Loadflex* - 524 EZ directly from the static mixing nozzle into joints or cracks until the entire void is filled. Maintain a steady flow of material to eliminate overlapping as the coverse in the adjacent joint edges to facilitate a smooth appearance. For best results, shave the over-filled and shave device with the adjacent joint edges to facilitate a smooth appearance. For best results, shave the over-fille between 15 minutes to 24 hours after juncing, when cure dat 73 F (22) C. Lartridge Prevent joint as are static. Refer to the relevant CSA A23 to ACI 302 J standards.         Limitations       • For best results, Sika* Loadflex* -S24 EZ is avapor barrier after cure.         • Not to be used in moving cracks or joints which are designed for or exhibit movement.         • Not to be used in moving cracks or joints which are designed for or exhibit movement.         • Not to be used in moving cracks or joints which are designed for or exhibit movement.         • No				ed
Mixing <ul> <li>Pre-mik each component thoroughly before using. Sika* Loadflex* -524 EZ must be machine mixed / dispensed using a 1 to 1 ratio, juniar component, pump and 30 element static mixing nozzle. Note: Sika* Loadflex* -524 EZ sets too quickly to allow hand mixing.</li> </ul> Surface Preparation <ul> <li>Surface must be clean, sound and dry, Remove all surface contaminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials that might prevent bond. Preferred methods of joint cleaning include using a dustless saw with diamond blade, with buds elightly wider than the joints or cracks until the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the adjacent joint direct botom safter plactang, when cured at 72<sup>17</sup> (22<sup>17</sup>). Cartridge: Product gels in static mixer after 15 seconds. Once stated, do not stop the extrusion process. Additional static mixers are available from your supplie, if needed.</li> <li>Limitations         <ul> <li>For best results, Sika* Loadflex* -524 EZ should be installed 120 days or longer after initial concrete placement, when the majority of concrete shrinkage has occurred and control joints are static. Refer to the relevant CS Ad21 or Ad1201 standards.</li> <li>Sust and address or joint switch are are static pressure.</li> <li>Not too suspline, if avanor barring rate for core.</li> <li>Sixe 1 Loadflex* -524 EZ set state are should be conditioned to between 65 and 86<sup>17</sup> (18 and 30<sup>17</sup>C).</li> <li>Do not thin. Solvents may prevent proper cure.</li></ul></li></ul>		on-site due to local factors, including environme	nt, preparation, application, curing and test methods.	
Mixing <ul> <li>Pre-mik each component thoroughly before using. Sika* Loadflex* -524 EZ must be machine mixed / dispensed using a 1 to 1 ratio, juniar component, pump and 30 element static mixing nozzle. Note: Sika* Loadflex* -524 EZ sets too quickly to allow hand mixing.</li> </ul> Surface Preparation <ul> <li>Surface must be clean, sound and dry, Remove all surface contaminants including without limitation contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials that might prevent bond. Preferred methods of joint cleaning include using a dustless saw with diamond blade, with buds elightly wider than the joints or cracks until the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the entire void is filled. Maintain a steady flow of material to eliminate our-laped livel with the adjacent joint direct botom safter plactang, when cured at 72<sup>17</sup> (22<sup>17</sup>). Cartridge: Product gels in static mixer after 15 seconds. Once stated, do not stop the extrusion process. Additional static mixers are available from your supplie, if needed.</li> <li>Limitations         <ul> <li>For best results, Sika* Loadflex* -524 EZ should be installed 120 days or longer after initial concrete placement, when the majority of concrete shrinkage has occurred and control joints are static. Refer to the relevant CS Ad21 or Ad1201 standards.</li> <li>Sust and address or joint switch are are static pressure.</li> <li>Not too suspline, if avanor barring rate for core.</li> <li>Sixe 1 Loadflex* -524 EZ set state are should be conditioned to between 65 and 86<sup>17</sup> (18 and 30<sup>17</sup>C).</li> <li>Do not thin. Solvents may prevent proper cure.</li></ul></li></ul>	Method of Application			
tion contaminants such as dust, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials that might prevent bood. Preferred methods of joint cleaning include using a dustless saw with diamond blade, with blade slightly wider than the joint so both sides of joint are cleaned or sand blasting. If unusual conditions are present contact Sika Technical Services. Application <ul> <li>Dispense Sika<sup>®</sup> Loadflex<sup>®</sup> -524 EZ directly from the static mixing nozzle into joints or cacks until the entire void is filled. Maintain a steady flow of material to eliminate overlapping as this may cause bubbling within the material, joints should be slightly over filled and shaved level with the adjacent joint edges to facilitate a smooth appearance. For best results, shave the over-fill between 15 minutes to 24 hours after placing, when cured at 73° E (23°C). Cartridge: Product gels in static mixer are available from your supplier, if needed.</li> <li>Limitations</li> <li>For best results, Sika<sup>®</sup> Loadflex<sup>®</sup> -524 EZ should be installed 120 days or longer after initial con crete placement, when the majority of concrete shninkage has occurred and control joints are static. Refer to the relevant CSA At 13 02.1 standards.</li> <li>Substrate temperature should not be less than -13° E (25°C) and rising at time of application. For interior, horizontal use only.</li> <li>For best results, materials should not be less than -13° E (25°C) and rising at time of application. Wort for oscillar gracks under hydrostatic pressure.</li> <li>Not to be used in moving cracks or joints which are designed for or exhibit movement.</li> <li>Not to be used in moving cracks and joint shear designed for or exhibit movement.</li> <li>Not to be used in moving cracks or joints which are designed for or exhibit movement.</li> <li>Not colling cracks under hydrostatic pressure.</li> <li>Sika<sup>®</sup> Loadflex<sup>N</sup> - 524 EX MUST AlWAYNS READ AND FOLLOW THE WARNNOSS AND SFRUCTONS ON THE PRODUCT MOST CURRENT PRODUCT TAS EFET</li></ul>	Mixing n	nixed / dispensed using a 1 to 1 ratio, plural	component pump and 30 element static mixing nozz	le.
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the entire void is filled. Maintain a steady flow of material to eliminate overlapping as this may cause bubbling within the material, joints should be slightly over filled and shaved level with the adjacent joint edges to facilitate a smooth appearance. For best results, shave the over-fill between 15 minutes to 24 hours after placing, when cured at 73°F (23°C). Carringe: Product gels in static mixer after 15 seconds. Once started, do not stop the extrusion process. Additional static mixers are available from your supplier, if needed. Limitations For best results, Sika <sup>®</sup> Loadflex <sup>®</sup> - 524 EZ should be installed 120 days or longer after initial concrete placement, when the majority of concrete shrinkage has occurred and control joints are static. Refer to the relevant CSA A231 or ACI 302 Statandards. Substrate temperature should not be less than -13°F (-25°C) and rising at time of application. For interior, horizontal use only. For best results, materials should be conditioned to between 65 and 86°F (18 and 30°C). Do not thin, Solvents may prevent proper cure. Sika <sup>®</sup> Loadflex <sup>®</sup> - 524 EZ is a vapor barrier after cure. Not for sealing cracks under hydrostatic pressure. Not to be used in moving cracks or joints which are designed for or exhibit movement. Not recommended for use as joint filler under resilient flooring or under polymer flooring. Contact your local Sika Sales Representative or the Technical Service Department for further information. Reference of the State Contact State St	jo	pint are cleaned or sand blasting. If unusua	al conditions are present contact Śika Technical Service	es.
Limitations   For best results, Sika® Loadflex® -524 EZ should be installed 120 days or longer after initial concrete placement, when the majority of concrete shrinkage has occurred and control joints are static. Refer to the relevant CSA A231 or ACI 302.1 standards. Substrate temperature should not be less than -13°F (-25°C) and rising at time of application. For interior, horizontal use only. For best results, materials should be conditioned to between 65 and 86°F (18 and 30°C). Do not thin, Solvents may prevent proper cure. Sika® Loadflex® -524 EZ is a vapor barrier after cure. Not for sealing cracks under hydrostatic pressure. Not for sealing cracks under hydrostatic pressure. Not recommended for use as joint filler under resilient filoring or under polymer flooring. Contact your local Sika Sales Representative or the Technical Service Department for further information. The PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHE WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COW OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARtmet AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ A FOLLOW THE WARNINGS AND DSTRUCTIONS FOR EACH SIKA PRODUCT LAS SET FORTH IN THE CURRENT PRODUC DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LOUD THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT LAS SET FORTH IN THE CURRENT PRODU DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUCT LABEL AND SAFETY DATA SHEET PRODUC	t c a 1! n	he entire void is filled. Maintain a steady fl ause bubbling within the material. Joints sl djacent joint edges to facilitate a smooth a 5 minutes to 24 hours after placing, when c nixer after 15 seconds. Once started, do not	ow of material to eliminate overlapping as this may nould be slightly over filled and shaved level with the appearance. For best results, shave the over-fill betwe cured at 73°F (23°C). Cartridge: Product gels in static	en
<pre>rete placement, when the majority of concrete shrinkage has occurred and control joints are static. Refer to the relevant CSA A231 or ACI 302.1 standards.</pre> <pre>Substrate temperature should not be less than -13*F (-25*C) and rising at time of application.</pre> For best results, materials should be conditioned to between 65 and 86*F (18 and 30*C). Do not thin. Solvents may prevent proper cure. Sika*Loadflex*-654 EZ is a vapor barrier after cure. Not for sealing cracks under hydrostatic pressure. Price To EACH USE OF ANY SikA PRODUCT. THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND STRUCTIONS ON THE PRODUCT SMOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHE WHICH ARE AVAILABLE ONLINE AT HTTP://JSA.SIKA.ACOW/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTIME AT 80033.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OFT HIN THE CURRENT PRODUCT LABEL AND SAFETY DATA SHE For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheet product current excutal Safety Data Sheet product Line case of emergency, call CHEMTERCA 1+800-4224:9300, International 703-527.3887. Or further information and advice regarding transportation, handling, storage and follow the warnings and instruction for each Sheet product is solver product within shell like. Uncereent Product Data Sheet, product lable and Safety Data Sheet whic		/ 11 /		
Image: Struction of the product is most current product Data Sheet, product Label and Safety Data Sheet Partment at 800-933-7452. Nothing containing in any Sika Materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product base for the current Product Data Sheet product base for the current product base for the current product base for the current product base for the current product base for the current product base for the current product base for the current product base for the current product base set of the current product base set of the current product base set of the current product base set of the current product base set of the current product base set of the current product base set of the current product base and product base set of the current product base and product base set of the current product base and product base and product base product base product base product base product base product base product base for the current product base product base and product base proces product base proces.		crete placement, when the majority of co static. Refer to the relevant CSA A23.1 or Substrate temperature should not be less For interior, horizontal use only. For best results, materials should be cond Do not thin. Solvents may prevent proper Sika® Loadflex® -524 EZ is a vapor barrier Not for sealing cracks under hydrostatic p Not to be used in moving cracks or joints Not recommended for use as joint filler u	ncrete shrinkage has occurred and control joints are ACI 302.1 standards. s than -13°F (-25°C) and rising at time of application. ditioned to between 65 and 86°F (18 and 30°C). cure. after cure. iressure. which are designed for or exhibit movement. nder resilient flooring or under polymer flooring. Conta	act
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Image: Containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.         Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.         SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF FIRE/ANATABILITY OR FITNESS FOR A PARTICULAR PULY POSC. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS NEE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.         Image: Comparison 201 Polito Avenue Ling Any Wark and Char Avenue Prior Comparison and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation 201 Polito A				
Ref       Data Sheet, product label and Safety Data Sheet which are available online at http://uša.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.         SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor ncost of labor.No OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATERINT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.         Its to ur website at usa.sika.com       1-800-933-SIKA NATIONWIDE         Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.       Sika Canada Inc.         01 Polito Avenue       01 Polito Avenue       01 Delmar Avenue       Sika Mexicana S.A. de C.V.       Carretera Libre Celaya Km. 8.5       Frace. Industrial Balvanera       Corregidora, Queretaro       Siffor Core Celay Km. 8.5	actual Safety D	ata Sheets containing physical, ecological, toxicologic	al and other safety related data. Read the current actual Safety Data S	
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Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.         Sika Corporation         201 Polito Avenue         Lyndhurst, NJ 07071         Phone: 800-933-7452             Quebec HQR 4A9             Sika Constant your regional center.             Sika Constant your regional center.             Sika Mexicana S.A. de C.V.         Carretera Libre Celaya Km. 8.5         Frace. Industrial Balvanera         Corregidora, Queretaro	the current Pro Buyer's sole re EXPRESS OR I SHALL NOT BE THE USE OF TH SALE OF SIK	duct Data Sheet if used as directed within shelf life. Use medy shall be limited to the purchase price or replacem MPLIED SHALL APPLY INCLUDING ANY WARRANTY C E LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL O IIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATE A PRODUCTS ARE SUBJECT SIKA'S TERMS AND (	er determines suitability of product for intended use and assumes all tent of product exclusive of labor or cost of labor. NO OTHER WARRAN OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. R CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE NT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTH	risks. NTIES SIKA EFOR IERS.
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Fax: 201-933-6225 Phone: 514-697-2610 C.P. 76920 Rex: 514-694-2792 Phone: 52 442 2385800	Regional Info Sika Corp 201 Polito Lyndhurst Phone: 80	Sika Canada Inc.           Avenue         601 Delmar Avenue           NJ 07071         Pointe Claire           09-933-7452         Quebec H9R 4A9           933-6225         Phone: 514-697-2610	Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920	)

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### Sikadur<sup>®</sup> 51 NS Flexible epoxy control-joint sealer/adhesive

Description	Sikadur <sup>®</sup> 51 NS is a 2-component, non-sagging, solvent-free, moisture-tolerant, flexible epoxy control joint sealer and adhesive.
Where to Use	<ul> <li>Use to fill vertical and overhead non-moving, saw-cut construction control joints and cracks.</li> <li>Use as a flexible adhesive.</li> </ul>
Advantages	<ul> <li>2 to 1 ratio ensures easy mixing, easy handling.</li> <li>An adhesive with excellent flexibility.</li> <li>Excellent durability.</li> <li>Conforms to ACI 302.1R (4.10-Joint Materials).</li> <li>Shock-absorbent cure.</li> <li>Prevents deterioration of control-joint edges.</li> <li>Use as a security sealant.</li> </ul>
Coverage	1 gal. will yield 231 cu. in. or will fill 102 ft. of 1/8 in. wide x 1.5 in. deep joint.
Packaging	3 gallon units.

#### Typical Data Material and curing conditions @ 73°F (23°C) and 50% R.H.

	D UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, N METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
Shelf Life	2 years in original, unopened containers
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-85° F (18°- 29°C) before using.
Color	Concrete gray
Mixing Ratio	Component 'A': Component 'B' = 2:1 by volume.
Viscosity	Comp. 'A'         300,000-350,000 cps           Comp. 'B'         29,000-31,000 cps           Mixed         Non-sag paste
Pot Life	1-1.5 hours
Tack-Free Time	7-8 hours.
Elc	STM D-638)nsile Strength650 psi (3.9 MPa)ingation at Break80%dulus of Elasticity1,800 psi (12.4 MPa)nsile stress at % elongation2.5%50 psi (0.35 MPa)5%90 psi (0.62 MPa)10%160 psi (1.10 MPa)
Tear Resistance (AST	<b>M D-624)</b> 14 days 110 lb./in. (19.4 N/mm)
Hardness (ASTM D-2	<b>240) 28 days</b> (Shore A) 75-80 (Shore D) 30-40



How to Use Surface Preparation	Substrate must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials, etc., by mechanica means (i.e. sandblasting, high pressure water blasting).
Mixing	<b>Pre-mix each component.</b> It is critical to accurately proportion 2 parts Component 'A' and 1 part Componen 'B' by volume into a clean pail or appropriately sized mixing container. Mix thoroughly for 3 minutes with a Sik Paddle on a low-speed (400- 600 rpm) drill until uniform in color. Mix only that quantity which can be use within pot life.
Application	For vertical or overhead applications, gun Sikadur <sup>®</sup> 51 NS into construction/control joints and cracks with caulking gun, pressure extruder, or other suitable methods. Be sure to maintain steady pressure and stead flow of material, filling entire joint in a single application. Take care to eliminate overlapping as this may caus bubbling within the material. For use as a flexible adhesive, consult Sika Technical Service at 800-933-SIKA
Limitations	<ul> <li>Do not thin Sikadur® 51 NS. Addition of solvents may prevent proper cure.</li> <li>Substrate temperature should be 40°F (4°C) minimum and rising.</li> <li>For best results, materials should be maintained between 65°-85°F (18°-29°C) during application.</li> <li>Do not apply through standing water.</li> <li>Minimum age of concrete is 28 days.</li> <li>Materials are vapor barriers after cure.</li> <li>Concrete or masonry must be tested for water-vapor transmission prior to application.</li> <li>Not designed for use under constant immersion in water or other liquids.</li> <li>Do not use in expansion (moving) joints.</li> <li>For application in non-moving joints only.</li> <li>The ultimate performance of Sikadur® 51 NS depends upon many factors, [i.e., proper joint design, thermally stable areas, (concrete slab), etc.].</li> <li>For applications other than sealing of control or construction joints, consult Sika Technical Service at 800-933-SIKA.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>
INS SH PAI TO RE KEEP For f	IOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN ITRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT EET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUF NT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLI I Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data She

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Product Data Sheet Edition 10.29.2014 Sikadur<sup>®</sup> 51 SL

### Sikadur<sup>®</sup> 51 SL Flexible epoxy control joint resin

Description	Sikadur® 51 SL is a 2-component, self-leveling, 100% solids, flexible, control joint resin sealer and adhesive.
Where to Use	<ul><li>Use to fill horizontal, non-moving, saw cut construction control joints and cracks.</li><li>Use as a flexible adhesive.</li></ul>
Advantages	<ul> <li>Remains flexible. Does not age-harden.</li> <li>Prevents deterioration of joint edges.</li> <li>Excellent adhesive properties.</li> <li>Conforms to ACI 302.1R (4.10-Joint Materials).</li> <li>Ideal for use with plural injection type systems.</li> <li>Can be used on grades up to 15%.</li> <li>Shock absorbent and durable. Withstands wheel traffic and heavy loads.</li> <li>Use as a security sealant.</li> <li>Use as a tamper resistant sealant.</li> </ul>
Coverage	1 gal. will yield 231 in <sup>3</sup> or will fill 100 lin. ft. of 1/8 in. x 1.5 in. deep joint.
Packaging	4 gallon units.

#### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original, unopened containers.						
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75° F (18°-24°C) before using.						
Color	Concrete Gray						
Mixing Ratio	Component 'A': Component 'B' = 1:1 by volume.						
Viscosity	Comp. 'A'5,800 cps (5,800)Comp. 'B'7,900 cps (7,900)Mixed7,000 cps (7,000)						
Pot Life	20-25 minutes, 1 gallon (3.8 liter) 40 minutes, 8 fl. oz. (250 ml)						
Tack-Free Time	7-8 hours						
Elo	STM D-638)nsile Strength570 psi (3.9 MPa)ongation at Break90%odulus of Elasticity2,800 psi (19.3 MPa)nsile stress at % elongation2.5%5%110 psi (0.48 MPa)5%110 psi (0.75 MPa)10%160 psi (1.10 MPa)						
Tear Resistance (AST	M D-624) 14 days 170 lb./in. (29.8 N/mm)						
Hardness (ASTM D-2	240) 28 days Hardness (Shore D) 50-55						
Water Absorption (A	<b>STM D-570)</b> 7 days (24 hour immersion) 1.86%						



How to Use Surface Preparation	grease, curing compounds, bond inhibitin	by be dry or damp, but free of standing water. Remove dust, laitanc ig impregnations, waxes and any other contaminants. red to achieve a laitance and contaminant free, open textured surfact al means.
Mixing	· · ·	qual parts by volume of Component A and Component B into clea low-speed (400-600 rpm) drill using a Sika paddle until uniform pplied within its pot life.
Application		repared joint or use low-pressure extrusion equipment. y, settle and self-level filling entire depth. Strike-off level and remo ore it hardens.
		will overflow out of joint. Allow material to completely harden. App ften cured resin. Shave Sikadur <sup>®</sup> 51 SL with a sharp razor to lev ine the control joint.
Limitations	<ul> <li>Do not apply through standing water.</li> <li>Minimum age of concrete is 28 days.</li> <li>Materials are a vapor barrier after cure</li> </ul>	<ul> <li>(4°C) minimum and rising.</li> <li>naintained between 65°-75°F (18°-24°C) during application.</li> <li>e.</li> <li>for water-vapor transmission prior to application.</li> </ul>
	<ul> <li>Do not use in expansion (moving) join</li> <li>For application in non-moving joints of</li> <li>The ultimate performance of Sikadur<sup>®</sup> mally stable areas (concrete slab), etc</li> <li>Sikadur<sup>®</sup> 51 SL should be installed full</li> </ul>	ts. nly. 51 SL depends upon many factors, [i.e., proper joint design, ther .]. depth when sealing construction/control joints.
	recommended.	than 28 days after new concrete is placed. A 60-90 day cure is r time, especially when exposed to ultraviolet rays, artificial heate
	For applications other than sealing of	joints, consult Sika Technical Service prior to use.
IN S P. Ti	ISTRUCTIONS ON THE PRODUCT'S MOST CU HEET WHICH ARE AVAILABLE ONLINE AT HTT ARTMENT AT 800.933.7452 NOTHING CONTAINE D READ AND FOLLOW THE WARNINGS AND IN	THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS A RRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DA P://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE I ED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATI ISTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CL
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Dat me for	a Sheet, product label and Safety Data Sheet which are	read and follow the warnings and instructions on the product's most current Prod available online at http://usa.sika.com/ or by calling Sika's Technical Service Dep als relieves the user of the obligation to read and follow the warnings and instruct ata Sheet, product label and Safety Data Sheet prior to
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Phone: 52 442 2385800 Fax: 52 442 2250537





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**B200** 

Product Data Sheet Edition 5.13.2016 Sikasil-728 NS

## Sikasil<sup>®</sup>-728 NS

# Non-sag, ultra low modulus, highway/parking garage, neutral cure silicone sealant

Description	silicone sealant. Meets th	performance, non-sag. one-component, ultr. he requirements of ASTM D-5893: ASTM C-920 ith ultra low Shore Hardness: TT-S-00230C,	), Type S, Grade NS, Class 100/50,
Where to Use	Construction Applicati Highway joints Bridges Stadiums Parking garages Plaza decks Driveways Decks Expansion joints Saw cut joints Substrate Concrete, steel, glass,	ion , aluminum, ceramic, masonry, brick, stone a	nd granite
Advantages	<ul> <li>Excellent flexibility for</li> <li>Bonds to most subs</li> <li>Ready to use, labor</li> <li>Non sag, excellent for</li> <li>All season ease of a</li> </ul>	or extreme high and low temperature condition or dynamic joint movement trates without priming; best performance obta cost reduction or vertical joints application all types of concrete joints	
Packaging		ail; 52 gal (197 l) in 55 gal drum. 29 oz. cartridge	e/12 per case.
	TEMPERATURE, APPLICAT Shelf Life Storage Conditions Colors <u>Uncured Properties at</u> Cure Time (MNA Metho Slump (ASTM D-2202) Skin-over Time (MNA M Tack Free Time (ASTM Extrusion Rate (ASTM Rheological, Vertical (A VOC Content Service Temperature	Method) C-679) C-1183 modified) ASTM C-639) 7 days at 77°F (25°C), 50% R.H. ASTM C-639) STM D-412) Shore OO (ASTM C-661 & ASTM D-2240) Shore A (ASTM C-661 & ASTM D-2240) D-412) -794) M D-412) ss, (ASTM C-719) e	TIONS AND CURING CONDITIONS. s at or below 90°F (32°C), shelf life is one s, remove prior to use.



Coverage	1 ga	llon: Yield	d in Linea	r feet		29	oz Cartrid	ge: Yield i	n Linear f	eet	
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		3/8"	205.3	136.8		11	3/8"	46.5	31.0		
		1/2"	153.9	102.6	77.0		1/2"	34.9	23.3	17.4	
	茾										
	Width	3/4"	102.6	68.4	51.3	Width	1	23.3	15.5	11.6	
		1"	<u> </u>		38.5		1"	<u> </u>		8.7	4
		1.25"			30.8	ļļ	1.25"			7.0	
		1.5"			25.7		1.5"			5.8	
How to Use											<u>.</u>
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	join	t depth	does r	not allo	w for b	acke	rod, us	e polye	ethylen	e bond	breaker tape to prevent three-sided adhesic o not compress more than 40%.
Surface Preparation		e substr tings th						sound	and free	e of any	voils, greases or incompatible sealers, paints
	No	n-poro	us sub	strates	s – for	clean	ing non	porous	substr	ates, u	ound surface free of contamination and laitand se two rag wipe method using xylene or an a alant application.
Primer	whe res	en hori: ults and	zontal j d propo	oints a	are prir oplicati	ned. <sup>.</sup> on m	Test by	applyir Refer	ig the s	sealant	of a primer; however, best results are obtain and/or primer sealant combination to confi Data Sheet for Sikasil Primer 2100 and conta
Application	unti into reco sha tool Stri	il prepa the joi ess 1/4 pe and ling. Re	aration nt. App l inch ( l maxin emove low the	work h ly the s 6 mm) num ac excess solver	as bee sealant . For h dhesion s seala	n cor so th ighw n. Dry ant fro	npleted at it is re ay joints tooling om subs	Apply ecesse s, rece is rece strate v	sealar d 1/8 ir ss 1/2 ommen /hile ur	nt using nch (3 m inch (13 nded. D ncured	ing equipment. Do not open product contain g consistent, positive pressure to force seala nm) below the surface. For parking deck joint 3 mm). Tool sealant to create a concave joi O NOT use soapy water or other liquids who using a commercial solvent, such as xylen tions for use. Cured sealant may be remove
Limitations					t to co	ne in	contac	t with s	olvent	durina	cure.
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For actu	further al Safet	informat y Data S	ion and heets co	advice r ntaining	egardin physica	g trans	portation ogical, to:	, handlir cicologic	ng, stora al and o	ge and d ther safe	IPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ON disposal of chemical products, users should refer to t ity related data. Read the current actual Safety Data Sh iternational 703-527-3887.
Prio Data mer for e	r to eacl a Sheet, at at 800-	h use of a product 933-745 a produc	any Sika label an 2. Nothir	product d Safety g contai	, the use Data Sh ned in a	r must eet wh ny Sika	always re ich are av a material	ad and f ailable o s relieve	ollow the nline at s the use	warning http://usa	gs and instructions on the product's most current Prod a.sika.com/ or by calling Sika's Technical Service Dep obligation to read and follow the warnings and instruct d Safety Data Sheet prior to
the Buy EXP SHA THE SAL	CURRENT RESS C LL NOT USE OF E OF S	Product I remedy R IMPLII BE LIAB THIS PR	Data She shall be ED SHAL SLE UND CODUCT ODUCTS	et if use limited t L APPL ER ANY	d as dire o the pu Y INCLU LEGAL 1 INER TO	cted w rchase DING A 'HEOR INFRII	ithin shel price or r NY WAR Y FOR SP NGE ON A	f life. Use eplacem RANTY C ECIAL O NY PATE	er detern ent of pr F MERC R CONS NT OR A	nines suit oduct exe HANTAB EQUENT NY OTHE	facturing defects and to meet the technical properties tability of product for intended use and assumes all ris clusive of labor or cost of labor. NO OTHER WARRANTI BILITY OR FITNESS FOR A PARTICULAR PURPOSE. SI IAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE F R INTELLECTUAL PROPERTY RIGHTS HELD BY OTHEI SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR
O Visi	t our w	ebsite a	t usa.si								1-800-933-SIKA NATIONWIDE
	jional Ir Sika C 201 Pc		ion and ion nue	Sales C	enters. Sika Ca 601 Del Pointe (	i <b>nada</b> mar A	Inc.	of your	Sika M Carrete	<b>exicana</b> era Libre	es office, contact your regional center. S.A. de C.V. Celaya Km. 8.5 Balvanera

Product Data Sheet Edition 6.8.2016 Sikasil-728 RCS

# Sikasil<sup>®</sup>-728 RCS

Two-part, self-leveling, rapid cure, ultra low modulus, horizontal application, neutral cure silicone sealant

Description	Cilcocil 700 DCC (Danid Cur			
	elastomeric, neutral cure silio	cone sealant. Exceeds th	e requirem	mponent, very rapid cure, ultra low modulu ents of ASTM C-920, Type M, Grade P, Clas SHTO reports and state DOT approvals.
Where to Use	Construction Application <ul> <li>Horizontal expansion joints</li> <li>Highway and bridge joints</li> <li>Saw cut joints - new and research and rese</li></ul>			
	<ul> <li>Interior and exterior</li> <li>Above grade or on grade</li> <li>Substrate</li> <li>Concrete, steel, glass, alu</li> </ul>	minum tile ceramic ma	sonry brick	stone and granite
Advantages	<ul> <li>No tooling, less labor</li> <li>Excellent flexibility for ext</li> <li>Excellent flexibility for dyr</li> <li>Bonds to most substrates</li> <li>Open to traffic in one hou</li> <li>All season ease of applica</li> <li>Good contact/adhesion w</li> <li>Ideal for cold climates</li> <li>Excellent for use on runw</li> <li>Jet fuel resistant</li> <li>Resistant to road salts</li> </ul>	reme high and low tempo namic joint movement without priming r ation ith hard to reach areas		
Packaging				- 2 pails each containing 4.5 gal (17 L); 104
	gal unit (394.16 L) –2 drums e	each containing 52 gai (19	97.08 L)	
	Typical Data           RESULTS MAY DIFFER BASED O           TEMPERATURE, APPLICATION           Shelf Life         W           Sk           Storage Conditions         Sti           Colors         Lir <i>Uncured Properties at 77°F (25°)</i> Cure Time (MNA Method)           Skin-over Time (MNA Method)           Tack Free Time (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)           Extrusion Rate (ASTM C-679)	JPON STATISTICAL VARIATION METHODS, TEST METHODS, A hen stored in the original, unoper in may form in pails and drums, r ore in unopened containers at te nestone and Charcoal Gray (whe <u>C), 50% R.H.</u> odified, Type S) 39) 77°F (25°C), 50% R.H.	NS DEPENDIN CTUAL SITE of hed containers emove prior to mperatures at 1 an Part A, dark 90% in 1 hr. 10 min. 25 min. 50 g/min. 1/6 self-leveling (	or below 90°F (32°C). gray and Part B, white, are mixed). 3° orifice @ 50 psi Specific Gravity 1.25 - 1.35 9 (120°F (49°C) 2.4% by wt., 30 g/l, 0.25 lbs/gal -80° to 350°F (-62.2° to 176.6°C)
	Typical Data         RESULTS MAY DIFFER BASED I         TEMPERATURE, APPLICATION         Shelf Life       W         sk         Storage Conditions       Sti         Colors       Lir         Uncured Properties at 77°F (25°C         Cure Time (MNA Method)         Skin-over Time (MNA Method)         Tack Free Time (ASTM C-679)         Extrusion Rate (ASTM C-1183 m         Rheological, Vertical (ASTM C-6         VOC Content         Service Tomperature         Cured Properties atter 7 days at         Movement Capability & Bond D         (glass, aluminum and concrete)         Elongation at Break (ASTM D-41	JPON STATISTICAL VARIATION METHODS, TEST METHODS, A hen stored in the original, unoper in may form in pails and drums, r ore in unopened containers at te nestone and Charcoal Gray (whe <i>C), 50% R.H.</i> odified, Type S) 39) <i>77°F (25°C), 50% R.H.</i> urability (ASTM C-719) 2)	NS DEPENDIN CTUAL SITE ( hed containers remove prior to mperatures at n Part A, dark 90% in 1 hr. 10 min. 25 min. 50 g/min. 1/6 self-leveling (	CONDITIONS AND CURING CONDITIONS. at or below 90°F (32°C), shelf life is one year. A product use. or below 90°F (32°C). gray and Part B, white, are mixed). at orifice @ 50 psi Specific Gravity 1.25 - 1.35 9 (120°F (49°C) 2.4% by wt., 30 g/l, 0.25 lbs/gal -80° to 350°F (-62.2° to 176.6°C) +100%, -50%
	Typical Data         RESULTS MAY DIFFER BASED O         TEMPERATURE, APPLICATION         Shelf Life       W         Sk       Storage Conditions         Storage Conditions       Sti         Colors       Lit         Uncured Properties at 77°F (25°F)         Cure Time (MNA Method)         Skin-over Time (MNA Method)         Tack Free Time (ASTM C-679)         Extrusion Rate (ASTM C-1183 m         Rheological, Vertical (ASTM C-679)         Extrusion Rate (ASTM C-1183 m         Newoment Capability & Bond D         (glass, aluminum and concrete)         Elongation at Break (ASTM D-41         Hardness,       St	JPON STATISTICAL VARIATION METHODS, TEST METHODS, A hen stored in the original, unoper in may form in pails and drums, r ore in unopened containers at te nestone and Charcoal Gray (whe <i>C), 50% R.H.</i> odified, Type S) 39) <i>TT°F (25°C), 50% R.H.</i> urability (ASTM C-719)	NS DEPENDIN CTUAL SITE of hed containers remove prior to more atures at 1 an Part A, dark 90% in 1 hr. 10 min. 25 min. 50 g/min. 1/6 self-leveling ( D-2240) -2240)	CONDITIONS AND CURING CONDITIONS. at or below 90°F (32°C), shelf life is one year. A product use. or below 90°F (32°C). gray and Part B, white, are mixed). <sup>2°</sup> orifice @ 50 psi Specific Gravity 1.25 - 1.35 9 (120°F (49°C) 2.4% by wt., 30 g/l, 0.25 lbs/gal -80° to 350°F (-62.2° to 176.6°C) +100%, -50%



Coverage

20 c	z Sausag	e: Yield in	Linear fe	et
	)epth	1/4"	3/8"	1/2"
	1/4"	48.1		
	3/8"	32.1	21.4	
_	1/2"	24.1	16.0	12.0
Width	3/4"	16.0	10.7	8.0
	1"			6.0
	1.25"			4.8
	1.5"			4.0

1 ga	1 gallon: Yield in Linear feet								
	)epth	1/4"	3/8"	1/2"					
	1/4"	307.9							
	3/8"	205.3	136.8						
	1/2"	153.9	102.6	77.0					
Width	3/4"	102.6	68.4	51.3					
[	1"			38.5					
	1.25"			30.8					
	1.5"			25.7					

#### How to Use Installation

Primer

Joint Design: The number of joints and the joint width may be designed for high movement capability. For joints one to three inches in width, the sealant will accept movements +100% and -50% and for three to four inches in width, the sealant will accept movements of  $\pm50\%$  of joint width at time of installation. The depth of the sealant should be 1/2 the width of the joint. The minimum depth is 1/4 inch (6 mm) and the maximum is 1/2 inch (12 mm). For joints greater than 1 inch (25.4 mm), do not exceed 1/2 inch (6 mm) in depth

Joint Backing: To control joint depth, use closed cell polyethylene or non-gassing polyolefin backer rod. If clinit depth does not allow for backer rod, use polyethylene bond breaker tape to prevent three-sided adhesion. Closed cell backer rod should be 25% larger than joint width; do not compress more than 40%. Never use open cell rod in on grade horizontal joints.

**Surface Preparation** The substrate must be clean, dry, frost free, sound and free of any oils, greases or incompatible sealers, paints or coatings that may interfere with adhesion. Porous Substrates - clean by mechanical methods to expose a sound surface free of contamination and laitance.

Non-porous substrates - for cleaning non-porous substrates, use two rag wipe method using xylene or an approved commercial solvent. Allow solvent to evaporate prior to sealant application.

Sikasil-728 RCS is designed to obtain adhesion without the use of a primer; however, best results are obtained when horizontal joints are primed. Test by applying the sealant and/or primer sealant combination to confirm results and proposed application methods. Refer to Technical Data Sheet for Sikasil Primer and contact Technical Service for additional information.

Application Apply sealant using consistent, positive pressure to force sealant into the joint. Apply the sealant so that it is recessed 1/8 inch (3 mm) below the surface. For parking deck joints, recess 1/4 inch (6 mm). For highway joints, recess 1/4 inch (13 mm). Sikasil-728 RCS is self-leveling - no tooling is needed. DO NOT use soapy water or other liquids. Consult full application guide for further information. Sikasil-728 RCS will obtain adhesion to aged, cured asphalt. Never use on newly poured asphalt. Conduct a field test to document and confirm at the surface. adhesion under actual jobsite conditions.

Removal Remove excess sealant from substrate while uncured using a commercial solvent, such as xylene according to the solvent manufacturer's warnings and instructions for use. Cured sealant can only be removed by mechanical means. Limitations

Do not allow sealant to come in contact with solvent during cure. 

Do not allow sealant to come in contact with curing polyurethane sealants during cure. 

- Not intended for immersion.
- Sealant may be applied below freezing temperatures if substrates are completely dry, frost free and clean. Contact Technical Service for more information. -
- Contact Technical Service prior to using in joints over three inches (76 mm) wide.
- Not intended for structural glazing.
- Test recommended for absorptive surfaces such as limestone, granite or marble where staining may occur.
- Do not apply to substrates that bleed oil, plasticizers or solvent.
- Do not apply to damp or wet substrates.
- Lower temperature and humidity will extend tack free and cure rates.
- Allow treated wood to age six months before application.
- Brass and copper may discolor. Test apply prior to application.

Test sensitive substrates, such as mirror backings for compatibility before use. 

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 1-800-933-SIKA NATIONWIDE

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Product Data Sheet Edition 5.13.2016 Sikasil-728 SL

### Sikasil<sup>®</sup>-728 SL

Self-leveling, ultra low-modulus, highway/parking garage, neutral cure silicone sealant

Description	Sikasil-728 SL is a self-leveling, one-component, ultra low modulus, e ant. Meets the requirements of ASTM D-5893; ASTM C-920, Type S, A, O with an ultra low Shore Hardness; TT-S-00230C, Type I, Class A	Grade P, Class 100/50; Use T, M, G,
Where to Use	Construction Application Highway joints Bridges Stadiums Parking garages Plaza decks Driveways Decks Expansion joints Saw cut joints Substrate Concrete, steel, glass, aluminum, tile, ceramic, masonry, asphalt, b	prick, stone and granite
Advantages	<ul> <li>No tooling, less labor</li> <li>Durable</li> <li>Ideal for cold climates</li> <li>Excellent flexibility for extreme high and low temperature conditio</li> <li>Excellent flexibility for dynamic joint movement</li> <li>Bonds to most substrates without priming including aged asphalt</li> <li>Ready to use</li> <li>All season ease of application</li> <li>Good contact/adhesion with hard to reach areas</li> <li>Excellent for use on runways and tarmacs</li> <li>Jet fuel resistant</li> <li>Resistant to road salts</li> </ul>	
Packaging	<ul> <li>Resistant to road saits</li> <li>4.5 gal (17 L) in a 5 gal pail; 52 gal (197 L) in 55 gal drum; 29 oz. cartridg</li> </ul>	40
	Typical Data         RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPO TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDI Shelf Life         12 months in original unopened container. A proc remove prior to use.         Storage Conditions       Store in unopened containers at temperatures at Colors         Limestone and Charcoal Gray.         Uncured Properties at 77°F (25°C), 50% R.H.	TIONS AND CURING CONDITIONS. duct skin may form in pails and drums,
	Cure Time (MNA Method)	1/16" / 24 hours
	Skin-over Time (MNA Method)	60 min.
		115 min.
	Tack Free Time (ASTM C-679) Extrusion Rate (ASTM C-1183 modified) Rheological, Vertical (ASTM C-639) VOC Content Service Temperature Cured Properties after 7 days at 77°F (25°C), 50% R.H.	900 g/min. 1/8" orifice @ 90 psi self-leveling @ 120°F (49°C) 2.27% by wt., 29 g/L, 0.24 lbs/gal -80° to 350°F (-62.2° to 176.6°C)
	Movement Capability (ASTM C-719)	+100%, -50%
	Elongation at Break (ASTM D-412)	1100%
	Hardness Shore OO (ASTM C-661 & ASTM D-2240)	40
	Shore A (ASTM C-661 & ASTM D-2240)	3-5
	Stress at 100% (ASTM D-412)	30 psi (0.21 MPa)
	Stress at 100% (ASTM D-412) Peel Strength (ASTM C-794)	30 psi (0.21 MPa) 25 pli
	Peel Strength (ASTM C-794)	25 pli



Coverage	29 (	oz Cartridg	ge: Yield i	n Linear f	eet		1 gal	llon: Yiel	d in Linea	r feet		J
		Depth 1/4" 3			3/8" 1/2"		D	epth	1/4"	3/8"	1/2"	]
		1/4"	69.8			1 [		1/4"	307.9		1	1
		3/8"	46.5	31.0		1		3/8"	205.3	136.8	1	1
		1/2"	34.9	23.3	17.4	1		1/2"	153.9	102.6	77.0	1
	Width	3/4"	23.3	15.5	11.6	11	Width	3/4"	102.6	68.4	51.3	1
	≥	1"			8.7	1	>	1"			38.5	-
		1.25"			7.0	1		1.25"			30.8	-
		1.5"			5.8	$\left\{ \right. \right\}$		1.5"			25.7	4
How to Use		1.5			5.0			1.5			23.7	
Application	exca Join doe bacl The coal Por Sika hori: prop add Rea unti	eed 1/2 t Backii s not al ker rod substra- tings the bus Sub i-porous mercia asil-728 zontal ji bosed a itional ii dy to u	inch (1 ng: To c llow for should ate mus at may ostrates s substi I solver SL is d oints ar upplicat format se, app ration V	3 mm) control j backe be 25° st be cl interfe s – clea rates – nt. Allov lesigne re prime ion me tion.	in dep oint de r rod, u % large ean, dr re with in by m for clea v solve d to ob ed. Tes thods. I	th. pth, i use p r tha y, frcc adhe necha aning nt to tain a t by a Refe ession n coi	use polye in jo post fr esion anic: nor eva adhe appl r to	closed ethyler int wid ree, so n. al meth poroto aporate esion v lying th Techn	cell po ne bond th; do r und an nods to s subs p prior to vithout ne seala cal Dat	lyethyle break not com d free o expos trates, o seala the use ant and ta Shee n or dis ealant	ene or r ter tape of any c e a sou use two int appl e of a pr l/or prin et for Si ppensin using c	or joints greater than 1 inch (25.4 mm), do not non-gassing polyolefin backer rod. If joint dept a to prevent three-sided adhesion. Closed co more than 40%. bils, greases or incompatible sealers, paints of and surface free of contamination and laitance or ag wipe method using xylene or an approve ication. rimer; however, best results are obtained whe ner sealant combination to confirm results an ikasil Primer and contact Technical Service for operation of the pressure to force sealar n) below the surface. For parking deck joints
Removal	rece no t cure sea Con Ren Iow	ess 1/4 ooling e. This lant joir iduct a nove ex	inch (6 is need conditi nt. Sika field te kcess s t manu	5 mm). ded. It on doe asil-728 est to d sealant facture	For hig is typic s not a SL wi ocume from s er's ins	ghwa al th affec II obi nt ar subst truct	ay jo lat 7 t the tain nd c trate	oints, r 728 SL e time adhes confirm while s for us	ecess may r the su sion to adhes uncure se and	1/2 inc etain s rface j aged, sion un ed usin warnir	h (13 m some re oint ca cured a ider act ig a cor ing s. Cu	nm). Sikasil-728 SL is self leveling therefore esidual surface tack in its first 10-14 days of n be open to service in a properly recesse asphalt. Never use on newly poured asphal tual jobsite conditions. mmercial solvent, such as xylene. Strictly fo ured sealant may be removed by mechanica
Limitations		Do not	allow s	sealant	to con	ne in		ntact v	vith sol	vent d	uring ci	
		clean. Not inte Test rec Do not Do not Lower f Allow tr Brass a Test se Due to itself, S	t may be Contact ended to comme apply to apply to apply to temper reated and cop nsitive the ve Sikasil To	be app to Tech for stru- ended for to substo dam ature a wood to oper m substr ry low f 728 SL	lied be nical S ctural s or abso aces th strates p or we and hun o age ay be o ates fo tensile is not	low f ervice glazi orptiv at wi that et su midit six m disco or con streat reco	ce fo ing. /e si blee bstr boot pont blore mpa ngth	or mor urface e pain ed oil, rates. ill exte ths be ed. Tes atibility of as pendeo	e inforr s such ed. plastic nd tack fore ap st apply before phalt a d for as	nation as gra izers o k free a plicatio plicatio prior e use. nd pos phalt t	nite, lim r solver and cur on. to appli ssibility o asph	re rates. ication. that asphalt may fail cohesively within alt joints.
	INSTRUC SHEET W PARTMEN TO READ RENT PRO KEEP CONTAIN For further i actual Safety before using	TIONS ( HICH A IT AT 80 AND FO DUCT IER TIGHTI nformati Data Sh the prod	ON THE RE AVA 00.933.7 OLLOW DATA S LYCLOSE on and a neets cor duct. In o	E PROE ALLABL 7452 NG 7452 G 750 NG	UCT'S E ONLI OTHING /ARNIN PRODU UT OF RE/ egarding physical emergen	MOS NE A CON IGS A JCT I ACH OF trans I, ecol cy, ca	ST C T H NTAI AND LAB F CHIL sport logic II CH	URRE TTP://UNED IN INSTR EL AN DREN. Notation, h al, toxic IEMTRE	NT PRO JSA.SIF NANY S UCTIO D SAFE OT FOR IN andling, ological C at 1-80	CODUCT (A.COM SIKA M/ NS FOR TY DA TERNAL C storage and oth 00-424-9	DATA S A/ OR B ATERIA R EACH TA SHE CONSUMPT and dis er safety 300, Inte	AND FOLLOW THE WARNINGS AND SHEET, PRODUCT LABEL AND SAFETY DATA BY CALLING SIKA'S TECHNICAL SERVICE DE LS RELIEVES THE USER OF THE OBLIGATION I SIKA PRODUCT AS SET FORTH IN THE CUR ET PRIOR TO PRODUCT USE. TION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY sposal of chemical products, users should refer to the related data. Read the current actual Safety Data Shee rnational 703-527-3887.
	Data Sheet,   ment at 800- for each Sika	product I 933-7452 a produc	abel and Nothin t as set	I Safety g contain forth in t	Data She ned in an he curre	et wh y Sik ent Pro	ich a a ma oduc	are avai terials r t Data \$	able onl elieves t Sheet, pr	ine at ht he user o oduct la	tp://usa.s of the ob bel and \$	and instructions on the product's most current Produc sika.com/ or by calling Sika's Technical Service Depar ligation to read and follow the warnings and instructio Safety Data Sheet prior to product use.
R	the current F Buyer's sole EXPRESS O SHALL NOT THE USE OF SALE OF SIK Visit our we Regional In	Product D remedy R IMPLIE BE LIAB THIS PRO APRODU absite at formatic	Data Shee shall be ED SHAL LE UNDE ODUCT I CTSARE Usa.sik	et if used limited to L APPLY ER ANY L N A MAN SUBJEC (a.com	l as direc o the pur INCLUE EGAL TI NER TO TSIKA'S	cted w chase DING A HEOR INFRI TERM	vithin Pric ANY XY FC NGE ISAN	n shelf li e or rep WARRA OR SPEC ON ANY ID COND	fe. User ( lacemen NTY OF CIAL OR ( PATENT ITIONS O	determir t of prod MERCH CONSEC OR ANY FSALEA	nes suital luct exclu ANTABIL QUENTIA ( OTHER VAILABL ka sales	cturing defects and to meet the technical properties o bility of product for intended use and assumes all risks usive of labor or cost of labor. NO OTHER WARRANTIE LTY OR FITNESS FOR A PARTICULAR PURPOSE. SIK L DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOI INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. LAT HTTP://USA.SIKA.COM/OR BY CALLING 201-933-8800 1-800-933-SIKA NATIONWIDE office, contact your regional center.

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Jika

### Sikadur<sup>®</sup> 31, Hi-Mod Gel (1:1 Mix Ratio) High-modulus, high-strength, structural, epoxy paste adhesive

cription	strength, structural epo	el, is a 2-component, 100% so oxy paste adhesive. It conform O M-235 specifications.		
ere to Use	<ul> <li>Structural bonding o</li> </ul>	f concrete, masonry, metals, v	vood, etc. to a maximum glu	ie line of ¼ in. (3 mm).
	<ul> <li>Grout bolts, dowels,</li> </ul>			
		ound injection ports prior to pr		
		overhead repair of concrete a		al facilitian
		ant around windows, doors, lo	•	
antages		irements of ASTM C-881 Type		s B & C.
		water contact, meets NSF/AN o concrete, masonry, metals, v		naterials
		leal for vertical and overhead		
		ngth-producing adhesive.		
	Convenient easy mix	k ratio A:B = 1:1 by volume.		
erage	1 gal. yields 231 cu. in	(3,785 cm <sup>3</sup> ) of epoxy paste a	dhesive. 1 gal. (3.8 L) mixe	d with 1 gal. (3.8 L) by loos
	volume of oven-dried a	ggregate yields approximately	y 346 cu. in. (5,670 cm <sup>3</sup> ) of e	epoxy mortar.
kaging	1 gal. and 3 gal. (11.4 l	_) units.		
	Typical Data (Mat	terial and curing conditions	@ 73°F (23°C) and 50% R.	.Н.)
		SED UPON STATISTICAL VARIATION		
	· · · · · ·	TION METHODS, TEST METHODS, AC	CTUAL SITE CONDITIONS AND CU	RING CONDITIONS.
	Shelf Life	2 years in original, unopened co		
	Storage Conditions	Store dry at 40°-95°F (4°-35°C)	. Condition material to 65°-85°F	(18°-29°C) before using.
	Color	Concrete gray		
	Mixing Ratio	Component 'A' : Component 'B'	= 1:1 by volume	
	Consistency	Non-sag paste		
	Pot Life	Approximately 60 minutes @ 73	3°F. (500 gram mass)	
	Tack-Free Time	1.5 - 2.5 hours at 30 mils. thick		
	Tensile Properties (AST	<sup>-</sup> M D-638)		
		e Strength 3,300 psi (22	2.7 MPa)	
		ation at Break 0.9 %		
	Flexural Properties (AS 7 day Flexura	al Strength (Modulus of Rupture)	6,100 psi (42.0 MPa)	
	•	nt Modulus of Elasticity in Bending		MPa)
	Shear Strength (ASTM	D-732) 7 day Shear	Strength 4,600 psi (31.7 M	/IPa)
	Bond Strength (ASTM (	C-882)		
		e to Hardened Concrete:		
		cure) 2,200 psi (15.2 MPa		
		st cure) 2,400 psi (16.5 MPa st cure) 2,900 psi (20.0 MPa	*	
	Hardened Concrete	<i>,</i> , , , , , , , , , , , , , , , , , ,	)	
	2 day (dry cure		)	
	Tensile Bond Strength	(Pull-off Method, Dyna, ASTM C	-1583-04)	
	2 day	420 psi (2.9 MPa)		
	Heat Deflection Temper	ature (ASTM D-648) 7 day (Fi	ber Stress Loading = 264 psi)	135°F (57°C)
	Water Absorption (AST			
	Compressive strength	(ASTM D-695) psi (MPa)		
		40°F (4°C)* **	73°F (23°C)* **	90°F (32°C)* **
	2 hou 4 hou		-	450 (3.1)
	4 hour 8 hour		800 (5.5) 8,500 (58.6)	10,500 (72.4) 12,200 (84.1)
	16 hou		10,500 (72.4)	13,000 (89.6)
	1 day	6,000 (41.4)	13,000 (89.6)	15,000 (103.4)
	1 duy	44 000 (75 0)	14,000 (96.5)	16,000 (110.3)
	3 day	11,000 (75.8)		
	3 day 7 day	12,900 (88.9)	15,000 (103.4)	16,000 (110.3)
	3 day	12,900 (88.9) 13,500 (93.0)	15,000 (103.4) 15,400 (106.1) 16,000 (110.3)	16,000 (110.3) 16,000 (110.3) 16,000 (110.3)



	Compressive Modulus of Elasticity (ASTM D-695)         7 day         7.95 X 10 <sup>5</sup> psi         (5,485 MPa)           VOC Content         4.0 g/L (A+B)         5						
	<ul> <li>* Material cured and tested at temperatures indicated.</li> <li>** See Limitations section for further information.</li> </ul>						
How to Use Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance grease, curing compounds, impregnations, waxes, and any other contaminants. <b>Preparation Work:</b> Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free open textured surface by blast cleaning or equivalent mechanical means. <b>Steel</b> - Should be cleaned and prepared thoroughly by blast cleaning or other equivalent mechanical means						
Mixing	<b>Pre-mix each component.</b> Proportion 1 part Component 'B' to 1 part Component 'A' by volume into a clear pail or appropriately sized mixing container. Mix thoroughly for 3 minutes with Sika paddle on low-speed (40 600 rpm) drill until uniform in color. Mix only that quantity which can be used within its pot life. Prior to mixin material should be conditioned to 65°-85°F (18°-29°C). To prepare an epoxy mortar, slowly add up to 1 part by loose volume of an oven dried aggregate, to 1 part of the mixed Sikadur <sup>®</sup> 31, Hi-Mod Gel, and mix un uniform in consistency.						
Application	As a structural adhesive - Apply the neat mixed Sikadur <sup>®</sup> 31, Hi-Mod Gel to the prepared substrates. Wor into the substrate for positive adhesion. Secure the bonded unit firmly into place until the adhesive has cured Glue line should not exceed 1/8-in. (3 mm).						
	To seal cracks for injection grouting - Place the neat mixed material over the cracks to be pressure injecter and around each injection port. Allow sufficient time to set before pressure injecting. For interior vertical and overhead patching - Place the prepared mortar in void, working the material into the prepared substrate, filling the cavity. Strike off level. Lifts should not exceed 1-in (25 mm).						
	As a pick-proof sealant - Use automated or manual method. Apply an appropriate size bead of material around the area being sealed. Seal with neat Sikadur® 31, Hi-Mod Gel.						
Limitations	THE NTSB HAS STATED THAT THIS PRODUCT IS APPROVED FOR SHORT TERM LOADS ONLY AN SHOULD NOT BE USED IN SUSTAINED TENSILE LOAD ADHESIVE ANCHORING APPLICATION WHERE ADHESIVE FAILURE COULD RESULT IN A PUBLIC SAFETY RISK. CONSULT A DESIG PROFESSIONAL PRIOR TO USE.						
	<ul> <li>Components of original 2:1 mix ratio formulation of Sikadur<sup>®</sup> 31, Hi-Mod Gel cannot be cross-mixed wi components of Sikadur<sup>®</sup> 31, Hi-Mod Gel (NEW 1:1 Mix Ratio) formulation.</li> </ul>						
	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not thin. Solvente will prove proper ourse</li> </ul>						
	<ul> <li>Do not thin. Solvents will prevent proper cure.</li> <li>When preparing an epoxy mortar, use oven-dried aggregate only.</li> </ul>						
	<ul> <li>When preparing an epoxy monar, use oven-oned aggregate only.</li> <li>Maximum epoxy mortar thickness is 1 in. (25 mm) per lift.</li> </ul>						
	<ul> <li>Epoxy mortar is for interior use only. Material is a vapor barrier after cure.</li> </ul>						
	<ul> <li>Minimum age of concrete must be 21-28 days, depending upon curing and drying conditions, for mortar applications.</li> </ul>						
	<ul> <li>Porous substrates must be tested for moisture-vapor transmission prior to mortar applications.</li> </ul>						
	Not for sealing cracks under hydrostatic pressure.						
	Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.           RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS A           STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY D.						
SH PA TO RE KEEP For f	HEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE I RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATI D READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CI ENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.						
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Data men for e	to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart- at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction ich Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to ict use.						

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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# Sikadur<sup>®</sup> Combiflex<sup>®</sup> SG System

High performance joint sealing system

Description	High performance joint sealing system for construction, expansion and connection joints as well as for cracks. When fixed to the joint, allows irregular and high movement in more than one direction, while maintaining a high quality seal. The Sikadur Combiflex SG System consists of a modified flexible Polyolefin (FPO) waterproofing tape with advanced adhesion using Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio).				
Where to Use	Sealing system for expansion, construction and connection joints, as well as for cracks in:         Tunnels and culverts         Hydroelectric power plants         Sewage treatment plants         Basements         Water retaining structures and drinking water reservoirs         Around iron, steel and concrete pipes         Swimming pools         Sealing of:         Joints with extreme movement         Building sections where varying settlement is expected         Cracks         Repair/reinstatement of leaking joint sealing systems such as:         Waterbars         Joint sealants, etc.				
	<b>Typical Data</b> ( <i>Material and curing conditions</i> 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT.				
	TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.				
	Shelf life         Combiflex Kit - 2 years in original, unopened containers.				
	<b>Storage Conditions</b> Store dry at 40°-85°F (4°-30°C.) <b>Condition material to 65°-85°F</b> before using.				
	Color Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio), adhesive - light gray. FPO sheeting - concrete gray.				
	Typical Technical Data for Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio), Adhesive:Pot LifeApproximately 60 minutes.Tack Free Time1.5 - 2.5 hours				
	Typical Technical Data for Combiflex SG:         Tensile Properties (ASTM D-412)         Tensile Strength       > 1,740 psi (12 MPa)         Elongation at Break       > 600%         Tear Resistance (ASTM D-624) Die C         Tear Strength       69 lb/in. (12 N/mm)         Low Temperature of Performance       Maintained to -40°F				
	Typical Technical Data for Sikadur Combiflex System:				
	Peel Strength (ASTM D-903)7 daysSubstrate, ConcreteNo loss of adhesion between the Tape and the Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio), or the Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio) and the concrete				
	Chemical Resistance				
	Long term to: Water, lime water, cement water, seawater, salt solutions, domestic sewage, bitumen (accord- ing to EN 1548), bitumen emulsion coatings (staining possible), etc. Temporary to: Light fuel oil, diesel, diluted alkali and mineral acids, ethanol, methanol, petrol, etc.				
	Ozone Resistance				
	3 month Exposure Water/Ozone (3 ppm) - No Effect; Air/Ozone (2-300 ppm) - No Effect				
	For additional information on Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio), consult Technical Data Sheet or call Technical Service.				
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RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



Advantages	<ul> <li>Advanced adhesion, no activation of tape required</li> <li>Easy to install</li> <li>Suitable for both dry and damp concrete surfaces</li> <li>UL Listed for potable water applications</li> <li>Extremely flexible</li> <li>Performs well within a wide range of temperatures</li> <li>Excellent adhesion to many materials</li> <li>Weather and water resistant</li> <li>Approved for contact with potable water</li> <li>Good resistance to many chemicals</li> <li>Root resistant</li> <li>Versatile system suitable for many difficult situations</li> </ul>					
Coverage	Sikadur Combiflex SG Tape - 82 lineal ft./roll. Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio) - 40 lineal ft./ gal.					
Packaging	Kits: Pre-measured kits containing 4 in. wide by 20 ft. long Sikadur Combiflex SG tape, 60 oz. of Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio). The components may be also be purchased separately: Sikadur Combiflex SG Tape - 4, 8 and 12 in. wide by 20 ft. long and 82 ft. long. Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio) - 3 gal. units, and 1 gal. unit.					
How to Use						
Surface Preparat	Surface must be clean and sound. It may be dry or damp but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes, and any other contaminants. Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blastcleaning or equivalent mechanical means. Steel - Should be cleaned and prepared thoroughly by blastcleaning.					
Mixing	Surface must be clean and sound. It may be dry or damp but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes, and any other contaminants. Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blastcleaning or equivalent mechanical means. Steel - Should be cleaned and prepared thoroughly by blastcleaning or other equivalent means.					
Application	Surface must be clean and sound. It may be dry or damp but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes, and any other contaminants. Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blastcleaning or equivalent mechanical means. Steel - Should be cleaned and prepared thoroughly by blastcleaning					
Limitations	<ul> <li>Minimum surface temperature 40°F.</li> <li>Do not thin Sikadur 31, Hi-Mod Gel (1:1 Mix Ratio). Solvents will prevent proper cure.</li> <li>Maximum application thickness of epoxy is 1/8 in.</li> <li>Epoxy is a vapor barrier after cure.</li> <li>Cover plates over joint are required when using Sikadur Combiflex SG Tape in traffic areas.</li> <li>If joints are to be subjected to water pressure, the tape must be supported in the joint. Hard foam or joint sealant is recommended.</li> <li>For exposure to negative water pressure, the Sikadur Combiflex SG Tape must be secured with a steel plate fixed on one side.</li> <li>The Sikadur Combiflex SG Tape must be protected from mechanical damage.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>					
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# Sikadur<sup>®</sup> 23, Lo-Mod Gel

Low-modulus, paste-consistency, epoxy resin binder

Description	Sikadur <sup>®</sup> 23, Lo-Mod Gel, is a 2-component, 100% solids, moisture-tolerant, low-modulus, non-sag paste-consistency, epoxy resin binder. It conforms to the current ASTM C-881 and AASHTO M-235 specifications.							
Where to Use	<ul> <li>Use as a binder for epoxy mortar repairs.</li> <li>As a pick-proof sealant around windows, doors, lock-ups, etc., inside correctional facilities, schools an institutions.</li> </ul>							
Advantages	<ul> <li>Non-sag consistency.</li> <li>Convenient easy to mix ratio A:B = 1:1 by volume.</li> <li>Moisture-tolerant epoxy adhesive binder.</li> </ul>							
Coverage	ge 1 gal. of mixed Sikadur <sup>®</sup> 23, Lo-Mod Gel, when mixed with 1 part by loose volume of oven-dried aggregative yields approximately 346 cu. in. of epoxy mortar.							
Packaging	4-gal. units							

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original, unopened containers.						
Storage Conditions	<ul> <li>Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.</li> </ul>						
Color	Concrete gray.						
Mixing Ratio	Ratio Component 'A':Component 'B' = 1:1 by volume.						
Consistency	nsistency Non-sag paste.						
Pot Life	Approximately 45 minutes. (200 gram mass)						
Tensile Properties Mortar 1:1 (ASTM D-638) 14 day Tensile Strength Elongation at Break Modulus of Elasticity			2,400 psi (16.5 MPa 1.0 % 6.1 x 10⁵ psi (4,206 №	6.3%	2,000 psi (13.8 MPa) 6.3%		
Flexural Properties Mortar 1:1 (ASTM D-790) 14 day Flexural Strength (Modulus of Rupture) Tangent Modulus of Elasticity in Bending			3,900 psi (26.9 MPa 6.8x10⁵ psi (4,688 M	/ / I	4,800 psi (33 MPa) )    4.71x10⁵ psi (3,247 MPa)		
Shear Strength Morta 14 day Shear Streng			3,300 psi (22.7 MPa) 3,000 psi (21 MPa)				
Water Absorption Neat (ASTM D-570) 7 day (2 hour Boil) 0.4%							
Deflection Temperature Mortar 1:1 (ASTM D-648) 14 day [fiber stress loading = 66 psi (0.46 MPa)] 102°F (39°F)							
Bond Strength (ASTM C-882): Hardened concrete to hardened concrete2 day (dry cure)Bond Strength2,600 psi (17.9 MPa)14 day (moist cure)Bond Strength1,700 psi (11.7 MPa)							
Compressive Properties Mortar 1:1, (ASTM D-695)         Neat           Compressive Strength, psi (MPa)         Neat           40°F* (4°C)         73°F* (23°C)         90°F* (32°C)         73°F* (23°C)							
8 hour -	. ,	- `	3,500 (24.1)	-			
16 hour -		3,300 (22.7)	) 5,600 (38.6)	120 (0.83)	960 (6.6)		



	7 day 14 day 28 day	2,200 (15.2) 7,300 (50.3) 7,400 (51.0)	6,500 (44.8) 7,100 (48.9) 7,200 (49.6)	5,800 (40.0) 5,900 (40.7) 6,000 (41.4)	4,600 (31.7) 5,000 (34.5) 5,150 (35.5)	3,600 (24. 3,800 (26. 3,900 (26.
	Compressive	Modulus 28 d	l <b>ays</b> 4.0x10⁵	psi (2,758 MPa)	1.28x10⁵ psi	(883 MPa)
	* Cured and tested	at the temperatures indicated	l.			
How to Use Surface Preparation		e clean and sound. It n ompounds, impregnat				e dust, laita
		uld be cleaned and pre or equivalent mechar	•	laitance and contar	ninant free, open t	extured sur
	Steel - Should I a shiny metal fir	be cleaned and prepar iish.	red thoroughly by I	plastcleaning other	equivalent mecha	anical meai
Mixing	a clean pail. Mix in color. Slowly a	omponent. Proportion thoroughly for 3 minu add up to 1 part by loc d mix until uniform in c	tes with a Sika pao ose volume of an o	ddle on a low-speed	d (400-600 rpm) d te to 1 part of mix	rill until uni ∋d Sikadur®
Application	from deepest to	pply the Sikadur <sup>®</sup> 23, shallowest area. Strik <b>f sealant -</b> Use autor	e off level.			
		being sealed. Seal wi			11 1	
	around the area	0				

1 day

3 day

7 day

100 (.69)

2 200 (15 2)

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5,700 (39.3)

5,800 (40.0)

5,800 (40.0)

4,500 (31.0)

5,600 (38.6)

1,600 (11.0)

1,800 (12.4)

3,600 (24.8)

1,300 (9.0)

2,900 (20.0)

4,600 (31.7)





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# Sikaflex<sup>®</sup>-11 FC

One part advanced polyurethane, elastomeric sealant/adhesive

Description		e-component, gun-grade, adhesive and sealing compound of permanent elastic- material is based on a special moisture-cured polyurethane with an accelerated
Where to Use		skets and coverings. iles. nd door sills. struction materials. nd door frames. eealer for: h vacuum systems. s, and silos. ngs in walls or floors for ducts, piling, etc. ter retaining structures.
	<ul> <li>Bolted lap joints.</li> </ul>	
Advantages	<ul><li>polyester and acry</li><li>Fast cure rate.</li><li>Good weathering</li><li>Non-corrosive.</li></ul>	on on all cement-based materials, brick, ceramics, glass, metals, wood, epoxy, rylic resin. g and water resistance. over with water, oil, and rubber-based paints. (Preliminary tests recommended)
Chemical Resista	nce Good resistance to wa	ater, weak acids, weak alkalis, sewerage, mineral oils, vegetable oils, fats, fuels
		ic solvents, paint thinner, strong acids, strong alkalis). Consult Technical Service fo
Packaging	specific data.	., moisture-proof composite cartridges, 12/case.
	RESULTS MAY DIFFER BASE	
	Ostar	before using.
	Color VOC Content	White
	Application Tempera	28.5 g/L ature 40° to 100°F. Sealant should be installed when joint is at mid-range
		of its anticipated movement.
	Service Range	-40° to 170°F
	Curing Rate	Tack-free Time (TT-S-00230C) 1 to 2 hours depending on climate. Final Cure 3 to 5 days
	Recovery	ASTM C-719 >90%
	Shore A Hardness (A	ASTM D-2240) 40-45
	Tensile Properties (A Tensile Stress	225 psi
		(ASTM D-1002) modified, glass substrate
	73 F/50% RH Weathering Resistan	165 psi nce Excellent
	U	
	STRUCTIONS ON THE PRODUC HEET WHICH ARE AVAILABLE O \RTMENT AT 800.933.7452 NOTH ) READ AND FOLLOW THE WAR	IKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND CT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- HING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION RNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- RODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



Coverage

10.1	oz Cartrio	lge: Yield	in Linear	feet
	)epth	1/4"	3/8"	1/2"
	1/4"	24.3		
	3/8"	16.2	10.8	
_	1/2"	12.1	8.1	6.1
Width	3/4"	8.1	5.4	4.0
_	1"			3.0
	1.25"			2.4
	1.5"			2.0

### How to Use

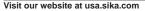
How to Use	
Surface Preparation	Clean all surfaces. Joint walls must be sound, clean, dry, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter mustbe thoroughly removed. A roughened surface will also enhance bond.
Priming	Priming is not usually necessary for anodized aluminum, steel, non-absorbent materials such as glass, ceramics, stoneware and tiles. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure. Consult Technical Service at 1-800-933-SIKA for additional information on priming.
Application	Recommended application temperatures: 40°-100°F. For cold weather application, condition material to 65°-75°F before using.
	Place nozzle of gun into bottom of the joint and fill entire joint. Keep the nozzle in the sealant; continue on with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping of sealant to eliminate entrapment of air.
Tooling and Finishing	Tool as required. Joint dimension should allow for 1/4 inch minimum and 1/2 inch maximum thickness for sealant. Proper design is 2:1 width to depth ratio.
Removal	In case of spills of leaks, wear suitable protective equipment, contain spill, collect with absorbent material, and transfer to suitable container. Ventilate area. Avoid contact. Dispose of in accordance with current, applicable local, state, and federal regulations. In case of emergency, call chemtrec 1-800-424-9300.
Over Painting	Allow 5 day cure at standard conditions when using Sikaflex-11 FC in total water immersion situations and prior to painting.
Limitations	<ul> <li>Allow 5 day cure at standard conditions when using Sikaflex-11 FC in total water immersion situations and prior to painting.</li> <li>Avoid exposure to high levels of chlorine. (Maximum level is 5ppm).</li> <li>Maximum depth of sealant must not exceed 1/2 in.; minimum depth is 1/4 in.</li> <li>Maximum expansion and contraction should not exceed 12.5% of average joint width.</li> <li>Avoid contact with alcohol and other solvent cleaners during cure.</li> <li>Do not apply when moisture-vapor-transmission condition exists from the substrate as this can cause bubbling within the sealant.</li> <li>Use opened cartridges the same day.</li> <li>When applying sealant, avoid air-entrapment.</li> <li>Since system is moisture-cured, permit sufficient exposure to air.</li> <li>White color tends to yellow slightly when exposed to ultraviolet rays.</li> <li>The ultimate performance of Sikaflex-11 FC depends on proper application, good design and proper preparation of joint surfaces.</li> <li>Not for use in expansion joints.</li> <li>Heavier substrates may require additional support during the cure period.</li> <li>Do not use in contact with bituminous/asphaltic materials.</li> </ul>
INSTRUST SHEET PARTM TO RE. RENT KEEPCON For furth actual Sa before us Prior to e Data She ment at 8	TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND UCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA I WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION AD AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Jona Information and S Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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 Image: Sika Structure St



Sika and Sikaflex are registered trademarks. Printed in Canada. Product Data Sheet Edition 2.19.2015 SikaBond Construction Adhesive

## **SikaBond<sup>®</sup> Construction Adhesive** One part advanced polyurethane, elastomeric adhesive

Description	SikaBond Construction Adhesive is a one-component, gun-grade, adhesive and sealing compound of permanent elasticity. This dual-purpose material is based on a special moisture-cured polyure-thane with an accelerated curing time.
Where to Use	As an elastic adhesive for: Paver caps, masonry veneer and Faux stone. Cover plates, gaskets and coverings. Acoustic ceiling tiles. Floor moldings and door sills. Light weight construction materials. Wood, metal, or plastic window and door frames. Roof tiles. As an elastic joint sealer for:
	<ul> <li>Air ducts and high vacuum systems.</li> <li>Containers, tanks, and silos.</li> <li>Gaskets in openings in walls or floors for ducts, piling, etc.</li> <li>Reservoirs or water retaining structures.</li> <li>Aluminum fabrication.</li> <li>Bolted lap joints.</li> </ul>
Advantages	<ul> <li>Excellent adhesion on all cement-based materials, brick, ceramics, glass, metals, wood, epoxy, polyester, acrylic resin, and plastics.</li> <li>Fast cure rate.</li> <li>Waterproof and water immersible after cure.</li> <li>Good weathering resistance.</li> <li>Non-corrosive.</li> <li>Can be painted over with water, oil, and rubber-based paints. (Preliminary tests recommended).</li> <li>High durability.</li> </ul>
Coverage	10.1 fl. oz. cartridge seals 12.2 lineal ft. of 1/2 x 1/4 in. joint.
Packaging	10.1 fl. oz. cartridge seals 12.2 lineal ft (3.72 lin m) of 1/2 x 1/4 in. joint (1.27 x 0.64 cm); 29 oz. cartridge seals 35 lineal ft. (10.7 lin.m.) of 1/2 x 1/4 in. joint
1	

#### **Typical Data** (*Material and curing conditions* @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf life	10.1 oz 12 months in unopened container, 29 oz 12 months in unopened container
Storage Conditions	Store in dry warehouse conditions between 40°F and 80°F. For cold weather application, condition material to 65°-75°F before using.
Color	Gray
Application Temp	40° to 100°F
Service Range	-40° to 170°F
Final Cure	3 to 5 days
Weathering Resistance	Excellent
Chemical Resistance	Good resistance to water, weak acids, weak alkalis, sewer- age, mineral oils, vegetable oils, fats, and fuels. (Not resistant to organic solvents, paint thinner, strong acids, strong alkalis). Consult Technical Service for specific data.



Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure. Consult Technical Service at 800-933-7452 for additional information on priming. Clean all surfaces. Joint walls must be sound, clean, dry, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter must be thoroughly removed.
Priming is not usually necessary for anodized aluminum, steel, non-absorbent materials such as glass, ceramics, stoneware and tiles. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure. Consult Technical Service for additional nformation on priming.
Cut plastic tip to desired size and puncture airtight seal at base of tip. Force adhesive onto bonding surface. Use as spread, bead or for spot bonding. Recommended application temperatures: 40°-100°F.
Wait a minimum of 1 week and test for compatibility before painting.
Tack free in 1-2 hours, depending on climate. Final cure in 5-8 days.
<ul> <li>Allow a minimum of 1 week cure at standard conditions when using SikaBond Construction Adhesive in total water immersion situations and prior to painting.</li> <li>Avoid exposure to high levels of chlorine. (Maximum level is 5 ppm).</li> <li>Avoid contact with alcohol and other solvent cleaners during cure.</li> <li>Not for expansion joints.</li> <li>Heavier substrates may require additional support during the cure period.</li> <li>Do not use on tar, bituminous or asphaltic-based surfaces.</li> </ul>

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

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# Sikaflex<sup>®</sup> Sealant/Adhesive Primers

Sikaflex Primers 260, 429, and 449

Description	Sikaflex primers are special materials formulated to improve the bond of Sikaflex urethane sealants when applied to specific substrates.
Sikaflex Primer 260	Sikaflex Primer 260 promotes adhesion of urethane sealants to various metallic, non-metallic, and plastic substrates.
Sikaflex Primer 429	Sikaflex Primer 429 promotes adhesion to clean, sound, and dry concrete, masonry, Exterior Insulation Finish Systems (EIFS), and wood — including teak and mahogany.
Sikaflex Primer 449	Sikaflex Primer 449 is used to promote adhesion to pvc, solvent-based enamel, PPG's fluorocarbon Duranar-finish, and certain plastics such as ABS and Plexiglass.

Substrate	Primer Required	Recommended primer if necessary
Concrete and Masonry		
Concrete Block	No	Sikaflex 429 primer
Placed Concrete	No	Sikaflex 429 primer
Precast Concrete	No	Sikaflex 429 primer
Mortar	No	Sikaflex 429 primer
Grout	No	Sikaflex 429 primer
Brick	No	Sikaflex 429 primer
SikaTops	No	Sikaflex 429 primer
Stone		
Granite	No	Sikaflex 429 primer
Marble	No	Sikaflex 260 primer
Paints		
Acrylic Latex	No Bone	d Achieved
Emercoat 33	No Bone	d Achieved
DeSoto Fluoropon	No Bone	d Achieved
PPG Duracon S600	No Bone	d Achieved
Solvent-based Enamel	Yes	Sikaflex 449 primer
PPG Fluorocarbon	Yes	Sikaflex 449 primer
Duranar	Yes	Sikaflex 449 primer
PPG Polycron	Yes	Sikaflex 449 primer
Kynar	Yes	Sikaflex 449 primer
Siliconized Polyester	Yes	Sikaflex 260 primer
Alucobond	Yes	Sikaflex 260 primer
Plastics		
PVC	Yes	Sikaflex 449 primer
ABS	Yes	Sikaflex 449 primer
Plexiglass	Yes	Sikaflex 449 primer
Plexiglass DR	Yes	Sikaflex 449 primer
Lucite	Yes	Sikaflex 449 primer
Rovel Plastic	Yes	Sikaflex 449 primer

Substrate	Primer Required	Recommended primer if necessary
Plastics cont'd		
Lexan	Yes	Sikaflex 260 primer
Teflon	No Bon	d Achieved
Polyethylene	No Bon	d Achieved
Polypropylene	No Bon	d Achieved
Tuffak	Yes	Sikaflex 449 primer
Polyester/Fiberglass	No	Sikaflex 449 primer
Glass		
Glass - Sheet, float or plate	No	Sikaflex 260 primer
Porcelain	No	Sikaflex 260 primer
Ceramic tile	No	Sikaflex 260 primer
Metals		
Aluminum - Anodized	No	Sikaflex 260 primer
Aluminum - Mill Finish	Yes	Sikaflex 260 primer
Lead	No	Sikaflex 260 primer
Copper (bright/clean)	No	Sikaflex 260 primer
Brass	No	Sikaflex 260 primer
Zinc	No	Sikaflex 260 primer
Tinplate	No	Sikaflex 260 primer
Steel (Bright/Clean)	No	Sikaflex 260 primer
Steel - Stainless	Yes	Sikaflex 260 primer
Steel - Galvanized	Yes	Sikaflex 260 primer
Rubber		
Urethane	No	Sikaflex 449 primer
Woods		
Unfinished Woods	No	Sikaflex 429 primer
EIFS**		
Dryvit	Yes	Sikaflex 429 primer
Sto	Yes	Sikaflex 429 primer
Synergy	Yes	Sikaflex 429 primer

#### **Typical Data** (*Material and curing conditions 73°F and 50% R.H.*) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf life	6 months in original, unopened containers.
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F
	before using.
Color	Clear



Where to Use	Most substrates require a primer after cure. Certain substrates do	, ,	need for it or where the sealant will be underwated er all conditions.
Advantages	<ul> <li>Single-component,</li> </ul>	ready to use.	
Ū	<ul> <li>Easily applied by br</li> </ul>	rush, dauber, or spray	
Coverage	Following are average coverage	s, depending on poros	sity of substrate:
Ū.		age per pint (Liner ft	•
	260		300-500
	429		300
	449		300-500
Packaging	Sikaflex 260 and 449 primers a	re available in pints, 6	/carton.
	Sikaflex 429 primer is available	in pints, 6/carton; and	I gallons, 2/carton.
How to Use			
Surface Proparation	The key to good bonding with Si	kaflov applants/primo	ra is surface proparation. Specifically, all surfaces
Surface Preparation	must be dry and free of dirt, great the joint contains old sealant, it a	ase, mold release age and all extraneous ma	rs is surface preparation. Specifically, all surfaces nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost free
Surface Preparation	must be dry and free of dirt, grea the joint contains old sealant, it a mechanical means. Apply primer	ase, mold release age and all extraneous ma rs at substrate temper	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned
	must be dry and free of dirt, grea the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before u	ase, mold release age and all extraneous ma rs at substrate temper	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray.
	must be dry and free of dirt, grea the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before u	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray. Ing sealant
	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before to <b>Sikaflex Primer Dry tin</b>	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle <b>me before installin</b>	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.*
	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before to Sikaflex Primer Dry tin 260	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle me before installin >1 hr.	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.*
	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before to Sikaflex Primer Dry tin 260 429	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle me before installin >1 hr. >1 hr. >30 min.	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.* <8 hrs.* <8 hrs.*
	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before to Sikaflex Primer Dry tin 260 429 449 * If sealant cannot be installed w	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle me before installin >1 hr. >1 hr. >30 min.	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fro ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.* <8 hrs.* <8 hrs.* ng, reprime.
Application	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before u Sikaflex Primer Dry tin 260 429 449 * If sealant cannot be installed w • Primer should not b	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle <b>me before installin</b> >1 hr. >1 hr. >30 min. vithin 8 hours of primir we used if it starts to ge	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fro ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.* <8 hrs.* <8 hrs.* ng, reprime.
Application	must be dry and free of dirt, great the joint contains old sealant, it a mechanical means. Apply primer Shake or stir primer well before to Sikaflex Primer Dry tin 260 429 449 * If sealant cannot be installed w Primer should not b Protect Sikaflex primi immediately.	ase, mold release age and all extraneous ma rs at substrate temper using. Apply to dry, cle <b>me before installin</b> >1 hr. >1 hr. >30 min. vithin 8 hours of primir we used if it starts to ge	nts, loose mortar, laitance, and any foreign matter. terial must be removed and the substrate cleaned atures of 40°F and rising. Surface must be frost fre ean, oil free surface with a brush, dauber or spray. <b>Ig sealant</b> <8 hrs.* <8 hrs.* <8 hrs.* ng, reprime. el in container.

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# Sikasil<sup>®</sup> Primer-2100

Sikasil silicone primer

Description Sikasil Primer 2100 is used to promote adhesion of Sikasil silicone sealants to a variety of construction materials such as stone, masonry, metal, coated glass and plastics. Packaging 8 fl. oz. (240 ml) container, 33 fl. oz. (1 L) container Typical Data (Material and curing conditions @ 77°F {25°C} and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Shelf Life 18 months in unopened packaging **Storage Conditions** When stored in the original, unopened containers at or below 90°F (32°C), Sikasil Primer-2100 has a shelf life of 18 months from the date of manu facture. Color Clear Odor solvent odor **Physical State** Liquid **Specific Gravity** 0.76 Viscosity 1 cps **VOC Content** 748 g/L **Recommended Dry Time** 15-30 min. Test results are averages obtained under laboratory conditions. Reasonable variations can be expected. How to Use For best bonding results, the following steps should be taken when using Sikasil Primer-2100. Application 1. Thoroughly clean all surfaces of dust, dirt, tar, oils and other debris. Remove rust and scale from metal surfaces by abrasive cleaning or wire brushing. Masonry surfaces must clean dry and sound and prepared by mechanical means. 2. For cleaning non-porous substrates, use two cloth wipe method using xylene or an approved commercial solvent. Strictly follow solvent manufacturer's instructions for use and warnings. Allow solvent to evaporate prior to sealant application. 3. Apply Sikasil Primer-2100 to clean, dry surfaces by brushing or spraying before installation of backer rod. A coverage rate of about 400 square feet per gallon is recommended on rough or porous substrates. On smooth metal surfaces, a coverage rate of 800 square feet per gallon is possible. 4. For non-porous substrates, allow the primer to dry a minimum of 15 minutes or until all the solvent evaporates. If a white film is noted, remove excess primer with a clean dry cloth then apply sealant. For porous substrates, allow primer to dry 30-60 min. For EIFS substrates, apply a heavy coat in two directions at a minimum rate of 400 square feet per gallon. A light white primer stain should be visible. Drying time depends on temperature, humidity conditions and the porosity of the substrate. 5. Apply sealant as directed within eight hours or cleaning and re-priming will be required Limitations Containers should be kept tightly sealed when not in use. Sikasil Primer-2100 hydrolyzes on contact with atmospheric moisture and prolonged exposure will reduce or destroy its effectiveness. When hydrolyzed, the primer will appear milky in color, do not use. Sikasil sealants must be applied within 8 hours of priming with Sikasil Primer-2100 or cleaning and repriming will be required.



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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

 
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Product Data Sheet Edition 2.9.2015 Sika Boom

# Sika<sup>®</sup> Boom<sup>®</sup> One-component, polyurethane foam

Description	Sika Boom is a pre-pressurized, portable, one-component, polyurethane foam system applied in a bead form. Sika Boom expands and cures slowly to a semi-rigid, closed cell foam upon reaction with moisture, such as ambient humidity. It is designed for easy dispensing through a straw adapter that is included with each can.
Advantages	Sika Boom provides the following beneficial properties:
	<ul> <li>Dries tack-free in approximately 8-10 minutes or less depending on moisture and temperature conditions.</li> </ul>
	Fully cures within 24 hours.
	Cured foam can be sanded, painted or stained.
	Cured foam is resistant to heat and cold.
	Adheres to most building materials.
	Expands 2 to 3 times its original size.
Where to Use	<ul> <li>On any clean surface to fill, insulate and seal around gaps, beneath base plates, muds sills, top plate penetrations, corner joints, T-joints, exterior cracks, around utility panels, pipes, duct penetrations, etc.</li> </ul>
	For dispensing as a bead for filling cracks, crevices, and to fill smaller cavities.
Yields	1/4" Bead (6 mm) = 1,760 ft. (536 m)
	3/8" Bead (9 mm) = 780 ft. (238 m)
	1/2" Bead (12 mm) = 440 ft. (134 m)
Packaging	12 oz. can, 12/carton. 20 oz. can, 12/carton

#### **Typical Data** (*Material and curing conditions* @ 70°F and 40% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,

TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	18 months.		
Storage Conditions	Store in a cool, dry area. Do not expose to open flame or temperatures above 120°F (49°C). Store at room temperature before use.		
Application Tempera	ature 40°F (1	8°C) and 120°F (38°C)	
Service Range	-200°F to 200°F (-29	°C to 93°C)	
Core Density	1.2 lbs/ft <sup>3</sup> (19.2 kg/m <sup>3</sup> )		
R-factor	4-5 per inch (.03 w/m	n.k) typically	
Closed cell content	(ASTM D-2856)	>70% (typically)	
Tack-Free Time	Approx. 10 minutes		
Cure Time	12-24 hours		
Cuttable (1" Bead at room conditions)		1 hour	
ASTM E-84 (12.5%)	Flame Spread	25	
	Smoke Developed	50	



Substrate Prep	Substrate must be clean, firm, free of loose particles and free of dust, grease, mold release agents. Protect surfaces not to be foamed. Shake can before using. For best results in cavities larger than 3 inches in diameter, dampen substrate to supplement atmospheric pressure humidity in affecting consistent cure throughout applied foam.
Application	After following instruction for set-up, can is ready to use. The foam sealant flow can be me- tered by means of tilting the one piece straw adapter with the valve pointing downwards. By activating the adapter lever carefully, the extrusion rate can be regulated. Foam application can be interrupted when needed, as outlined in the instructions. Sika Boom is especially usefu for irregular voids and on nonlinear cracks and crevices, as foam will expand up to 200% dur- ing curing process. Filling excessively large cavities can result in a prolonged curing process. Also, insufficient air or substrate moisture during cure may cause delayed expansion.
Limitations	<ul> <li>Not resistant to UV rays unless painted, covered or coated.</li> <li>Will not adhere to polyethylene, Teflon, silicone, oils and greases, mold release agents and similar materials.</li> <li>Do not expose to open flame or temperatures above 120°F (49°C). Excessive hea can cause shorter shelf life.</li> <li>Not intended as a firestop.</li> <li>Do not use where temperatures rise above 240°F (116°C).</li> </ul>

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Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera

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**Product Data Sheet** Edition 4.6.2016 Identification no. Sika<sup>®</sup> Duoflex<sup>®</sup> NS



# Sika<sup>®</sup> Duoflex<sup>®</sup> NS

Two-Component, Non Sag, Polysulfide Sealant

				ag, premiun	n-quality pol	ysulfide seal	ant, specifica
<ul> <li>Joints i</li> <li>Joints i</li> <li>Expans</li> <li>Joints i</li> <li>Perime</li> </ul>	n precast con n glass and r ion and cont n metal sidin ters of alumi	ncrete. netal curtair rol joints in Ig. inum windov	n wall constru concrete and w frames and	uction. I masonry w I metal pane	alls.	atic and dynai	nic joints:
<ul> <li>Remair cohesiv</li> <li>Stays re</li> <li>Excelle</li> <li>Tenacic combin</li> <li>Effectiv</li> <li>Certifie</li> </ul>	ns flexible wi re failure, ba esilient withi nt resistance bus adhesion ation, typica re under con ed under NSF	th expansion sed on good n a wide ter to water, o to concrete Illy without t stant immer (ANSI Meth	joint design nperature ra ils, grease, m e, metal, woo the need for rsion or satur od 61 and U	nge. ost solvents d, glass, sto priming with ated condition	, mild acids ne, ceramic n Sika Duofle ions, when s	and alkalis. and masonry x 5050 Prime uitably prime	surfaces in ar r.
Coverage b	ased on linea	ar feet of sea	alant per gall	on:			-
Width	<b> </b>	· · · · ·	1	epth	- <u>1</u>		1
in (mm)	0.25 (6)	0.5 (13)	0.75 (19)	1 (25)	1.25 (32)	1.5 (38)	
0.25 (6)	307.7				_		
· · ·	153.8	76.7					
0.75 (19)	102.8	51.0	34.8				
1 (25)	76.7	38.6		19.6			
1.25 (32)	61.9	31.0	21.2	14.7	12.5		4
1.5 (38)	51.0	26.1	17.4	12.5	9.8	8.7	]
1.5 gallon (	5.7 liter) unit	i		art)			
(see Sika Du	uoflex chemi	cal resistanc	e chart)				
RESULTS MAY APPLICATION Self Life	Y DIFFER BASED UF I METHODS, TEST I	PON STATISTICAL	ARIATIONS DEPEN	IDING UPON MIXI S AND CURING CO in original, un	NG METHODS AND NDITIONS. Opened packa	ging.	PERATURE,
Product C Color	onditioning		Conditi conditi when v Bronze	on material to oning units to vorking at the	o 40 to 100°F l approximatel	before applicat y 70°F (21°C) i	s necessary
Properties Pot Life	s at 73°F (23°	C) and 50% R.	. <b>H.</b> 1 hr				
	designed for Sika® Duofil Joints i Joints i Perime Joints l Perime Joints l Tough, Remair cohesiv Stays ru Excelle Tenacic combin Effectiv Certifie Coverage b Width in (mm) 0.25 (6) 0.5 (13) 0.75 (19) 1 (25) 1.25 (32) 1.5 (38) 1.5 gallon (1 (see Sika Du Self Life Storage Co Product C	designed for vertical and Sika® Duoflex is suitable Joints in precast cou Joints in glass and r Expansion and cont Joints in metal sidin Perimeters of alumi Joints located in gas Tough, elastic, rubb Remains flexible wi cohesive failure, ba Stays resilient withi Excellent resistance Tenacious adhesion combination, typica Effective under con Certified under NSF Coverage based on linea Width in (mm) 0.25 (6) 0.25 (6) 307.7 0.5 (13) 153.8 0.75 (19) 102.8 1 (25) 76.7 1.25 (32) 61.9 1.5 (38) 51.0 1.5 gallon (5.7 liter) unita (see Sika Duoflex chemi Self Life Storage Conditions Product Conditioning Color UV Color Stability Properties at 73°F (23°C	designed for vertical and overhead size Sika® Duoflex is suitable for either eff Joints in precast concrete. Joints in glass and metal curtain Expansion and control joints in Joints in metal siding. Perimeters of aluminum window Joints located in gas stations /ref Tough, elastic, rubber-like seal. Remains flexible with expansion cohesive failure, based on good Stays resilient within a wide ter Excellent resistance to water, o Tenacious adhesion to concrete combination, typically without f Effective under constant immer Certified under NSF/ANSI Meth Coverage based on linear feet of sea Width in (mm) 0.25 (6) 0.5 (13) 0.25 (6) 307.7 0.5 (13) 153.8 76.7 0.75 (19) 102.8 51.0 1 (25) 76.7 38.6 1.25 (32) 61.9 31.0 1.5 (38) 51.0 26.1 1.5 gallon (5.7 liter) unit (see Sika Duoflex chemical resistance Typical Data (Material and curing coor RESULTS MAY DIFFER BASED UPON STATISTICAL WARD STATIST	designed for vertical and overhead surfaces. Sika® Duoflex is suitable for either exterior or int Joints in precast concrete. Joints in glass and metal curtain wall constru Expansion and control joints in concrete and Joints in metal siding. Perimeters of aluminum window frames and Joints located in gas stations /refueling envir Tough, elastic, rubber-like seal. Remains flexible with expansion and contrate cohesive failure, based on good joint design. Stays resilient within a wide temperature ra Excellent resistance to water, oils, grease, m Tenacious adhesion to concrete, metal, wood combination, typically without the need for Effective under constant immersion or satur Certified under NSF/ANSI Method 61 and US Coverage based on linear feet of sealant per gall Width	designed for vertical and overhead surfaces.         Sika® Duoflex is suitable for either exterior or interior use to         Joints in precast concrete.         Joints in glass and metal curtain wall construction.         Expansion and control joints in concrete and masonry w         Joints in metal siding.         Perimeters of aluminum window frames and metal pane         Joints located in gas stations /refueling environments.         Tough, elastic, rubber-like seal.         Remains flexible with expansion and contraction of build cohesive failure, based on good joint design.         Stays resilient within a wide temperature range.         Excellent resistance to water, oils, grease, most solvents         Tenacious adhesion to concrete, metal, wood, glass, stor combination, typically without the need for priming with         Effective under constant immersion or saturated condition (certified under NSF/ANSI Method 61 and USDA accepta         Coverage based on linear feet of sealant per gallon:         Width       Depth         in (mm)       0.25 (6)       0.5 (13)       0.75 (19)       1 (25)         0.75 (19)       102.8       51.0       34.8       1 (25)       1.5 (38)       51.0       2.6.1       1 9.6         1.25 (32)       61.9       31.0       21.2       14.7       1.5 (38)       51.0       2.6.1       1 9.6	designed for vertical and overhead surfaces.         Sika* Duoflex is suitable for either exterior or interior use to seal both state Joints in glass and metal curtain wall construction.         Expansion and control joints in concrete and masonry walls.         Joints in metal siding.         Perimeters of aluminum window frames and metal panels.         Joints located in gas stations /refueling environments.         Tough, elastic, rubber-like seal.         Remains flexible with expansion and contraction of building compor cohesive failure, based on good joint design.         Stays resilient within a wide temperature range.         Excellent resistance to water, oils, grease, most solvents, mild acids :         Tenacious adhesion to concrete, metal, wood, glass, stone, ceramic a combination, typically without the need for priming with Sika Duofle         Effective under constant immersion or saturated conditions, when s         Coverage based on linear feet of sealant per gallon:         Width       Depth         in (mm)       0.25 (6)       0.5 (13)       0.75 (19)       1 (25)       1.25 (32)         0.5 (13)       153.8       76.7       1       1       1         0.5 (13)       102.8       51.0       34.8       1       1       1       1       1       1       1       1       1       1       1       1       1       2.5	Sika® Duoflex is suitable for either exterior or interior use to seal both static and dynar         Joints in precast concrete.         Joints in glass and metal curtain wall construction.         Expansion and control joints in concrete and masonry walls.         Joints in metal siding.         Perimeters of aluminum window frames and metal panels.         Joints located in gas stations /refueling environments.         Tough, elastic, rubber-like seal.         Remains flexible with expansion and contraction of building component without a cohesive failure, based on good joint design.         Stays resilient within a wide temperature range.         Excellent resistance to water, oils, grease, most solvents, mild acids and alkalis.         Tenacious adhesion to concrete, metal, wood, glass, stone, ceramic and masonry combination, typically without the need for priming with Sika Duoflex 5050 Prime         Effective under constant immersion or saturated conditions, when suitably prime         Certified under NSF/ANSI Method 61 and USDA acceptance (NS grade only).         Coverage based on linear feet of sealant per gallon:         Width       Depth         in (mm)       0.25 (6)       0.5 (13)       0.75 (19)       1 (25)       1.25 (32)       1.5 (38)         0.5 (13)       153.8       76.7       38.6       26.1       19.6       1         1/25 32       61.9       31.0       21.2

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Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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**Product Data Sheet** Edition 9.6.2015 Identification no. Sika<sup>®</sup> Duoflex<sup>®</sup> SL

# Sika<sup>®</sup> Duoflex<sup>®</sup> SL

Two-Component, Self Leveling, Polysulfide Sealant

Description		cation to hor			premum-qt	aanty polysu	lfide sealant id	cany suit
Where to Use	Sika* Duoflex SL is suitable for either exterior or interior use in both static and dynamic joints:							
	<ul><li>Joints i</li><li>Expans</li><li>Joints i</li></ul>	ion and cont n podium de ion joints in n gas station nt to chlorin	ck structure tile and bric s / refueling	s. k flooring. environmer	nts			
Advantages	<ul> <li>Remain cohesin</li> <li>Stays r</li> <li>Excelle</li> <li>Tenacin combi</li> <li>Effective</li> </ul>	ve failure, bas esilient withi nt resistance bus adhesion nation, typica ve under cons	th expansion sed on good n a wide ter to water, o to concrete ally without stant immer	joint design nperature ra ils, grease, m e, metal, woo the need for sion or satur	nge. nost solvents od, glass, sto r priming. rated conditi	, mild acids a ne, ceramic	nent without ad and alkalis. and masonry s uitably primed	urfaces in
Coverage		ased on linea	ar feet of se					
	Width	0.05 (6)	0.5 (12)	1	Depth	4.25 (22)	4.5 (20)	
	in (mm) 0.25 (6)	0.25 (6)	0.5 (13)	0.75 (19)	1 (25)	1.25 (32)	1.5 (38)	
	0.25 (8)	307.7	76.7					
	0.75 (19)	153.8	76.7 51.0	34.8				
	1 (25)	76.7	38.6	26.1	19.6			
	1.25 (32)	61.9	31.0	21.2	19.0	12.5		
	1.5 (38)	51.0	26.1	17.4	12.5	9.8	8.7	
Packaging	1.5 gallon (	5.7 liter) unit	:			0		·
Chemical Resistance		uoflex chemi		e chart)				
	Color UV Color	ON METHODS, TES	UPON STATISTICA	L VARIATIONS DEP UAL SITE CONDITION 1 yea Store Cond cond wher Bron Very	ending UPON M DNS AND CURING ar in original, t e dry between lition material itioning units n working at tl	IXING METHODS A CONDITIONS. unopened pact 40 and 95°F to 40 to 100° to approximat	0 0	ion. Pre- is necessar
	Pot Life Tack Free Full Curr Testing Applicat	e Standards ion Temperati	ure	1 hr 6 hrs 7 day ASTN 39 to Seala antic -40 tr ± 259	/s A C920, Class 2 ant should be ipated moven o 170°F (-40 t	38°C), ambient installed wher nent.	and substrate to joint is at mid-r	

Construction



How to Use	
Surface Preparation	All joint surfaces must be clean, sound, dry and frost-free. Joint walls must be free of oils, grease, paints coatings, sealers, curing compound residues, and any other foreign matter that might prevent adhesior This should be accomplished by mechanical means (e.g. sandblasting, abrasive grinding, etd.). Bon breaker tape or backer rod must be used in bottom of joint to prevent bond.
	Joint Design Proper joint design for moving joints is 2:1 width to depth ratio, with a recommended 1/4" (6 mm minimum and 1/2" (13 mm) maximum depth of sealant. For non-moving joints, the width to dept ratio can vary.
	<b>Priming</b> For maximum adhesion, including in submerged or immersed applications, the use of Sika® Duofle 5050 Primer is necessary. Consult your Sika Technical Service Representative if unsure if primer is nece essary. A uniform glossy sheen after priming indicates adequate primer. Some surfaces, such as porou concrete, may require two coats. Primer must be tack-free before applying sealant, typically 2 hrs of concrete and 4 hrs on steel at 77°F (25°C). Sealant must be applied same day as primer. Primed area left overnight should be re-primed.
Mixing	Pour entire contents of Component B into pail of Component A and mix using a low speed drill (100 300 rpm) and Sika mixing paddle. Mix for 3-5 minutes to achieve uniform color and consistency. Scrap down sides of pail periodically. Avoid entrapment of air during mixing.
	Mixed material must be used within the pot life parameters given. Do not attempt to thin or use material that has started to harden. The individual components are formulated, manufactured and shippe to be used together.
	When mixed in cold weather (<50 degF), do not force the mixing paddle to the bottom of the pail. After adding Component B in Component A, mix the top 1/2 to 3/4 of teh pail in the first minute of mixing After scraping down the sides of the pail, mix again for another minute. The paddle should reach th bottom of the pail between the first and second minute of mixing. Scrap down the sides of the pail second time and then mix for an additional 2-3 minutes until sealant is well blended.
Application	Recommended application temperatures 40 to 100°F (4 to 38°C). Pre-conditioning units to approximatel 70°F (21°C) is necessary when working at the far ends of the application range. Move pre-conditione units to work areas just prior to application. Apply sealant only to clean, sound, dry, and frost-fre substrates. Sika® Duoflex SL should be applied into joints when joint slot is at mid-point of its designe expansion and contraction. To place, load directly into bulk gun or use a follower plate loading system Place nozzle of gun into end of joint and fill entire joint. Keeping the nozzle deep in the sealant, cor tinue with a steady flow of sealant preceding nozzle to avoid air entrapment. Also, avoid overlappin of sealant since this also entraps air. On floor joints, properly recess the sealant to avoid material over the surface plane. Dry tool as required.
Limitations	<ul> <li>Do not use the B component from NS with the A component for SL and vice versa.</li> <li>The ultimate performance of Sika Duoflex SL depends on good joint design and proper applicatio</li> <li>Primary and secondary immersion applications; Sika® Duoflex® Primer must be used</li> <li>Do not apply when moisture vapor transmission exists since this can cause bubbling within the sealant</li> <li>When overcoating: an on-site test is recommended to determine actual compatibility.</li> </ul>
	<ul> <li>Not suitable for:</li> <li>Joint movement more than 25%.</li> <li>Glazing applications.</li> <li>Improperly prepared or contaminated surfaces.</li> <li>Joints involving adhesion to painted surfaces.</li> </ul>



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Sika Mexicana S.A. de C.V.

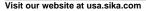
Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

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Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.





**B330** 

Product Data Sheet Edition 7.23.2014 Identification no. Sika<sup>®</sup> Duoflex<sup>®</sup> Primer 50/50

## Sika<sup>®</sup> Duoflex<sup>®</sup> 5050 Primer

Sika Duoflex 5050 Primer is a two component, low viscosity, adhesion-promoting, epoxy primer for use with Sika

Description	Sika <sup>®</sup> Duoflex <sup>®</sup> Primer 5050 is a two-component, low-viscosity, adhesion-promoting epoxy primer for Sika <sup>®</sup> Duoflex <sup>®</sup> polysulphide sealants.		
Where to Use	To promote adhesion to porous and dense substrates, including concrete and metal, prior to installing Sika <sup>®</sup> Duoflex <sup>®</sup> NS/SL.		
Advantages	<ul> <li>Two-component 1:1 volume ratio</li> <li>Low viscosity: easy to apply by brush.</li> <li>Fast drying time; allowing earlier sealing.</li> <li>Minimizes downtime; quicker use of joint.</li> <li>Maximizes adhesion; enhances durability</li> <li>Low VOC contents</li> </ul>		
Coverage	Yield Concrete: 700 – 800 lin. ft./unit (210 – 240 lin. m/unit) at 3-5 mils/coat		
Packaging	1/4 gal. (0.95 L) unit		

Typical Data (Material and curing conditions @ 73°F and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Self Life	1 year in original, unopened packaging.
Storage Conditions	Store dry between 65 and 80°F (18 and 27°C).
Color	Part A: (Resin) Clear Part B: (Hardener) Amber
Yield: Concrete Steel	700 – 800 lin. ft./unit (210 – 240 lin. m/unit) at 3-5 mils/coat 1100 – 1300 lin. ft./unit (335 – 395 lin. m/unit) as 2-3 mils coat
Application Temperature: Ambient Substrate	40 to 95°F (5 to 35°C) 41°F (5°C) above dew point
Mix Ratio	1:1 by volume
Volume Solids	65%
Pot Life	3 hours
Waiting Time before Sealing: Concrete Steel	Min. 2 hours /Max. 36 hours Min. 4 hours /Max. 36 hours
VOC Content	50 g/L
Note:	Material cures more slowly at cooler temperatures, and wor- king time will be substantially reduced at higher temperatures. In hot weather, material should be cooled to between 65 and 80°F (18 and 27°C) prior to mixing and application to improve workability and avoid shortened pot life.



	How to Use	
	Surface Preparatio	compounds, oils, greases or any other contaminants which would impede penetration or adhesion. All surface irregularities, including cracks or substrate details, such as expansion joints and control joints, should be properly addressed prior to application. New concrete should be cured a minimum of 28 days with laitance and any weak surface layers removed. Concrete that has been contaminated with chemicals or other foreign matter must be neutralized or
		<ul> <li>removed.</li> <li>Concrete should have a minimum surface tensile strength of at least 300 psi (2 MPa) as per ASTM D4541 and a surface profile of CSP 3-5 (a profile equal to 60-grit sandpaper, or coarser) in accordance with the International Concrete Repair Institute (ICRI) standard guideline #03732 for coating concrete. Prepare surface by mechanical means to achieve this desired profile.</li> <li>Concrete surfaces potentially subject to out-gassing should be primed when the temperature of the substrate is dropping. Alternatively, double priming will greatly reduce the effects of out-gassing by additionally filling the pores in the concrete.</li> <li>Steel: For service in an immersed environment, abrasive blast with an anchor profile of 2 - 4 mils in accordance with Steel Structures Painting Council Specification SP-5-63 or NACE No. 1, to achieve a "White Metal" finish. For splash and spillage exposure, "Near White" SP-10-63 or NACE No. 2 is required.</li> </ul>
	Mixing	Individually stir the contents of each component of Sika <sup>®</sup> Duoflex Primer 5050 until a uniform con- sistency and colour has been produced in each. Pour contents of Component B into the container in which Component A is held and thoroughly mix using a low speed drill and jiffy paddle for a minimum of 2 minutes until the blended liquid is of a consistent color (no streaking) and uniform consistency. Mix no longer than 3 minutes. <b>Note:</b> When initially pouring Component B into Component A, ensure all hardener is emptied from the container into the resin. While mixing, use a suitable tool to scrape the side and bottom of the container in which the blended components are held to ensure the entire product has been properly mixed. Any unmixed material will not cure and will potentially cause the subsequent installation of Sika <sup>®</sup> Duoflex NS/SL sealants to fail
	Application	Apply Sika® Duoflex® Primer 5050 by brush at approximately 700 - 800 lin. ft./unit (210 - 240 lin. m/ unit) as 3-5 mils coat onto concrete and 1100 - 1300 lin. ft./unit (335 - 395 lin. m/unit) as 2-3 mils coat onto steel. Sika® Duoflex® Primer 5050 must be dry to the touch, following a drying time of typically 2 hours at 73°F (25°C) on concrete and 4 hours at 73°F (25°C) on steel. Do not allow the waiting time to exceed 36 hours before proceeding with the installation of Sika® Duoflex® NS/SL sealants. Where the maximum waiting time is exceeded, do not seal but contact Sika Corp, Technical Services for guidance <b>Note:</b> Observe the above waiting times after priming and before installation of the sealant. Installation of the sealant too soon or too late will jeopardize the adhesion and performance of Sika® Duoflex® NS/ SL.
	Limitations	<ul> <li>Do not thin with solvents</li> <li>Confirm with Sika Corp. that the product is suitable for specific chemical environments, prior to use.</li> <li>Prepare substrate according to "Surface Preparation" portion of this document.</li> <li>Minimum application temperature of 40°F (5°C) above dew point must be observed; do not apply onto damp surfaces.</li> <li>Moisture content of substrates must be &lt; 4% (Tramex meter reading) and vapor transmission should be 3 pounds or less per 1000 square feet over 24 hours as confirmed through appropriate ASTM testing and quantitative relative humidity (RH) testing should confirm concrete RH results of &lt; 75%.</li> <li>For industrial and commercial use only; to be handled by experienced or trained personnel only.</li> <li>For use only with Sika® Duoflex® sealants, as supplied by Sika Corp.</li> </ul>
		PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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ſ	fr p s tt E S S S	The table solution of the obligation to read and follow the warnings and instruction or each Sike product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to roduct use. SiKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shell life. User determines suitability of product for intended use and assumes all risks. Super's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA HALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR HALLS OF SIKA PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELECTUAL PROPERTY RIGHTS HELD BY OTHERS. AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.
f1		Sika Corporation       Sika Canada Inc.       601 Delmar Avenue       Sika Canada Inc.       601 Delmar Avenue       Carretera Libre Celaya Km. 8.5       Fracc. Industrial Balvanera         Lyndhurst, NJ 07071       Phone: 800-933-7452       Fax: 201-933-6225       Phone: 514-697-2610       Fracc. Industrial Balvanera       C.P. 76920         Fax: 514-694-2792       Phone: 52 442 2385800       Fax: 52 442 2250537       Estonsible Calific       Estonsible Calific



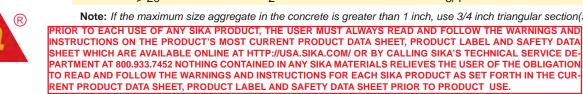
B340

Product Data Sheet Edition 10.30.2014 SikaSwell S-2

### SikaSwell<sup>®</sup> S-2 One part polyurethane.

One part polyurethane, extrudable swelling waterstop (bentonite-free)

Description	swellable, one-comp for use in all kinds o	pecially formulated, high-performance conent, polyurethane-based watersto of construction joints. Swelling rubber ion seal within joint, blocking the	
Where to Use	<ul> <li>crete structures.</li> <li>Excellent for seali floor slabs.</li> <li>Excellent for seali</li> <li>May be applied to faces.</li> </ul>	struction joints in new watertight con- ing pipe penetrations through walls ar ing joints between precast elements. phorizontal, vertical and overhead sur it construction joints between new and	
Advantages	<ul> <li>water and wastew</li> <li>Permanently wate</li> <li>Capable of sealin</li> <li>Elastic-withstands</li> <li>Easy, simple appl</li> <li>Adaptable in the f</li> <li>No nails, glue, or</li> <li>Controlled expans</li> <li>Offers resistance</li> <li>Thixotropic prope</li> <li>Very economical.</li> <li>Saves labor by eliand tieing to reba</li> <li>No mixing require</li> <li>Allows more thore</li> </ul>	er resistant, with no leaching and does g construction joints with head pressu s wet/dry cycling. ication. ield to suit job requirements. hooks required. sion eliminates cracking in fresh conc to various chemicals. rties allow SikaSwell S-2 to seal irreg iminating inverted keyways, split form r associated with conventional PVC w	s not dissolve in water. ires of up to 50 psi (115 ft. head). rete. ular joint surfaces. ing, heat splicing, special fittings vaterstops.
	Typical Data (Mate	rial and curing conditions 73°F (23	°C) and 50% R.H.)
		UPON STATISTICAL VARIATIONS DEPENDING UPON METHODS, TEST METHODS, ACTUAL SITE CONDIT	
	Shelf life	9 months	
	Storage Conditions	For best results, store dry at 70°F (	20°C) before using.
	Color	Red	
	Temperature of Produ	ct for Best Application	50° to 90°F
	Tack Free Time		2-3 hours
		Swollen (7 days in tap water)	2-3 hours >10
		Swollen (7 days in tap water) Non Swollen (7 days) 1 day	>10
	Shore A Hardness	Non Swollen (7 days) 1 day 7 days	>10 40-60 <20% >100%
	Shore A Hardness Swelling Capacity Suggested Cross Sec Concrete Thickness	Non Swollen (7 days) 1 day 7 days Reduced and delayed s ction of Extruded Bead	>10 40-60 <20% >100% welling properties in salty water. le length of triangular bead (in.)
	Shore A Hardness Swelling Capacity Suggested Cross Sec Concrete Thickness 8-12	Non Swollen (7 days) 1 day 7 days Reduced and delayed s stion of Extruded Bead s Number of Beads (in.) Sid 1	>10 40-60 <20% >100% welling properties in salty water. le length of triangular bead (in.) 5/8
	Shore A Hardness Swelling Capacity Suggested Cross Sec Concrete Thickness	Non Swollen (7 days) 1 day 7 days Reduced and delayed s ction of Extruded Bead	>10 40-60 <20% >100% welling properties in salty water. le length of triangular bead (in.)



Coverage	20 fl.oz. uni-pac sausage seals: Triangular Yield 5/8 x 5/8 x 5/8 in. 18 lineal ft. 3/4 x 3/4 x 3/4 in. 12 lineal ft. Note: Yield may vary based on substrate irregularities.	
Packaging	Disposable 20 fl. oz., moisture-proof uni-pac sau- sages, 20/carton.	
How to Use Surface Preparation	Clean all surfaces. Substrate must be clean, sound, free of loose particles, dust, laitance, oils, and other contaminants. Surface may be dry or damp, with no presence of standing water. Do not leave the prod- uct in contact with wet concrete, or on a surface with a very high moisture content, for a long period of time, before casting new concrete. These conditions will decrease the adhesion between the SikaSwell S-2 bead and the surface of the joint.	2
Application	Recommended application temperatures: 50°-90°F. Extrude material using Sika MK-5 bulk caulking gun or other approved bulk gun. Cut the nozzle to obtain a triangular extrusion section with a size fulfilling effective needs (or use nozzle included in carton of SikaSwell S-2). Apply a uniform, continuous bead to the hardened concrete. Wait for approximately 2 hours after placement of the SikaSwell S-2 before placing concrete. The minimum thickness of concrete around the SikaSwell S-2 should be 4 inches on each side (reinforced concrete) or 6 in. on each side (non-reinforced concrete) and 4 inches on top. For optimum application, store at 70°F for a minimum of 8 hours prior to use; if the material appears stiff, knead the sausage for a short time before placing in bulk gun.	<ul> <li>SikaSwell S-2 Installation</li> <li>1. Clean surface of concrete.</li> <li>2. Cut nozzle to obtain triangular extrusion section (or use nozzle included in carton of SikaSwell S-2).</li> <li>3. Apply a uniform, continuous bead to hardened concrete. Wait 2 hours before placing</li> </ul>
Limitations	<ul> <li>Not suitable for expansion joints.</li> <li>Protect from rain to avoid expansion before placing swelling capacity.</li> <li>Avoid placement of the concrete from a height great</li> </ul>	

possible, allow SikaSwell S-2 to cure for 2 days before placing concrete.

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Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

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**B350** 



# **C** - Epoxy Resin and Structural Engineering Systems

Bonding	Agents
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Sika Armatec 110 EpoCem	A10
Sikadur 32 Hi-Mod	A20
Sikadur 32 Hi-Mod LPL	A30

Crack Repair and Injection Injection	Resins
Sikadur 33	C10
Sikadur 35 Hi-Mod I V	Γ20

	C20
Sikadur 35 Hi-Mod LV LPL	C30
Sikadur 52	C40
Sikadur Crack Fix	C50
Sikadur Crack Weld	C60
Sikadur Injection Gel, Standard Set	C70
Healer/Sealers	
Sikadur 55 SLV	C80
SikaPronto 19 TF	C90
Polyurethane Grouts	
SikaFix HH+	C100
SikaFix HH Hydrophilic	C110
SikaFix HH LV	C120

#### Structural Strengthening Systems Preformed

C130
C140
C150
C160
C170
C180
C190
C200
C210
C220
C230
C240
C250
C260
C270
C280
C290
C300
C310
C320
C330
C340
C350
C360

### **Multi-Purpose Structural Adhesives**

Sikadur 31 Hi-Mod Gel (1:1 Mix Ratio)	B240
Sikadur 31 Hi-Mod Gel LPL	C370
Sikadur 31, SBA (20-45°F)	usa.sika.com

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Sikadur 31, SBA Normal Set	C380
Sikadur 31, SBA Slow Set	C390
Sikadur 32 Hi-Mod	A20
Sikadur 32 Hi-Mod LPL	A30
Sikadur 33	C10
Sikadur 35 Hi-Mod LV	C20
Sikadur 35 Hi-Mod LV LPL	C30
Sikadur Injection Gel, Standard Set	C70

### Epoxy Resin Mortars and Broadcast Systems Heavy Traffic

Heavy Traffic	,
Sikadur 21 Lo-Mod LV	C400
Sikadur 22 Lo-Mod	C410
Sikadur Epoxy Broadcast Overlay System	C420
Sikadur 22 Lo-Mod FS	C430
Sikadur 25 Lo-Mod	C440
Sikadur 23 Lo-Mod Gel	B270
Sikadur 35 Hi-Mod LV	C20
Sikadur 35 Hi-Mod LV LPL	C30
Sikadur 43 Patch-Pak	usa.sika.com
Light Traffic	
Sikagard 62	A450
Sikadur Balcony System	C450
Sikagard Duochem 7500	C460
Sikagard Duochem 7500 Thixo	C470
Sikagard WDE Primer	C480
Sikagard 616	C490
Sikagard 664	C500
Sikagard 600	C510
<b>Control Joint Systems</b> Sika Loadflex 524 EZ	B180
Sikadur 51 NS	B190
Sikadur 51 SL	B200
Llich Deufeumenes Jaint Custom	_
<b>High Performance Joint Systems</b> Sikadur 31 Hi-Mod Gel (1:1 Mix Ratio)	<b>b</b> B240
Sikadur Sombiflex SG System	B240 B260
Sindul complice Su System	8200
Flooring	
Sikagard 62	A450
Sikagard Duochem 7500	C460
Sikagard Duochem 7500 Thixo	C470
Sikagard WDE Primer	C480
Sikagard 616	C490
Sikagard 664	C500
Sikagard 600	C510
Anchoring	
Sika AnchorFix-1	C520
Sika AnchorFix-2	C530
Sika AnchorFix-2 Arctic	C540
Sika AnchorFix-500	C550
Sika AnchorFix-3001	C560



**BUILDING TRUST** 

### **Sikadur<sup>®</sup> 33** High-modulus, high-strength, structural, very rapid-curing epoxy, smooth-paste adhesive

al	Sikadur 33 is a 2-component, 100% solids, moisture-tolerant, high-modulus, high-strength, structur- al, smooth-paste epoxy adhesive. It conforms to the current ASTM C-881, Types I and II, Grade-3, Class B/C* and AASHTO M-235 specifications. *except for gel time					
	se to seal cracks and to essure-injection grouti		ports in structural	concrete and wood	d trusses prior to	
•	New smooth-paste co Very rapid curing, eve Injection may proceed	n in thin film, for	aster pressure-inje	ction grouting.	ealing.	
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Shelf Life 2 years in original, unopened containers.Storage ConditionsStore dry at 40°-95°F (4°-35°C). Condition material to					
	Color		8°-24°C) before us	ing.		
		Concrete gr	•			
	Mixing RatioComponent 'A': Component 'B' = 1:1 by volume.ConsistencySmooth-paste adhesive.					
	Consistency Pot Life					
	Tack-Free Time		ely 15 minutes. (60	90°F (32°C)*		
	Tack-Free Time	<b>40°F (4°C</b> 1.5-1.75	, , ,	20-25 min		
	Tensile Properties			20 20		
		sile Strength	3,300 psi (22.7 N	IPa)		
		ngation at Break dulus of Elasticity	0.2% 8.3 X 10⁵ psi (5,7	'00 MPa)		
		xural Strength (M	odulus of Rupture) Elasticity in Bendin			
	Shear Properties	(ASTM D-732)	1 day Shear Str	ength 2,200 ps	i (15.2 MPa)	
	Heat Deflection To 1 day 120	Heat Deflection Temperature (ASTM D-648)				
		STM C-882): Ha	dened Concrete t (20.6 MPa)	o Hardened Cond	crete	
	Water Absorption Compressive Pro Compressive Stre	(ASTM D-570) perties (ASTM D	7 day (24 ho	our immersion)	0.36 %	
		F (4°C)*	73°F (23°C)*	90°F (32°C)*		
		(0.20) 00 (12.4)	5,600 (38.6) 6,700 (46.2)	4,600 (31.7) 5,600 (38.6)		
		00 (24.1)	7,800 (53.7)	5,700 (39.3)		
		00 (43.4)	8,200 (56.5)	6,600 (45.5)		
		00 (47.5)	8,500 (58.6)	7,100 (48.9)		
	1 day7,400 (51)8,600 (59.3)7,300 (50.3)3 day7,900 (54.4)9,000 (62)7,600 (52.4)					
	<b>7 day</b> 8,300 (57.2) 9,200 (63.4) 7,800 (53.7)					
		00 (58.6)	9,200 (63.4)	8,100 (55.8)		
		00 (59.3)	9,400 (64.8)	8,300 (57.2)		
	Compressive Mo	dulus 28 day	9.6 X 10⁵ psi (6,60	00 MPa)		
	* Material cured and tested at the temperatures indicated.					





Coverage	1 gal. yields 231 cu. in. of paste adhesive.
Packaging	3 gallon unit
Cure Mechanism	Epoxy resin adhesive
How to Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes and any other contaminants. Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means. Steel - Should be cleaned and prepared thoroughly by blast cleaning.
Mixing	Pre-mix each component. Proportion equal parts by volume of Component 'B' and Component 'A' into a clean pail. Mix thoroughly for 3 minutes with Sika paddle on low-speed (400-600 rpm) drill until uniform in color. Mix only that quantity that can used within its pot life.
Application	To seal injection ports and cracks for injection grouting - Place the neat mixed material over the cracks to be pressure-injected and around each injection port. Allow sufficient time to set before pressure injecting. Use Sikadur 35, Hi-Mod LV, or Sikadur 52 for the low viscosity injection adhesive. Consult technical data sheets on these products for more information. Also, contact Technical Service (1.800.933. SIKA) for additional information on pressure injection grouting.
Removal	Uncured material can be removed with approved solvent (Xylene, M.E.K., Acetone, etc.). Strictly fol- low solvent manufacturer's warnings and instructions for use. Cured material can only be removed mechanically.
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not thin. Addition of solvents will prevent proper cure.</li> <li>Material is a vapor barrier after cure.</li> <li>Not for sealing cracks under hydrostatic pressure at the time of application.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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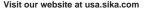
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> Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 11.13.2014 Sikadur® 35, Hi-Mod LV

## Sikadur<sup>®</sup> 35, Hi-Mod LV

Description	Sikadur <sup>®</sup> 35, Hi-Mod LV is a 2-component, 100% solids, moisture-tolerant, low-viscosity, high-strength, multi- purpose, epoxy resin adhesive. It conforms to the current ASTM C-881, Types I, II, and IV, Grade-1, Class C* and AASHTO M-235 specifications. *except for gel time						
Where to Use	<ul> <li>Pressure-injection of cracks in structural concrete, masonry, wood, etc.</li> <li>Gravity-feed of cracks in horizontal concrete and masonry.</li> <li>Epoxy resin binder for epoxy mortar patching and overlay of interior, horizontal surfaces.</li> <li>Seal interior slabs and exterior above-grade slabs from water, chlorides, and mild chemical attack; also improves wearability.</li> </ul>						
Advantages	<ul> <li>Super low viscosity.</li> <li>Convenient easy mix ratio A</li> <li>Unique, high-strength, struc</li> <li>Deep penetrating and tenac</li> <li>High-early-strength develop</li> </ul>	tural adhesive for	or "can't dry" su				
Coverage	1 gal. yields 231 in <sup>3</sup> of adhesiv oven-dried aggregate, yields a				d with 5 gal.	by loose volume of	
Packaging	3 gal. units; 1 gal. units; 12 flc	oz. units, 12/case	e.				
	Turning   Data (III )				(		
	Typical Data (Material and RESULTS MAY DIFFER BASED UPON	-					
	MENT, TEMPERATURE, APPLICATION						
		2 years in original		iners.			
	Product Storage	Store dry at 40°-9					
	Product Conditioning	Condition material	l to 65°-75°F (18°	-24°C) before us	sing.		
	Color Minimu Datia	Clear, amber.					
	-	Component A : Co		by volume.			
		Approximately 375 Approximately 25		n mass)			
		4°F (4°C)	minutes. (ou grai	73°F (23°C)		90°F (32°C)	
		4-16 hrs.		3-3.5 hrs.	1.5-2 hr		
	Tensile Properties (ASTM D-638)		Neat		Mortar		
	7 day Tensile Strength		8,900 psi (61	.4 MPa) 14 d		(5.8 MPa)	
	Elongation at Br		5.4%		0.3%		
	14 day Modulus of Elas		4.1 X 10⁵ psi	(2,800 MPa	7.6 X 1	0⁵ psi (5,200 MPa)	
	Flexural Properties (ASTM D-790 14 day Flexural Strength (Modu Tangent Modulus of Ela	ulus of Rupture)	14,000 psi (9 3.7 x 10⁵ psi	6.6 MPa) (2,600 MPa)		osi (15.2 MPa) 0⁵ psi (6,500 MPa)	
	Shear Strength (ASTM D-732)14 dayShear Strength		5,100 psi (35	5.2 MPa)	2,300	osi (15.9 MPa)	
	Heat Deflection Temperature (AS 7 day [fiber stress loading = 2		124°F (51°C	;)	129°F	(54°C)	
	Bond Strength (ASTM C-882): Ha 2 day (moist cure) 14 day (moist cure) 2 day (dry cure)		to hardened co 4,000 psi (2 2,900 psi (2 2,800 psi (1	7.6 MPa) 0.0 MPa)			
	Water Absorption (ASTM D-570)	7 day (24 ho	ur immersion)	0.27 %			
	Compressive Properties (ASTM Compressive Strength, psi (MPa	) Neat			Mortar (1:5)	2005 (2020)	
	40°F (4°C) 4 hour -	73°F (23°C)	90°F (32°C) -	40°F(4°C)	73°F (23°C) -	90°F (32°C) 800 (5.5)	
	8 hour -	180 (1.2)	3,200 (22.1)	-	-	4,100 (28.3)	
	16 hour -	4,500 (31.1)	6,300 (43.5)	-	400 (2.8)	5,700 (39.3)	
	1 day -	6,000 (41.4)	9,100 (62.8)	120 (0.8)	5,000 (34.5)	6,900 (47.6)	
	<b>3 day</b> 4,000 (27.6)	10,700 (73.8)	10,500 (72.5)	6,200 (42.8)	6,800 (46.9)	7,000 (48.3)	



Suc

	How to Use Surface Preparation
	Mixing
uction	Application
constr	Limitations

7 day

	14 day 28 day	10,300 (71.1) 12,400 (85.6)		10,500 (72.5) 10,500 (72.5)	6,800 (46.9)	8,500 (58.7)	8,800 (60.7) 8,800 (60.7)		
	Compressive N		Neat	<sup>₅</sup> psi (2,200 MF		Mortar	si (5,600 MPa)		
to Use ce Preparation	grease, curing co	ompounds, imp	regnations, wa	xes, foreign pa	rticles and dis	integrated mat	nove dust, laitance, terials. an open roughened		
	Steel - Should b	e cleaned and j	prepared thoro	ughly by blast o	leaning.				
g	Proportion 1 part Component 'B' to 2 parts Component 'A' by volume into a clean pail. Mix thoroughly for 3 minutes with Sika Paddle on low-speed (400-600 rpm) drill until uniformly blended. Mix only that quantity that can be used within its pot life. To prepare an epoxy mortar, slowly add 4-5 parts by loose volume of an oven-dried aggregate to 1 part of the mixed Sikadur <sup>®</sup> 35, Hi-Mod LV and mix until uniform in consistency.								
cation		ee-notched cra					r neat Sikadur <sup>®</sup> 35, side of slab prior to		
	<b>To pressure-inject cracks</b> - Use automated injection equipment or manual method. Set appropriate injection ports based on system used. Seal ports and crack with Sikadur <sup>®</sup> 31, Hi-Mod Gel or Sikadur <sup>®</sup> 33. When the epoxy adhesive seal has cured, inject Sikadur <sup>®</sup> 35, Hi-Mod LV with steady pressure. Consult Technical Service for additional information.								
	To seal slabs - Spread neat Sikadur <sup>®</sup> 35, Hi-Mod LV over slab. Allow penetration. Remove excess to prevent surface film. Seal interior slabs and above-grade exterior slabs only.								
		becomes tack	free. Place the	e epoxy mortar	using trowels.	Compact and	repared epoxy mor- level with vibrating r use only.		
ations	<ul> <li>Epoxy mortar</li> <li>Do not seal example</li> <li>Minimum age and to seal sl</li> <li>Porous substr</li> <li>Not for injection</li> </ul>	ed aggregate or bxy mortar thick is for interior un xterior slabs on of concrete mu abs. rates must be to on of cracks un cracks greater t	nly. ness is 1.5 in. se only. grade. ust be 21-28 da ested for moist der hydrostatic han 1/4 in. (6 r	(38 mm) per lift ays, depending ure-vapor trans pressure at the nm) Consult Te	t. on curing and mission prior e time of appli chnical Servio	to application. ication. ce.	ons, for mortar		

10,500 (72.5) 6,300 (43.5) 7,900 (54.5)

8,800 (60.7)

6,800 (46.9) 11,000 (75.9)

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Product Data Sheet Edition 9.23.2014 Sikadur® 35, Hi-Mod LV LPL

### **Sikadur® 35, Hi-Mod LV LPL** High-modulus, low-viscosity, high-strength, extended pot life, epoxy adhesive

Description	multi-purpose epoxy	resin adhesive. M-235 specificat	It conforms to the current A	Hi-Mod LV LPL is a 2-component, 100% solids, moisture-tolerant, low-viscosity, high-strength e epoxy resin adhesive. It conforms to the current ASTM C-881, Types I, II, and IV, Grade-1 AASHTO M-235 specifications. ad strength ure and high pressure injection of cracks in structural concrete, masonry, wood, etc.			
Where to Use	Low pressure and h	nigh pressure in	jection of cracks in structural	concrete, masonry, wood, etc.			
			concrete and masonry.				
			ar patching and grouting.	hlorides and mild chemical attack; also			
	improves wearabilit		ve grade slabs nom water, o				
	<ul> <li>Epoxy resin binder</li> </ul>	for epoxy morta	ar repair for structural pile mer	mbers.			
Advantages	Extended pot life.	weellest seset	otio a obility				
	<ul> <li>Low viscosity and e</li> <li>Slow reaction rate a</li> </ul>						
	<ul> <li>Convenient, easy n</li> </ul>						
			hesive for "can't dry" surface				
	<ul> <li>Deep, penetrating a</li> <li>Excellent chemical</li> </ul>		onding of cracks in structural	concrete.			
Coverage	oven-dried aggregate	, yields approxi surface sealing	mately 808.5 cu. in. of epoxy. . Coverage varies with porosi	when mixed with 5 gal. by loose volume of y mortar. Typical coverage is 150-175 ft. ity and surface profile of substrate. Highe			
Packaging	3 gal. units. 165 gal. u	inits.					
	o gai. anno. Too gai. e						
	o gai. anno. Too gai. c						
			ng conditions @ 73°F (23°C	C) and 50% R.H.)			
	Typical Data (Ma RESULTS MAY DIFFER B	aterial and cur		C) and 50% R.H.) PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS.			
	Typical Data (Ma RESULTS MAY DIFFER B	aterial and curr ASED UPON STATI ATION METHODS, 1	STICAL VARIATIONS DEPENDING UP	PON MIXING METHODS AND EQUIPMENT,			
	Typical Data (Ma RESULTS MAY DIFFER B TEMPERATURE, APPLIC	aterial and curr ASED UPON STATI ATION METHODS, 1 2 years in orig	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers	PON MIXING METHODS AND EQUIPMENT,			
	Typical Data (Ma RESULTS MAY DIFFER B. TEMPERATURE, APPLICA Shelf Life	aterial and curr ASED UPON STATI ATION METHODS, 1 2 years in orig	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS.			
	Typical Data (Ma RESULTS MAY DIFFER B. TEMPERATURE, APPLIC/ Shelf Life Storage Conditions	aterial and curr ASED UPON STATI ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber.	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using.			
	Typical Data (Ma RESULTS MAY DIFFER B. TEMPERATURE, APPLIC/ Shelf Life Storage Conditions Color	aterial and curr ASED UPON STATI ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber.	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CON ginal, unopened containers 0°-95°F (4°-35°C). Condition mate N': Component 'B' = 2:1 by volume	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using.			
	Typical Data (Ma RESULTS MAY DIFFER B TEMPERATURE, APPLIC/ Shelf Life Storage Conditions Color Mixing Ratio	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximately Approximately	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CON ginal, unopened containers 0°-95°F (4°-35°C). Condition mate N': Component 'B' = 2:1 by volume	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e			
	Typical Data (Ma RESULTS MAY DIFFER B TEMPERATURE, APPLIC/ Shelf Life Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tensile Properties (AS	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel (Component )	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate V': Component 'B' = 2:1 by volume / 250 cps. / 90 minutes (250 grams). / 40 minutes (250 grams) @ 100° 60°F (15°F)	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) <b>73°F (23°F)</b>			
	Typical Data (Ma RESULTS MAY DIFFER B TEMPERATURE, APPLIC/ Shelf Life Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tensile Properties (AS 7 day Tensi	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 250 cps. 90 minutes (250 grams). 40 minutes (250 grams). 60°F (15°F) 7,200 psi (49.6 MPa)	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa)			
	Typical Data (Marcon 1998)         RESULTS MAY DIFFER B.         TEMPERATURE, APPLICA         Shelf Life         Storage Conditions         Color         Mixing Ratio         Viscosity (Mixed)         Pot Life         Tensile Properties (AS 7 day         Tensile Construction	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength pation at Break	STICAL VARIATIONS DEPENDING UP           TEST METHODS, ACTUAL SITE CONI           ginal, unopened containers           0°-95°F (4°-35°C). Condition mate           V': Component 'B' = 2:1 by volume           / 250 cps.           / 90 minutes (250 grams).           / 40 minutes (250 grams) @ 100°           60°F (15°F)           7,200 psi (49.6 MPa)           4.0 %	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8%			
	Typical Data (Marcon Content of Con	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel BTM D-638) le Strength gation at Break Erature (ASTM D	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 250 cps. 90 minutes (250 grams). 40 minutes (250 grams). 60°F (15°F) 7,200 psi (49.6 MPa)	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C)			
	Typical Data (Marcon Content of Con	Aterial and curr ASED UPON STATE ATION METHODS, T 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break Prature (ASTM D C-882): Hardene	STICAL VARIATIONS DEPENDING UP           TEST METHODS, ACTUAL SITE CONI           ginal, unopened containers           0°-95°F (4°-35°C). Condition mate           V': Component 'B' = 2:1 by volume           / 250 cps.           / 90 minutes (250 grams).           / 40 minutes (250 grams) @ 100°           60°F (15°F)           7,200 psi (49.6 MPa)           4.0 %           -648)         7 day (Fiber Stress Load)	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) ete psi (7.6 MPa)			
	Typical Data (Ma         RESULTS MAY DIFFER B.         TEMPERATURE, APPLICA         Shelf Life         Storage Conditions         Color         Mixing Ratio         Viscosity (Mixed)         Pot Life         Tensile Properties (AS         7 day       Tensi Elong         Heat Deflection Tempe         Bond Strength (ASTM)         2 day (moist cure)         14 day (moist cure)	Aterial and curr ASED UPON STATI ASED UPON STATI ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate V: Component 'B' = 2:1 by volume / 250 cps. / 90 minutes (250 grams). / 40 minutes (250 grams) @ 100° 60°F (15°F) 7,200 psi (49.6 MPa) 4.0 % -648) 7 day (Fiber Stress Load d concrete to hardened concrete Bond Strength 1,100	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) tte psi (7.6 MPa) psi (9.0 MPa)			
	Typical Data (Ma         RESULTS MAY DIFFER B.         TEMPERATURE, APPLICA         Shelf Life         Storage Conditions         Color         Mixing Ratio         Viscosity (Mixed)         Pot Life         Tensile Properties (AS         7 day       Tensi Elong         Heat Deflection Tempe         Bond Strength (ASTM)         2 day (moist cure)         14 day (moist cure)	Aterial and curr ASED UPON STATE ASED UPON STATE 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene ASTM D-570) 2	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 250 cps. 90 minutes (250 grams). 40 minutes (250 grams) @ 100° 60°F (15°F) 7,200 psi (49.6 MPa) 4.0 % -648) 7 day (Fiber Stress Load d concrete to hardened concre Bond Strength 1,100 Bond Strength 1,300 4 hrs. (24 hr. immersion) 0.35	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) tte psi (7.6 MPa) psi (9.0 MPa)			
	Typical Data (Marcon Control Co	Aterial and curr ASED UPON STATE ASED UPON STATE ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene ASTM D-570) 2 erties (ASTM D	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Component 'B' = 2: by volume 2': Comp	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e PF (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) ete psi (7.6 MPa) psi (9.0 MPa) 5% 90°F (32°C)			
	Typical Data (Marcon Control Co	Aterial and curr ASED UPON STATE ASED UPON STATE ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene ASTM D-570) 2 erties (ASTM D	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 2': Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' =	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e PF (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) tte psi (7.6 MPa) psi (9.0 MPa) 5% 90°F (32°C) 7,100 psi (49.0 MPa)			
	Typical Data (Marcon Control Co	Aterial and curr ASED UPON STATE ASED UPON STATE ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene ASTM D-570) 2 erties (ASTM D	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 2' 250 cps. 2' 90 minutes (250 grams). 2' 40 minutes (250 grams) @ 100° 60°F (15°F) 7,200 psi (49.6 MPa) 4.0 % -648) 7 day (Fiber Stress Load bd concrete to hardened concret Bond Strength 1,100 Bond Strength 1,100 Bond Strength 1,300 4 hrs. (24 hr. immersion) 0.35 -695): 73°F (23°C) 1,450 psi (10.0 MPa) 9,600 psi (66.2 MPa)	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) te psi (7.6 MPa) psi (9.0 MPa) 5% 90°F (32°C) 7,100 psi (49.0 MPa) 10,000 psi (69.0 MPa)			
	Typical Data (Marcon Control Co	Aterial and curr ASED UPON STATE ASED UPON STATE ATION METHODS, 1 2 years in orig Store dry at 4 Clear, amber. Component '/ Approximatel Approximatel Approximatel STM D-638) le Strength gation at Break erature (ASTM D C-882): Hardene ASTM D-570) 2 erties (ASTM D	STICAL VARIATIONS DEPENDING UP TEST METHODS, ACTUAL SITE CONI ginal, unopened containers 0°-95°F (4°-35°C). Condition mate 1': Component 'B' = 2:1 by volume 2': Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' = 2: Component 'B' =	PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS. erial to 65°-75°F (18°-24°C) before using. e F (38°C) 73°F (23°F) 7,500 psi (51.8 MPa) 4.8% ding = 264 psi) 120°F (49°C) tte psi (7.6 MPa) psi (9.0 MPa) 5% 90°F (32°C) 7,100 psi (49.0 MPa) 10,000 psi (69.0 MPa) 11,100 psi (76.6 MPa)			



How to Use Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitanc grease, curing compounds, impregnations, waxes and any other contaminants. <b>Preparation Work</b> : Concrete - Should be cleaned and prepared thoroughly to achieve a laitance and contam nant free, open textured surface by blast cleaning or equivalent mechanical means. <b>Steel</b> - Should be cleaned and prepared thoroughly by blast cleaning or other equivalent mechanical means.
Mixing	<ul> <li>Proportion 1 part Component 'B' to 2 parts Component 'A' by volume into a clean pail. Mix thoroughly for minutes with a low-speed (400 - 600 rpm) drill using Sika Paddle until uniformly blended. Mix only that quanti that can be used within its pot life.</li> <li>To prepare an epoxy mortar slowly add 4-5 parts by loose volume of an oven-dried aggregate to 1 part the mixed Sikadur<sup>®</sup> 35, Hi-Mod LV LPL and mix until uniform in consistency.</li> </ul>
Application	<ul> <li>To gravity feed cracks - Blow vee-notched surface of crack clean with oil-free compressed air. Pour ne Sikadur® 35, Hi-Mod LV LPL, into vee-notched crack. Continue placement until completely filled. Seal underside of slab prior to filling if cracks reflect through.</li> <li>To seal slabs - Spread neat Sikadur® 35, Hi-Mod LV LPL over slab. Allow penetration. Remove excess</li> </ul>
	prevent surface film. Seal interior slabs and above-grade exterior slabs only. <b>For an epoxy mortar -</b> Prime prepared surface with neat Sikadur <sup>®</sup> 35, Hi-Mod LV, LPL. Place prepared epox mortar before primer becomes tack-free. Place the epoxy mortar using trowels. Compact and level with vibra ing screed or trowels. Finish with finishing trowel. Epoxy mortar is for interior use only.
	<b>To pressure inject cracks</b> - Suitable for low or high pressure injection. Use automated injection equipme or manual method. Set appropriate injection ports based on system used. Seal ports and crack with Sikadu 31, Hi-Mod Gel or Sikadur <sup>®</sup> 33. When the epoxy adhesive seal has cured, inject Sikadur <sup>®</sup> 35, Hi Mod LV LF with steady pressure. Consult Technical Service for additional information.
Limitations	<ul> <li>Minimum application temperature 40°F (4°C).</li> <li>Do not thin with solvents.</li> <li>Use oven-dried aggregate only.</li> <li>Maximum epoxy mortar thickness is 1.5 in. (38 mm) per lift.</li> <li>Epoxy mortar is for interior use only.</li> <li>Do not seal exterior slabs on grade.</li> <li>Minimum age of concrete must be 21-28 days, depending upon curing and drying conditions, for mortar application and to seal slabs.</li> <li>Porous substrates must be tested for moisture-vapor transmission prior to mortar or sealing slabs.</li> <li>Not for injection of cracks under hydrostatic pressure.</li> <li>Do not inject cracks greater than 1/4 in. (6 mm) Consult Technical Service.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>
IN SH PA TO RE	RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DA' IEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE D RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CU INT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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Construction

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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1-800-933-SIKA NATIONWIDE

Product Data Sheet Edition 9.23.2014 Sikadur® 52

### **Sikadur<sup>®</sup> 52** Advanced, very-low-viscosity, moisture-tolerant epoxy injection adhesive

Description	Sikadur <sup>®</sup> 52 is a 2-component, 100% solids, moisture-tolerant, epoxy adhesive. It is a low-viscosity, high-strength adhesive formulated specifically for grouting both dry and damp cracks. It conforms to the current ASTM C-881, Types I and II, Grade-1, Class C and AASHTO M-235 specifications.				
Where To Use	<ul> <li>Use neat for gravity feed or pressure injection of cracks in structural concrete, masonry, wood, etc.</li> <li>Seal interior slabs and exterior above grade slabs from water, chlorides and mild chemical attack and to improve wearability.</li> </ul>				
Advantages	<ul> <li>Tenacious crack-sealing grout.</li> <li>Convenient easy mix ratio A:B = 2:1 by volume.</li> <li>Advanced low-viscosity structural resin.</li> <li>Unique, high-strength adhesive for 'can't dry' cracks.</li> </ul>				
Coverage	1 gal. yields 231 cu. in.				
Packaging	3 gallons units.				
	RESULTS MAY DIFFER BASED U	ETHODS, TEST METHODS, ACTUAL SITE C 2 years in original, unopened co	GUPON MIXING METHODS AND EQUIPMENT, ONDITIONS AND CURING CONDITIONS.		
	Color	-			
		Clear, pale yellow. Component 'A': Component 'B' =	- Other wolume		
	Mixing Ratio Viscosity (Mixed)		= 2.1 by volume.		
	Pot Life	Approximately 200 cps.			
	Tensile Properties (AST	Approximately 30 minutes. (60 g	grammass <i>)</i>		
	14 day Tensile St Elongation	rength 7,900 psi (54	,		
		<b>TM D-790)</b> trength (Modulus of Rupture) lodulus of Elasticity in Bending	5,400 psi (37.2 MPa) 3.8 X 10⁵ psi (2,620 MPa)		
	Shear Strength (ASTM I	D-732) 14 day Shear Streng	th 4,300 psi (29.6 MPa)		
	Bond Strength (ASTM 0 2 day (dry cure) 14 day (moist cure)		ardened Concrete (20.6 MPa) (15.1 MPa)		
	Heat Deflection Temper 14 day 122°F (50 [fiber stree				
	Water Absorption (AST	<b>M D-570) 7 day</b> (2 hour boil)	) 1.5%		
	Compressive Properties Compressive Strength, 40°F* (4°C	psi (MPa)	90°F* (32°C)*		
	8 hour - 16 hour -	- 3,000 (20.6)	90 (0.62) 7,300 (50.3)		
	1 day -	4,500 (31.0)	8,400 (57.9)		
	<b>3 day</b> 1,800 (12.	4) 10,000 (68.9)	8,700 (60.0)		
	<b>7 day</b> 6,100 (42.	, , , ,	10,400 (71.7)		
	<b>14 day</b> 6,800 (46. <b>28 day</b> 8,400 (57.		10,400 (71.7) 10,400 (71.7)		
			S READ AND FOLLOW THE WARNINGS AND		





Mixing
Application
Limitations

	* Material cured and tested at the temperatures indicated.
How to Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes and any other contaminants.
	<b>Preparation Work: Concrete -</b> Should be cleaned and prepared to achieve a laitance and contami- nant free, open textured surface by blast cleaning or equivalent mechanical means.
	Steel - Should be cleaned and prepared thoroughly by blast cleaning or other equivalent mechanical means.
Mixing	Proportion 1 part Component 'B' to 2 parts Component 'A' by volume into a clean pail. Mix thoroughly for 3 minutes with Sika Paddle on low-speed (400-600 rpm) drill until uniformly blended. Mix only that quantity that can be used within its pot life.
Application	<b>To gravity feed cracks -</b> Blow vee-notched crack clean with oil-free compressed air. Pour neat Sikadur <sup>®</sup> 52 into vee-notched crack. Continue placement until cracks are completely filled. Prior to filling, seal underside of slab if cracks reflect through.
	<b>To pressure inject cracks</b> - Use automated injection equipment or manual method. Set appropriate injection ports based on system used. Seal ports and cracks with Sikadur 31, Hi-Mod Gel, or Sikadur <sup>®</sup> 33.
	When the epoxy adhesive seal has cured, inject Sikadur® 52 with steady pressure. Consult Technical Service for additional information.
	<b>To seal slabs -</b> Spread neat mixture of Sikadur <sup>®</sup> 52 over slab using a roller or squeegee, working material thoroughly into the substrate to ensure penetration. Coverage should be uniform. Coat interior slabs and above-grade exterior slabs only.
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not thin. Addition of solvents will prevent proper cure.</li> <li>Material is a vapor barrier after cure.</li> <li>Not for injection of cracks under hydrostatic pressure at the time of application.</li> <li>Do not inject cracks greater than 1/4 in. (6 mm) without consulting Technical Service.</li> <li>Do not seal exterior slabs on grade.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

**28 davs** 3.5 x 10<sup>5</sup> psi (2.400 MPa)

Compressive Modulus

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Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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Sika and Sikadur are registered trademarks. Printed in Canada. Product Data Sheet Edition 10.2.2014 Sikadur<sup>®</sup> Crack Fix

## Sikadur<sup>®</sup> Crack Fix Low-viscosity, high-strength epoxy sealing system

Advar Cover Packa

Description	Sikadur <sup>®</sup> Crack Fix is a 2-component, 100% solids, moisture-tolerant, low-viscosity, high-strength, multi-purpose, epoxy resin adhesive. It conforms to the current ASTM C-881 and AASHTO M-235 specifications.			
Where to Use	<ul> <li>Gravity-feed of cracks in horizontal concrete and masonry.</li> </ul>			
	Low pressure injection of cracks in structural concrete, masonry, wood, etc.			
	<ul> <li>Grouting bolts, dowels, pins, etc. into horizontal concrete surfaces.</li> </ul>			
Advantages	<ul> <li>Formulation identical to popular, high strength adhesive Sikadur® 35, Hi-Mod LV.</li> <li>Five times stronger than concrete.</li> <li>Convenient easy to use, single tube cartridge - fits standard caulk guns.</li> <li>Deep, penetrating and tenacious bonding of cracks in structural concrete.</li> <li>No mess - self-mixing.</li> </ul>			
Coverage	1 cartridge yields approximately 10.7-11.0 cu. in. (175-180 ml) of usable epoxy resin.			
Packaging	Carton contains 12 single caulk tube-style cartridges; each cartridge packaged with 2 static mixers and 2 flow			
i dekaging	restrictors.			
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)			
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,			
	TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.			
	Shelf Life 2 years in original, unopened containers.			
	<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C).			
	Condition material to 60°-75°F (15°-24°C) before using.			
	Color Clear, amber.			
	Mixing Ratio Component A : Component B = 2:1 by volume.			
	Viscosity (Mixed) Approximately 375 cps.			
	Pot Life Approximately 25 minutes. (60 gram mass)			
	Tack Free Time 40°F (4°C)* 73°F (23°C)* 90°F (32°C)*			
	( <b>3-5 mils</b> ) 14-16 hrs. 3-3.5 hrs. 1.5-2 hrs.			
	Tensile Properties (ASTM D-638)			
	7 day Tensile Strength 7,000 psi (48.3 MPa)			
	Elongation at Break 6.9%			
	Flexural Properties (ASTM D-790)			
	14 day Flexural Strength (Modulus of Rupture) 11,000 psi (75.9 MPa)			
	Tangent Modulus of Elasticity in Bending 3.1 x 10 <sup>5</sup> psi (2,139 MPa)			
	Shear Strength (ASTM D-732)			
	14 dayShear Strength4,800 psi (33.1 MPa)			
	Heat Deflection Temperature (ASTM D-648)			
	7 day [fiber stress loading = 264 psi (1.8 MPa)] 121°F (49°C)			
	Bond Strength (ASTM C-882): Hardened concrete to hardened concrete			
	2 day (moist cure) Bond Strength 1,300 psi (9.0 MPa)			
	14 day (moist cure) Bond Strength 1,350 psi (9.3 MPa)			
	Water Absorption (ASTM D-570)     7 day (24 hour immersion)     0.27%			
	Compressive Properties (ASTM D-695)			
	Compressive Strength, psi (MPa)			
	40°F (4°C)* 73°F (23°C)* 90°F (32°C)* 4 hour			
	<b>8 hour</b> - 180 (1.2) 3,200 (22.1)			



16 hour 1 day 3 day 7 day 14 day 28 day	4,000 (27.6) 6,800 (46.9) 10,300 (71.1) 12,400 (85.6)	4,500 (31.1) 6,000 (41.4) 9,000 (62.1) 11,000 (75.9) 12,000 (82.8) 13,000 (89.7)	6,300 (43.5) 9,100 (62.8) 10,500 (72.5) 10,500 (72.5) 10,500 (72.5) 10,500 (72.5)	
		psi (2,000 MPa)		
Surface must be clean, dry an compressed air.	nd sound. Remove	dust from crack by b	rushing or by blowing clean wit	h oil free
into opening. Insert one of the Crack Fix cartridge into good of any entrapped air. As mixed re	enclosed static mi quality caulking gui esin approaches e	kers through twist-cap n. Point upward during nd of mixer, discard re	and attach to threading. Insert g initial squeeze of gun's trigger	Sikadur® to purge
Fix slowly into vee-notched cr	ack. Continue pla			
or Sikadur <sup>®</sup> 33. When the epox	ky adhesive seal h	as cured, inject Sikadı		
<ul> <li>Minimum age of concrete m</li> <li>Do not apply over wet, gliste</li> <li>Not for injection of cracks se</li> <li>Do not inject cracks greater</li> </ul>	nust be 21-28 days ening surface. ubjected to osmot than ¼ in. (6 mm	, depending on curin c or hydrostatic press Consult Technical S	g and drying conditions. sure during application. ervice at 1-800-933-SIKA.	= (35°C).
-	1 day 3 day 7 day 14 day 28 day Compressive Modulus 7 da *Material cured and tested at the temp *Material cured and tested at the temp Surface must be clean, dry an compressed air. Cartridge Set-Up: Remove twi into opening. Insert one of the Crack Fix cartridge into good c any entrapped air. As mixed re squeeze to ensure uniform ble To gravity feed cracks - Blow Fix slowly into vee-notched cr filling if cracks reflect through. To inject cracks - Set appropri or Sikadur® 33. When the epox Consult Technical Service for Minimum substrate and am Minimum age of concreter m Do not apply over wet, glist Not for injection of cracks s Do not inject cracks greater	1 day       -         3 day       4,000 (27.6)         7 day       6,800 (46.9)         14 day       10,300 (71.1)         28 day       12,400 (85.6)         Compressive Modulus         7 day       2.9 X 10 <sup>5</sup> *Material cured and tested at the temperatures indicated.         Surface must be clean, dry and sound. Remove compressed air.         Cartridge Set-Up: Remove twist-cap and port plug into opening. Insert one of the enclosed static mix Crack Fix cartridge into good quality caulking gur any entrapped air. As mixed resin approaches er squeeze to ensure uniform blend of adhesive co         To gravity feed cracks - Blow vee-notched crack Fix slowly into vee-notched crack. Continue place filling if cracks reflect through.         To inject cracks - Set appropriate injection ports or Sikadur® 33. When the epoxy adhesive seal has Consult Technical Service for additional informate for a stature and ambient temperature Minimum age of concrete must be 21-28 days         Do not apply over wet, glistening surface.       Not for injection of cracks greater than ¼ in. (6 mm)	1 day       -       6,000 (41.4)         3 day       4,000 (27.6)       9,000 (62.1)         7 day       6,800 (46.9)       11,000 (75.9)         14 day       10,300 (71.1)       12,000 (82.8)         28 day       12,400 (85.6)       13,000 (89.7)         Compressive Modulus         7 day       2.9 X 10 <sup>5</sup> psi (2,000 MPa)         "Material cured and tested at the temperatures indicated.    Surface must be clean, dry and sound. Remove dust from crack by be compressed air. Cartridge Set-Up: Remove twist-cap and port plug from top of cartridge into opening. Insert one of the enclosed static mixers through twist-cap Crack Fix cartridge into good quality caulking gun. Point upward during any entrapped air. As mixed resin approaches end of mixer, discard resqueze to ensure uniform blend of adhesive components. To gravity feed cracks - Blow vee-notched crack clean with oil-free cc Fix slowly into vee-notched crack. Continue placement until complete filling if cracks reflect through. To inject cracks - Set appropriate injection ports. Seal ports and surfactor Sikadur® 33. When the epoxy adhesive seal has cured, inject Sikadur Sikadur® 33. When the epoxy adhesive seal has cured, inject Sikadur® 10 on ot apply over wet, glistening surface. Not for injection of cracks subjected to osmotic or hydrostatic presse Do not inject cracks greater than ¼ in. (6 mm) Consult Technical Service	1 day       -       6,000 (41.4)       9,100 (62.8)         3 day       4,000 (27.6)       9,000 (62.1)       10,500 (72.5)         7 day       6,800 (46.9)       11,000 (75.9)       10,500 (72.5)         14 day       10,300 (71.1)       12,000 (82.8)       10,500 (72.5)         28 day       12,400 (85.6)       13,000 (89.7)       10,500 (72.5)         28 day       12,400 (85.6)       13,000 (89.7)       10,500 (72.5)         Compressive Modulus         7 day       2.9 X 10 <sup>6</sup> psi (2,000 MPa)         *Material cured and tested at the temperatures indicated.    Surface must be clean, dry and sound. Remove dust from crack by brushing or by blowing clean wit compressed air. Cartridge Set-Up: Remove twist-cap and port plug from top of cartridge. Press one of enclosed "flow re into opening. Insert one of the enclosed static mixers through twist-cap and attach to threading. Insert Crack Fix cartridge into good quality caulking gun. Point upward during initial squeeze of gun's trigger any entrapped air. As mixed resin approaches end of mixer, discard rest of initial squeeze and portic squeeze to ensure uniform blend of adhesive components. To gravity feed cracks - Blow vee-notched crack clean with oil-free compressed air. Dispense Sikaduf Fix slowly into vee-notched crack. Continue placement until completely filled. Seal underside of sla filling if cracks reflect through. To inject cracks - Set appropriate injection ports. Seal ports and surface of crack with Sikadur <sup>6</sup> 31, Hi or Sikadur <sup>6</sup> 33. When the epoxy adhesive seal ha

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Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 2.24.2015 Sikadur<sup>®</sup> Crack Weld

## Sikadur<sup>®</sup> Crack Weld Crack Injection Kit

Description	Two component, low viscosity, fast curing epoxy sealing system for repairs to cracks in concrete and solid masonry. Conforms to ASTM C-881.			ete and solid	
Where to Use	<ul> <li>Low pressure injection of cracks in struct</li> <li>Gravity feed cracks in horizontal concrete</li> </ul>			у.	
Advantages	<ul> <li>As strong as concrete.</li> <li>Convenient mix in the nozzle cartridge system.</li> <li>Cartridges fit standard caulking guns.</li> </ul>				
Coverage	Capseal will yield Approx. 300 mL Injection resins will yield Approx. 250 mL (See Charts for specific coverage rates)				
Packaging	<ul> <li>Capseal (x2) 300 ml</li> <li>Injection Resin (x2) 250 ml</li> <li>Capseal mixer nozzle (x2)</li> <li>Capseal applicator fan (x2)</li> <li>Cartridge Flow Restrictor (x1)</li> <li>Injection resin mixers with extended tube</li> <li>Push fit connector (x1)</li> <li>Injection Ports (x16)</li> <li>Pair of Gloves (x2)</li> <li>Wooden Applicator (Tongue Depressor)</li> <li>Instructional DVD (x1)</li> </ul>				
	Typical Data (Material and curing condition RESULTS MAY DIFFER BASED UPON STATISTI TEMPERATURE, APPLICATION METHODS, TES Shelf Life 18 months in original Storage Conditions Store dry at 40°-75° Product Conditioning Condition dry at 40°- For Sikadur Injection Resin: Compressive Strength (ASTM D-695), psi MPa 4 hours 8 hours 1 day 3 days 7 days 14 days 28 days (68.9) Compressive Modulus (ASTM D-695) Viscosity Mixed (ASTM D-2393) Pot Life (ASTM C-881) Tensile Strength (ASTM D-638) Elongation at Break (ASTM D-638) Flexural Strength (ASTM D-732) Bond Strength (ASTM D-897) 2 day 14 days	CAL VARIATIONS D ST METHODS, ACTU. I, unopened conta P F (5°-24°C) -75°F (5°-24°C) -75°F (5°-24°C) 200,000 psi 500 cps 25-30 min. (60g 6000 psi 25% 250,000 psi 10,000 psi 350 psi (concrei 450 psi (concrei	EPENDING UPON N AL SITE CONDITION iners. 40°F - - 1500 (10.3) 6500 (44.8) 7500 (51.7) 9000 (62.1) mass)	IXING METHODS ANI	
	Water Absorption (ASTM D-570) Heat Deflection Temp. (ASTM D-648) VOC:	0.24% 109.7°F Capseal: Inj. Resin:	30 g/L 5 g/L		



### For Sikadur Capseal:

Temp. (°F)	Gel Time (min)	Ready for Injection (min)
40	18	145
50	10	85
68	6	50
77	5	40
86	4	35

Coverage Rates:

Consumption of Crack Injection Resin in a crack					
Length (in) Width (in) Depth (in) Cu. Inches # of Tube					# of Tubes
1/16" wide crack - 1" deep and 10 ft. Long	120	0.062	1	7.44	0.4
1/16" wide crack - 1.5" deep and 10 ft. Long	120	0.062	1.5	11.16	0.6
1/16" wide crack - 2" deep and 10 ft. Long	120	0.062	2	14.88	0.8
1/8" wide crack - 1" deep and 10 ft. Long	120	0.125	1	15	0.8
1/8" wide crack - 1.5" deep and 10 ft. Long	120	0.125	1.5	22.5	1.2
1/8" wide crack - 2" deep and 10 ft. Long	120	0.125	2	30	1.6
1/4" wide crack - 1" deep and 10 ft. Long	120	0.25	1	30	1.6
1/4" wide crack - 1.5" deep and 10 ft. Long	120	0.25	1.5	45	2.4
1/4" wide crack - 2" deep and 10 ft. Long	120	0.25	2	60	3.2

Consumption of Crack Injection Paste on a crack					
Length (in) Width (in) Depth (in) Cu. Inches # of Tube					# of Tubes
1" Wide Strip - 10 ft. Long and 1/8" thick	120	1	0.125	15	0.8
1" Wide Strip - 10 ft. Long and 1/4" thick	120	1	0.25	30	1.6
1.5" Wide Strip - 10 ft. Long and 1/8" thick	120	1.5	0.125	22.5	1.2
1.5" Wide Strip - 10 ft. Long and 1/4" thick	120	1.5	0.25	45	2.4
2.0" Wide Strip - 10 ft. Long and 1/8" thick	120	2	0.125	30	1.6
2.0" Wide Strip - 10 ft. Long and 1/4" thick	120	2	0.25	60	3.2

How to Use	
Surface Preparation	Substrate Preparation - For a successful application, very thorough preparation is a must. The crack to be treated must be dry and free from oil, grease, dust and other contaminants. Any loose material must be blown or brushed clear.
	For Vertical Cracks (walls, columns, beams) - The surface of the crack should be sealed with the fast set- ting Sikadur Capseal supplied. The Capseal should also be used to affix the injection ports. The distance between the injection ports should be greater than the estimated depth of the crack (typically 1.5 times. If depth is not known, consult technical services).
	For Horizontal Cracks (floors, slabs, etc.) - The Sikadur Capseal and injection ports may not be required as the resin may be introduced into the crack by gravity.
Mixing	Cartridge Set Up:
U	Sikadur Capseal - Open screw cap, cut film to remove metal clip and attach nozzle, extrude waste until a uniform color is achieved.
	Sikadur Injection Resin - Remove screw cap, insert outlet plugs, attach mixer nozzle with extension tube*. Extrude waste to form a homogeneous mix. Use the push fit connector to connect to injection port.
	*For horizontal cracks (floor, slab, etc.), remove the extension tube.
Application	For Vertical Cracks (walls, columns, beams) - The resin should be injected into the first (lower) port. When the resin begins to flow from the adjacent port, close off the first port and disconnect the hose. Reconnect to the second port and inject until resin starts to flow from the third; this process is repeated until the whole crack has been injected. After the resin has been allowed to cure, the injection ports and capseal should be removed and any holes or voids should be filled.
	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND
R INST	RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA
	ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-
	TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-

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Construction

	For Horizontal cracks (floors, slabs, etc.) - To gravity feed cracks, seal the underside of the substrate prior to filling if the crack reflects through. Dispense the injection resin slowly into the vee-notched crack. Continue injecting until completely filled.
Removal	After the resin has been allowed to cure, the injection ports and capseal should be mechanically removed and any holes or voids should be filled.
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (5°C). Maximum substrate temperature 95°F (45°).</li> <li>Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.</li> <li>Do not apply over wet, glistening surfaces.</li> <li>Not for injection of cracks subjected to osmotic or hydrostatic pressure during application.</li> <li>Do not inject cracks greater than 1/4 in (6mm). Consult Sika Technical Services.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> <li>NOT FOR USE AS AN ANCHORING ADHESIVE.</li> </ul>

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## **Sikadur® Injection Gel** High-modulus, high-strength, structural, non-abrasive, smooth epoxy paste adhesive

Description	Sikadur <sup>®</sup> Injection Gel, is a 2-component, 100% solids, moisture-tolerant, high-modulus, high-strength, structural epoxy. When mixed it gives a smooth, non-abrasive, paste adhesive. It conforms to the current ASTM C-881, Types I and IV, Grade-3, Class-C and AASHTO M-235 specifications.
Where to Use	<ul> <li>Structural crack repairs not exceeding 1/4 in. (6 mm) width.</li> <li>Mechanical grouting, machine and 'robotic' base plates, bearing pads, etc.</li> <li>Waterproofing tunnels, cable vaults, tanks, basements, etc.</li> <li>Re-anchoring of veneer masonry. Consult a design professional prior to use.</li> <li>Wood-truss repairs.</li> <li>Preventive maintenance - grout large cracks on new or existing structures to seal off reinforcing steel from the elements of corrosion.</li> <li>Anchor grouting, bolts, dowels, pins and special fasteners. Consult a design professional prior to use.</li> <li>As a pick-proof sealant around windows, doors, lock-ups, etc. inside correctional facilities.</li> </ul>
Advantages	<ul> <li>Unique, non-abrasive texture permits application with automated pressure-injection equipment.</li> <li>Tolerant of moisture before, during, and after cure.</li> <li>High-modulus, high-strength, structural-paste adhesive.</li> <li>Excellent adhesion to masonry, concrete, wood, steel and most structural materials.</li> <li>Paste consistency ideal for vertical and overhead grouting of cracks.</li> <li>Convenient easy mix ratio A:B = 1:1 by volume.</li> <li>Excellent lubricity for deep penetration.</li> </ul>
Coverage	1 gal. yields 231 in <sup>3</sup> of epoxy paste adhesive.
Packaging	4 gal. units.

Typical Data (Mat	erial and curing condi	itions @ 73°F (23°C) an	d 50% R.H.)			
		IATIONS DEPENDING UPON M DDS, ACTUAL SITE CONDITION	XING METHODS AND EQUIPMENT,			
Shelf Life	2 years in original, un					
Storage Conditions	Store dry at 40°-95°F using.	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before				
Color	Gray.					
Mixing Ratio	Component 'A' : Com	ponent 'B' = 1:1 by volum	ne.			
Consistency	Smooth, non-sag pas	ste.				
Pot Life	Approximately 30 mir	nutes. (60 gram mass)				
Elong	e Strength 4,30 ation at Break 1.3%	0 psi (29.7 MPa) 5 < 10⁵ psi (2,829 MPa)				
•	ASTM D-790) ral Strength (Modulus or ent Modulus of Elasticity	• /	6,700 psi (46.2 MPa) 7.5 x 10⁵ psi (5,175 MPa)			
Shear Strength (AST	M D-732) 14 day	Shear Strength	3,700 psi (25.5 MPa)			
2 day (dry cure)	<ul> <li>b hardened concrete</li> <li>Bond Strength</li> <li>Bond Strength</li> </ul>	3,000 psi (20.6 MPa) 2,500 psi (17.2 MPa) 2,600 psi (17.9 MPa)				
	Bond Strength re) Bond Strength	3,300 psi (22.7 MPa) 2,600 psi (17.9 MPa)				
	perature (ASTM D-648 stress loading = 264 psi	,	120°F (49°C)			
Water Absorption (A	STM D-570) 7 day	(24 hr. immersion)	0.11%			

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	Compressive Pro		2)			
	Compressive Su	4 hour	40°F*** (4°C)	73°F*** (23°C)	<b>90°F (32°C)</b> 300 (2.1)	
		8 hour	-	- 300 (2.1 MPa)	6,500 (44.8)	
		16 hour	100 (0.7)	7,500 (51.7)	7,000 (48.3)	
		1 day	1,400 (9.6)	8,000 (55.1)	9,500 (65.5)	
		3 day	7,600 (52.4)	8,500 (58.7)	10,000 (68.9)	
		7 day	9,000 (62.1)	9,000 (62.1)	10,000 (68.9)	
		14 day	10,000 (68.9)	10,000 (68.9)	10,000 (68.9)	
		28 day	10,000 (68.9)	10,000 (68.9)	10,000 (68.9)	
	Compressive Mc **Cured and tested at th *See limitations section	ne temperatures indic		1,863 MPa)		
How to Use						
Surface Preparatio			nay be dry or damp, but vaxes and any other cor	free of standing water. Ren ntaminants.	nove dust, laitance, greas	
	<b>Concrete</b> - Should I blast-cleaning or eq			ance and contaminant fre	e, open textured surface l	
	Steel - Should be cl	eaned and prepa	ared thoroughly by blast	-cleaning.		
Mixing	injection equipment Pre-mix each com	. Follow the recon ponent. Proporti for 3 minutes with	mmendations and direc on equal parts by volur n Sika paddle on low-sp	I to be mixed and applied tions supplied by the equi ne of Component 'B' and eed (400-600 rpm) drill ur	pment manufacturer. Component 'A' into a clea	
Application	substrate for positiv	e adhesion. Sec		njection Gel to the prepare nly into place until the adl 1/8 in. (3 mm).		
	<b>To seal injection ports and cracks for injection grouting</b> - Place the neat mixed material over the cracks to be pressure-injected and around each injection port. Allow sufficient time to set before pressure-injecting.					
	To anchor bolts, dowels, pins - Annular space around bolt should not exceed 1/8 in. (3 mm); depth of embedment is typically 10-15 times the bolt diameter. Grout with neat Sikadur® Injection Gel.					
	<ul> <li>To grout cracks - Use automated injecting equipment or manual method. Set appropriate injection ports based on the system used. Cracks up to 1/4 in. (6 mm) wide may be grouted.</li> <li>To anchor bolts, dowels, pins in hollow masonry or concrete block - Consult Sika Technical Service at 800-</li> </ul>					
	933-7452.		-	eplate and bearing pads		
		alant - use autor		d. Apply an appropriate si	ze bead of material arour	
	0		t Sikadur <sup>®</sup> Injection Gel			
Limitations		ion of solvents w	emperature 40°F (4°C). ill prevent proper cure.			
Limitations	<ul> <li>Material is a vaport</li> <li>Not for sealing cr</li> </ul>	acks under hydro	static pressure.	s in lighting and/or UV ex	posure.	
	Material is a vapo Not for sealing cr Not an aesthetic PRIOR TO EACH USE OF INSTRUCTIONS ON THE SHEET WHICH ARE AVAII PARTMENT AT 800.933.74 TO READ AND FOLLOW	acks under hydro product. Color m ANY SIKA PROI PRODUCT'S MOS LABLE ONLINE A 52 NOTHING CON THE WARNINGS A	ostatic pressure. ay alter due to variation DUCT, THE USER MUST ST CURRENT PRODUCT T HTTP://USA.SIKA.COI ITAINED IN ANY SIKA M AND INSTRUCTIONS FO	s in lighting and/or UV exp ALWAYS READ AND FOL DATA SHEET, PRODUCT W OR BY CALLING SIKA'S ATERIALS RELIEVES THE R EACH SIKA PRODUCT A TA SHEET PRIOR TO PRO	LOW THE WARNINGS AN LABEL AND SAFETY DA' TECHNICAL SERVICE D USER OF THE OBLIGATIC S SET FORTH IN THE CU	
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Product Data Sheet Edition 9.23.2014 Sikadur® 55 SLV

## Sikadur<sup>®</sup> 55 SLV

# Super low-viscosity, moisture-tolerant epoxy resin, crack healer/penetrating sealer

Description	Sikadur <sup>®</sup> 55 SLV is a 2-component, 100% solids, moisture-tolerant, epoxy crack healer / penetrating sealer, having a fast tack-free time to minimize downtime. It is a super low-viscosity, high-strength adhesive formulated specifically for sealing both dry and damp, existing, non-dynamic cracks. It conforms to the current ASTM C-881, Types I and II, Grade-1, Class-C* and AASHTO M-235 specifications. * except for gel time	
Where to Use	<ul> <li>Sikadur<sup>®</sup> 55 SLV seals cracked concrete.</li> <li>For interior slabs and exterior above-grade slabs.</li> <li>For elevated horizontal decks, parking garages and other structures exposed to foot and pneumatic tire traffic.</li> </ul>	
Advantages	<ul> <li>Super low viscosity/low surface tension for excellent penetration into existing cracks.</li> <li>Seals existing cracks by gravity down to 2 mils (0.002" / 0.05 mm) in width.</li> <li>Prolongs life of cracked concrete.</li> <li>Penetrates and seals surface from water absorption, chloride-ion intrusion, and chemical attack (patent pending technology).</li> <li>Improves concrete surface by reducing water and chloride intrusion.</li> <li>Can be open to traffic in 6 hours at 73°F (23°C).</li> <li>High bond strength, even in damp cracks.</li> <li>U.S. Patent No. (pending) for ultra low viscosity healer/sealer to strengthen cracked concrete.</li> </ul>	
Coverage	1 gal. (3.8 liters) yields 231 cu. in. (3,785 cm <sup>3</sup> ) Typical coverage is 150-175 ft <sup>2</sup> /gal. (3.7-4.3 m <sup>2</sup> /L) for surface sealing. Coverage varies with porosity and surface profile of substrate. Higher porosity concrete will reduce coverage. For crack healing, follow Application instructions and allow to pond over cracks.	
Packaging	3 gal. (11.35 l) unit = 'A' = 2 gal. (7.6 l) + 'B' = 1 gal. (3.8 l)	

#### Typical Data [Material and curing conditions @ 73°F (23°C) and 50% R.H.]

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original, unopened containers				
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.				
Color	Clear, amber				
Mixing Ratio	Component 'A' : Component 'B' = 2:1 by volume				
Viscosity (Mixed)	Approximately 105 cps	Approximately 105 cps			
Pot Life	Approximately 20 minutes				
Tack-Free Time	<b>40°F (4°C)</b> * > 11 hrs.	<b>60°F (15°C)</b> * 11 hrs.	<b>73°F (23°C)*</b> 6 hrs.	<b>90°F (32°C)*</b> 2.5 hrs.	
Tensile Properties (A 7 day	STM D-638) 73°F (23°C) Tensile Strength Elongation at break	) 7,100 psi (48.9 MF 10%	<sup>c</sup> a)		
Bond Strength (ASTI Hardened Concre	M C-882) ete to Hardened Concrete	2 day (moist cure 14 day (moist cu			
Hardened Concre	ete to Steel	2 day (moist cure 14 day (moist cur		,	
Flexural Properties (	ASTM D-790)				
7 day	Flexural Strength Tangent Modulus of Elastic		(58.6 MPa) psi (2,206 MPa)		
Shear Strength (AST	M D-732) 7 day	5,800 psi	(40.0 MPa)		
Heat Deflection Temp	Heat Deflection Temperature (ASTM D-648) 7 day				
[fiber stress loading =	[fiber stress loading = 264 psi (1.8 MPa) 110°F (43°C)				
Water Absorption (A	STM D-570) 7 day (24 h	nour immersion)	0.60%		



	Compressive Pro		,		
	1 day 3 day 7 day 14 day 28 day	<b>40°</b> F (4°C)* 2,000 (13.8) 7,800 (53.8) 9,600 (66.2) 11,700 (80.7)	<b>60°F (15°C)*</b> 320 (2.2) 6,500 (44.8) 10,400 (71.7) 11,000 (75.8) 12,000 (82.7)	<b>73°F (23°C)*</b> 1,100 (7.6) 8,300 (57.2) 10,900 (75.1) 11,800 (81.4) 12,000 (82.7)	<b>90°F (32°C)*</b> 4,800 (33.1) 8,000 (55.2) 8,300 (57.2) 10,000 (68.9) 10,000 (68.9)
	Compressive Mo	dulus 7 day	/ 3.0 x 10⁵	psi (2,068 MPa)	
How to Use Surface Preparation	compounds, waxe means (i.e. shot bl	s, impregnations, asting, sandblasti er Cleaning or Hig	foreign particles, ng, etc.). For best i	coatings and disinte results, substrate sho	ust, laitance, grease, oils, curin grated materials by mechanic uld be dry. Surfaces prepared l buld be allowed to dry for 24 hi
Mixing		jiffy mixer on a lov			oail. Mix thoroughly for 3 minute Ily blended. Mix only that quanti
Application	material over area a epoxy with roller lea sand before applyir A second treatment treatment, wait a m oven-dried 20/40 sil sq. ft Allow to cure	Ind allow to pond o ving no visible suff- ing Sikadur® 55 SLV may be required c inimum of 20-30 m ica sand or similar 6 hours minimum	ver cracks. Let mate ace film. For cracks 7. Seal cracks from n very porous subs inutes at 73°F (23°C). Rei at 73°F (23°C). Rei	erial penetrate into crack greater than 1/8 in. (3 r underside, when access trates. Apply second tr C) before broadcasting enly over the surface to move any loose sand a	/ flat squeegee or broom. Sprecks and substrate. Remove excemm) wide, fill crack with oven-drives sible, to prevent leakage. eatment before broadcasting Affig sand. Cover with broadcast of a percess at a rate of 30-40 lbs./10 and open to traffic once epoxy here.
	To pressure inject cracks with Sikadu When the epoxy ac	t <b>cracks:</b> Use auto r <sup>®</sup> 31, Hi-Mod Gel Ihesive has cured, or additional inform	mated injection eq , Sikadur <sup>®</sup> Injection inject Sikadur <sup>®</sup> 55 ation. Mock ups to	Gel or Sikadur <sup>®</sup> And SLV with steady press ascertain penetration	tion. ate injection ports. Seal ports a horFix 2/Sikadur® AnchorFix 50 sure. Consult Technical Service non job site conditions is strong
Limitations	cause surface w Not an aesthetic Sealed concrete Allow sufficient t Application temp Minimum ambie Do not inject cra Minimum age of Not designed to Penetration resu	or barrier after cu ain is imminent. W thitening. product. Color m surface may app ime for the substr perature of substra nt and substrate to cks greater than ' concrete is 21-28 seal or inject crac ults will vary. Factor d material), geom	re. /ater exposure or h ay alter due to vari- ear blotchy due to ate to dry after rain ate must be minimu- emperature 40°F (- //4 in. (6 mm) Cor days, depending ks under hydrosta prs that may imped etry of crack, conc	numidity will affect sur iations in lighting and differential absorptior n or other inclement c um 5°F (3°C) above ti 4°C). Maximum applio nsult Technical Service on curing and drying a tic pressure during ap le penetration include crete porosity, and dirf	n. onditions. he dew point. cation temperature 95°F (35°C e at 1-800-933-SIKA. conditions. oplication. , but are not limited to, temper
IN: SH PA TC	STRUCTIONS ON THE IEET WHICH ARE AVAI RTMENT AT 800.933.74	PRODUCT'S MOS LABLE ONLINE AT 152 NOTHING CON THE WARNINGS AI	CURRENT PRODU HTTP://USA.SIKA.C FAINED IN ANY SIKA ND INSTRUCTIONS	JCT DATA SHEET, PRC COM/ OR BY CALLING A MATERIALS RELIEVE FOR EACH SIKA PROI	ND FOLLOW THE WARNINGS AN DOUCT LABEL AND SAFETY DA SIKA'S TECHNICAL SERVICE D IS THE USER OF THE OBLIGATIO DUCT AS SET FORTH IN THE CU TO PRODUCT USE.
For actu befo Prio Data	further information and ac al Safety Data Sheets cont re using the product. In ca r to each use of any Sika pr Sheet, product label and \$	lvice regarding transp aining physical, ecolog ise of emergency, call oduct, the user must a Safety Data Sheet whic	ortation, handling, sto gical, toxicological and CHEMTREC at 1-800-4 ways read and follow t h are available online a	rage and disposal of chem other safety related data. F 24-9300, International 703- he warnings and instructio t http://usa.sika.com/ or by	ns on the product's most current Prod y calling Sika's Technical Service Depa
men for e proc SIK/ the d Buy EXP SHA THE SAL	t at 800-933-7452. Nothing each Sika product as set fo luct use. A warrants this product for current Product Data Sheet er's sole remedy shall be lir RESS OR IMPLIED SHALL LL NOT BE LIABLE UNDEF USE OF THIS PRODUCT IN	contained in any Sika rth in the current Proc one year from date of if used as directed wit nited to the purchase p APPLY INCLUDING AR ANY LEGAL THEORY A MANNER TO INFRIN.	naterials relieves the u luct Data Sheet, produc installation to be free f hin shelf life. User dete rice or replacement of j IY WARRANTY OF MER FOR SPECIAL OR CON 3E ON ANY PATENT OR	ser of the obligation to read ct label and Safety Data Sh rom manufacturing defects rmines suitability of produc product exclusive of labor of CHANTABILITY OR FITNE SEQUENTIAL DAMAGES. S ANY OTHER INTELLECTUA	d and follow the warnings and instructi
O Visi	t our website at usa.sika jonal Information and Sa Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800.933.7452		enue Sika Fraco		t your regional center.

Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537

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## **SikaPronto® 19 TF** Fast traffic time, high molecular weight methacrylate, crack healer/penetrating sealer

Description	SikaPronto® 19 TF is a 2-component, rapid-curing, solvent-free, high molecular weight methacrylate, crack
	healer/penetrating sealer, with an extremely fast traffic time to minimize downtime.
Where to Use	<ul> <li>Use on grade, above and below grade on concrete and mortar. SikaPronto® 19 TF seals surface of concrete from water and chlorides.</li> <li>For horizontal decks, slabs, patios, driveways, parking garages, and other substrates exposed to foot</li> </ul>
	and pneumatic-tire traffic.
Advantages	<ul> <li>Penetrates cracks by gravity.</li> </ul>
	<ul><li>Structurally improves concrete surface.</li><li>Opens to traffic in under 3 hours.</li></ul>
	<ul> <li>Easy-to-use, 2-component system.</li> </ul>
	<ul> <li>Does not produce a vapor barrier.</li> <li>Low viscosity for easy, topical applications and excellent penetration into cracks.</li> </ul>
	Low odor.
	<ul><li>High bond strength.</li><li>Prolongs life of cracked concrete.</li></ul>
	<ul> <li>As a penetrating sealer, SikaPronto<sup>®</sup> 19 TF reduces water absorption and chloride-ion intrusion.</li> </ul>
Coverage	Typical coverage is 90-150 ft <sup>2</sup> /gal. for crack healing and surface sealing. Coverage varies with porosity and surface profile of substrate. Higher porosity will reduce coverage.
Packaging	1 gal. units, 4/carton; 4.5 gal. units.
	Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life         Component 'A': 3 months in original, unopened container.           Component 'B': 6 months in original, unopened container.
	<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°- 24°C) before using. Storage at higher temperatures may cause mate- rial to pre-polymerize and will reduce shelf life.
	Color Dark purple when liquid; light amber after cure.
	Mixing Ratio         Plant-proportioned kit; mix entire unit.
	Methacrylate Monomer Viscosity 25 cps maximum.
	Pot Life Approximately 15 minutes.
	Bulk Cure Time 90 minutes maximum.
	Traffic Time 3 hours maximum.
	Flexural Properties (ASTM D-790)
	<b>1 day</b> Flexural Strength (Modulus of Rupture) 2,500 psi (17.2 MPa)
	Bond Strength (ASTM C-882): Hardened concrete to hardened concrete
	2 day(dry cure)Bond Strength2,100 psi(14.4 MPa)14 day(moist cure)Bond Strength2,300 psi(15.8 MPa)
	Compressive Properties (ASTM D-695) Compressive Strength, psi (MPa)
	40°F* (4°C) 73°F* (23°C) 90°F* (32°C)
	1 hour         -         1,000 (6.8)         1,900 (13.1)           2 hour         -         2,300 (15.8)         2,700 (18.6)
	<b>1 day</b> 1,800 (12.4) 2,900 (20.0) 3,500 (24.1)
	7 day         3,500 (24.1)         3,100 (21.3)         4,300 (29.6)           * Material cured and tested at the temperatures indicated.
	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND
R	INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA
Sa	SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION
	TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

How to Use	
Surface Preparation	Substrate must be clean, sound and free of surface moisture. Remove dust, laitance, grease, oils, curing com- pounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e., blast cleaning). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.
Mixing	Before adding 'B' Component, mix 'A' Component for 30 seconds with a low-speed drill using a Sika paddle. Empty entire contents of 'B' Component into pail containing 'A' Component. Mix for 3 minutes with a low speed drill (400-600 rpm) using a Sika paddle. Caution: Mix only that quantity that can be placed within the pot life. Material should be quickly poured from pail onto concrete surface to prolong working life.
Application	SikaPronto <sup>®</sup> 19 TF is applied to horizontal surfaces by roller, squeegee or broom. Spread material over area and allow to pond over cracks. Let material penetrate into cracks and substrate; remove excess material leaving no visible surface film. For cracks greater than 1/8 in. (3 mm) wide, fill crack with oven-dried sand before applying SikaPronto <sup>®</sup> 19 TF. Seal cracks from underside, when accessible, to prevent leakage.
	A second treatment may be required on very porous substrates. Apply second treatment before broadcasting. After treatment, wait at least 20 minutes at 73°F (23°C); cover with light broadcast of a dry 8/20 or similar sand. Distribute evenly over the surface at a rate of 15 to 20 lbs./100 ft <sup>2</sup> Allow to cure 3 hours at 73°F (23°C). Remove any loose sand and open to traffic. Consult Sika Technical Service for additional information.
Limitations	<ul> <li>Do not delay broadcasting more than 20 minutes @ 73°F (23°C).</li> <li>Do not thin. Addition of solvents will prevent proper cure.</li> <li>Minimum ambient and substrate temperature 35°F (2°C).</li> <li>Minimum age of concrete is 21-28 days, depending on curing and drying conditions.</li> <li>Sealed concrete surface may appear blotchy due to differential absorption.</li> <li>Not designed to seal cracks subject to hydrostatic pressure at the time of application.</li> </ul>

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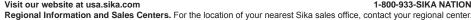
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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 5.4.2016 SikaFix HH+

## **SikaFix<sup>®</sup> HH+** Hydrophobic, expanding, polyurethane, chemical grout

Description	SikaFix HH+ is a hydrophobic polyurethane foam grout that, when used with accelerator, is de- signed to stop water infiltration and fill voids outside a structure or joint and cracks in concrete structures. It may also be used in applications with high pressure flowing water.
Where to Use	<ul> <li>Fill joints or cracks in concrete structures that exhibit some movement</li> <li>Fill voids such as rock fissures, crushed fault or gravel layers</li> <li>May be used in applications with high pressure water flow</li> <li>Curtain wall grouting below grade structures</li> </ul>
Advantages	<ul> <li>Easy to apply, one component with accelerator</li> <li>Hydrophobic, only a small amount of water is needed for reaction</li> <li>Expands up to 30 times the liquid volume</li> <li>Non-flammable</li> <li>Contains no volatile solvents</li> </ul>
Packaging	5 gal. metal pail. SikaFix Accelerator is available in 1 pint containers and SikaFix Pump Flush is available in 5 gal. pails. Sold separately.

#### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Self Life	1 year in original unopened container			
Storage	Store in a dry area between 40°F - 90°F (4°C - 32°C) using original re-sealable containers			
VOC	0 g/L			
Uncured				
Solids	100%			
Viscosity	700 cps @ 74°F (23°C)	ASTM D1638		
Color	Amber			
Specific Gravity	1.13			
Flashpoint COC method	>200°F	ASTM D93		
Toxicity	Non-toxic			
SikaFix Accelerator				
Appearance	Transparent liquid			
Viscosity	25 cps @ 74°F (23°C)	ASTM D1638		
Specific Gravity	.95			
Flashpoint	216°F	ASTM D3278-96		
Cured				
Density	4 lbs/ft <sup>3</sup>	ASTM D1622		
Tensile Strength	29 psi	ASTM D638		
Elongation	44%	ASTM D412		
Shear	17 psi	ASTM C273		
Absorption	<1%	ASTM D2842		
Shrinkage	<1%			
Service Temperature	180°F (82°C) max			
	Storage VOC Uncured Solids Viscosity Color Specific Gravity Flashpoint COC method Toxicity SikaFix Accelerator Appearance Viscosity Specific Gravity Flashpoint Cured Density Tensile Strength Elongation Shear Absorption Shrinkage	StorageStore in a dry area between 40°F - 90°IVOC0 g/LUncuredSolids100%Viscosity700 cps @ 74°F (23°C)ColorAmberSpecific Gravity1.13Flashpoint COC method>200°FToxicityNon-toxicSikaFix AcceleratorYes @ 74°F (23°C)AppearanceTransparent liquidViscosity25 cps @ 74°F (23°C)Specific Gravity.95Flashpoint216°FCuredPonsityDensity4 lbs/ft³Tensile Strength29 psiElongation44%Shear17 psiAbsorption<1%		

Values given are not intended to be used in specific preparation



Cure Mechanism	Temperature	Gel time in minutes/seconds	
	50º F (10º C)	3 m 15 s	1
	68º F (20º C)	2 m 10 s	
	77º F (25º C)	1 m 20 s	
	86º F (30º C)	1 m 10 s	
	recommended 5 gallon:1 pint i	rator dosage, corresponding with the atio of SikaFix HH+ to SikaFix Accelerator. gitated by shaking the container prior to use.	]
How to Use			
Surface Preparation	When the crack is contaminated on the outside, it will be necessary to clean the crack surface so that the crack can be exactly located. If the crack is wide or high water flows are encountered, it will be necessary to seal the surface of the crack with a surface sealing material (SikaSet Plug or open cell polyurethane foam saturated with SikaFix HH+). The surface sealing can be done before or after drilling the injection holes, depending on the particular situation.		
Mixing	Prior to installation, the material should be agitated by vigorously shaking the 5-gallon pail or by mix- ing with a jiffy mixer, bung mixer or by hand. Prior to using SikaFix Accelerator, the container should be shaken vigorously as the contents may settle during storage. For normal use, each 5 gallon unit of SikaFix HH+ should be used with one pint container of SikaFix Accelerator, a dosage of 2.5%. The grout should never be used with more than 5% SikaFix Accelerator. Excess acceleration will cause vigorous expansion that is prone to shrinkage. Pour the desired amount of SikaFix HH+ into a clean pail. Measure the appropriate amount of SikaFix Accelerator and pour it into the SikaFix HH+ and mix adequately.		
Application	to intersect the crack m Spacing of the injection necessary to flush the d This will also ensure the crack. Begin the injection packer flushed for a hori water from the crack. O pumping and reinstall th to the second packer ar Disconnect and go bac Some ports may take a Continue process until the	idway through the substrate. Ins ports depends on crack width, rilled holes with water to remove at the crack is wet enough to re- on of the grout at the lowest pace zontal crack. During the injection continue injecting until the grout he packer in the adjacent hole. Ind begin injection. Continue the k to the first packer and inject a dditional grout, which will fill up the length of the prepared crack	he crack at a 45 degree angle. Drill the hole stall injection packers in the holes and tighten but normal varies from 6" to 36". It is always debris and drill dust from the holes and crack act with the grout when it is introduced to the cker installed on a vertical crack or at the firs , you will notice that the SikaFix HH+ displaces t appears at the adjacent packer hole. Stop Tighten the packer and move the pump hose process until 3-4 packers have been grouted all the ports for the second time if necessary and further densify the material in the crack is injected. Note: Injection pressure will vari- crack, thickness of concrete and condition of
Removal	to a solid on the surface		moved with a scraper as long as it is not cure nove with a wire brush or hand held grinders s.
Tooling & Finishing	This will react with the re can be cut flush with the	esin left behind in the drill hole. A concrete surface or can be remore removing the packers. Packer h	installed packer with a small amount of water fter the injection, the packers or injection port oved from the injection holes. Let SikaFix HH- oles can be filled with Sikadur 31, SikaRepai
Limitations	allowed to freeze, i Avoid splashing wate Water used to activa Material must be stor Material must be pre Ambient temperature Must be used in conf	t will lower performance of the p er into open containers, as mate te SikaFix HH+ must be in a ran red between 40°F - 90°F (4°C - conditioned to between 60°F - 9 e must be between 40°F - 90°F ( ined spaces	rial is water activated ige of pH 3-10 for optimum foam quality 32°C) i0°F (16°C - 32°C) before use



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> Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

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# SikaFix<sup>®</sup> HH Hydrophilic

Low viscosity, expanding, polyurethane chemical grout

SikaFix <sup>®</sup> HH Hydrophilic is a nonflammable hydrophilic polyurethane resin designed to form a flexible gasket or plug joints and cracks in concrete from water infiltration. In its uncured form, SikaFix <sup>®</sup> HH Hydrophilic is a pale yellow liquid. When it comes in contact with water, the grout expands quickly and cures to a tough, flexible, adhesive, closed cell foam that is essentially unaffected by mildly corrosive environments.	
<ul> <li>Sealing leaks through concrete cracks and joints.</li> <li>Saturating backer rod to seal joints by the gasket method.</li> </ul>	
<ul> <li>Contains no volatile solvents.</li> <li>Non-flammable.</li> <li>Free Foam expands to 25 times its liquid volume.</li> <li>High elongation creates tight seal in moving cracks.</li> </ul>	
5 gallon pail.	
Water.	
Unaffected by mildly corrosive environments.	

#### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life Storage Conditions	1 year in original, unopened container. Store in a dry area between 40°F-90°F (4°C-32°C) using original re-sealable containers. Low temperatures will affect viscosity. To minimize this effect store the product at room temperature for a minimum period of 24 hours prior to use. Material must be preconditioned to between 60°F-90°F (16°C-32°C) before use. If site temperatures are extremely low, heat bands or heated water baths may be used on the pails, before and during use to maintain the products temperature. Immerse only the lower 2/3 of the pails. Avoic splashing water into open containers. Do not use if ambient temperature is below 40°F (4°C).					
Uncured						
Solids	100%					
Viscosity	650 cps @ 74°F (23°C)	ASTM D 1638				
Color	Pale yellow					
Specific Gravity	1.16 @ 74°F (23°C)					
Flash Point	>200°F					
Corrosiveness	Non-corrosive					
Reaction initiation time						
1:1 with water	30 sec @ 77°F (25°C)					
Cured						
Density	4 lbs/ft <sup>3</sup>	ASTM D 1622				
Tensile Strength	170 psi	ASTM D 638				
Elongation	400%	ASTM D 638				
Shrinkage	<1%					
Values given are not to be u	Values given are not to be used in a specific preparation.					



How to Use	
Surface Preparation	When the crack is contaminated at the outside, it will be necessary to clean the crack surface so that the crack can be exactly located. If the crack is wide or high water flows are encountered, it will be necessary to seal the surface of the crack with a surface sealing material (SikaSet® Plug, Sikadur® 31 Hi Mod Gel, or open cell polyurethane foam saturated with SikaFix® HH Hydrophilic). The surface sealing can be done before or after drilling the injection holes, depending on the particular situation.
Mixing	Prior to installation the material should be agitated vigorously shaking the 5 gallon pail or by mixing with a jiffy mixer, bung mixer or by hand. During injection the grout will follow the path of least resistance. When the material has stopped migrating, it will continue to expand against the confines of the crack/joint and compress within itself, forming a very dense, closed cell material and stopping the leak.
Application	Begin by drilling 5/8" diameter holes along the side of the crack at a 45 degree angle. Drill the hole to intersect the crack midway through the substrate. Install injection packers in the holes and tighten. Spacing of the injection ports depends on crack width, but normal varies from 6" to 36". It is always necessary to flush the drilled holes with water to remove debris and drill dust from the holes and crack. This will also ensure that the crack is wet enough to react with the grout when it is introduced to the crack. Begin the injection of the grout as the lowest packer installed on a vertical crack, or at the first packer flushed for a horizontal crack. During the injection, you will notice that the SikaFix <sup>®</sup> HH Hydrophilic displaces water from the crack. Continue injecting until the grout appears at the adjacent packer hole. Stop pumping and reinstall the packer in the adjacent hole. Tighten the packer and move the pump hose to the second packer and begin injection. Continue the process until 3-4 packers have been grouted. Disconnect and go back to the first packer and inject all the ports for the second time if necessary. Some ports may take additional grout, which will fill up and further densify the material in the crack. Continue process until the length of the prepared crack is injected.
	Note: Injection pressure will vary from 200 psi to 2500 psi depending on the width of the crack, thickness of concrete and condition of concrete.
Tooling & Finishing	When finished with the injection process, re-inject each installed packer with a small amount of water. This will react with the resin left behind in the drill hole. After the injection, the packers or injection ports can be cut flush with the concrete surface or can be removed from the injection holes. Let SikaFix <sup>®</sup> HH Hydrophilic completely cure before removing the packers. Packer holes can be filled with Sikadur <sup>®</sup> 31 or SikaSet <sup>®</sup> Plug and troweled smooth.
Removal	Residual resin that has foamed from the crack can be removed with a scraper as long as it is not cured to a solid on the surface. If the material has cured, remove with a wire brush or hand held grinders. SikaFix <sup>®</sup> HH Hydrophilic will aggressively bond to concrete surfaces.
Limitations	<ul> <li>Low temperatures will significantly affect viscosity and reaction time.</li> <li>Avoid splashing water into open containers, as material is water activated.</li> <li>Water used to activate SikaFix<sup>®</sup> HH Hydrophilic must be in a range of pH 3-10 for optimum foam quality.</li> <li>Material must be stored between 40°F-90°F (4°C-32°C).</li> <li>Material must be preconditioned to between 60°F - 90°F (16°C - 32°C) before use.</li> <li>Ambient temperature must be between 40°F - 90°F (4°C - 32°C) for use.</li> <li>Use only in applications where exposure to moisture is constant.</li> </ul>

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Product Data Sheet Edition 7.13.2016 SikaFix<sup>®</sup> HH LV

# SikaFix<sup>®</sup> HH LV

#### Low viscosity, expanding, polyurethane chemical grout

Description		ophobic polyurethane that, when used alou or plug joints and cracks in concrete from	ne or with SikaFix <sup>®</sup> Accelerator, is designed water infiltration.	
Where to Use	<ul> <li>Sealing leaks through concrete cracks and joints.</li> <li>Defective concrete (cracked and honeycombed).</li> <li>Limestone (tunnels, dams).</li> <li>Pipe intrusions.</li> <li>Wastewater tanks.</li> <li>Sewers, manholes, utility boxes, etc.</li> </ul>			
Advantages	<ul> <li>Easy to apply, one component with accelerator.</li> <li>Hydrophobic, only a small amount of water is needed for reaction.</li> <li>Expands up to 30 times in volume depending upon the amount of SikaFix® Accelerator used.</li> <li>Low viscosity permits injection into narrow hair line cracks.</li> <li>Excellent elongation creates tight seal in moving cracks.</li> <li>Tenacious adhesion to wet and dry surfaces.</li> <li>Contains no volatile solvents.</li> <li>ANSI Standard 61 potable water compliant</li> <li>5 gal plastic pail; 1 pint plastic container.</li> </ul>			
Cure Mechanism	Temperature	Gel Time (Accelerator dosage %)	]	
	50°F (10°C)	3m 10s (2.5%) 12m 0s (0%)	-	
	68°F (20°C)	1m 50s (2.5%) 6m 15s (0%)		
	77°F (25°C)	1m 15s (2.5%) 5m 10s (0%)		
	86°F (30°C)	1m 05s (2.5%) 4m 0s (0%)		
	recommended 5 gallon:1 p	ix <sup>®</sup> Accelerator dosage, corresponding with the init ratio of SikaFix <sup>®</sup> HH LV to SikaFix <sup>®</sup> Accelerator, esponding with no SikaFix <sup>®</sup> Accelerator added.		

and a 0% dosage, corresponding with no SikaFix<sup>®</sup> Accelerator added. SikaFix<sup>®</sup> Accelerator must be agitated by shaking the container prior to use.

Non-corrosive

#### **Typical Data**

Corrosiveness

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life Storage	Low temperatures will affect viscos	ner. 90°F (4°C-32°C) using original re-sealable containers. ity. To minimize this effect, store the product at room f 24 hours prior to use. Material must be preconditioned
	to between 60°F-90°F (16°C-32°C) to bands or heated water baths may b	before use. If site temperatures are extremely low, heat e used on the pails, before and during use to maintain only the lower 2/3 of the pails. Avoid splashing water into
Uncured		
Solids	100%	
Viscosity	500 cps @ 74°F	ASTM D1638
Color	Amber	
Specific Gravity	1.15 @ 74°F (23°C)	
Flashpoint	>200°F	ASTM D93



	Appearance Viscosity	Transparent liquid 25 cps @ 74°F (23°C)	ASTM D1638	
	Specific Gravity	.95 @ 74°F (23°C)	ASTNI D1030	
	Flashpoint	216°F	ASTM D3278-96	
	Cured			
	Density	4 lbs/ft <sup>3</sup>	ASTM D1622	
· · · · · · · · · · · · · · · · · · ·	Tensile Strength	29 psi	ASTM D638	
	Elongation	44%	ASTM D638	
	Shear	17 psi	ASTM C273	
	Absorption	<1%	ASTM D2842	
	Shrinkage	<1%		
	Service Temp	180°F (82°C) maximum		
	Values given are not intended to	be used in specific preparation.		
How to Use				
Surrace Preparatio	can be exactly located. If th the surface of the crack with polyurethane foam saturate	e crack is wide or high water flo a surface sealing material (Sika	ssary to clean the crack surface so that the cra ws are encountered, it will be necessary to so Set® Plug, Sikadur® 31 Hi Mod Gel, or open of face sealing can be done before or after drilli	
Mixing	a jiffy mixer, bung mixer or vigorously as the contents r should be used with one pin used with more than 5% Sika to shrinkage. Pour the desir	Prior to installation, the material should be agitated by vigorously shaking the 5-gallon pail or by mixing wit a jiffy mixer, bung mixer or by hand. Prior to using SikaFix <sup>®</sup> Accelerator, the container should be shake vigorously as the contents may settle during storage. For normal use, each 5 gallon unit of SikaFix <sup>®</sup> HH L' should be used with one pint container of SikaFix <sup>®</sup> Accelerator, a dosage of 2.5%. The grout should never b used with more than 5% SikaFix <sup>®</sup> Accelerator. Excess acceleration will cause vigorous expansion that is pron to shrinkage. Pour the desired amount of SikaFix <sup>®</sup> HH LV into a clean pail. Measure the appropriate amour of SikaFix <sup>®</sup> Accelerator and pour it into the SikaFix <sup>®</sup> HH LV and mix adequately.		
	injection ports depends on or drilled holes with water to re- crack is wet enough to reac as the lowest packer installed the injection, you will notice the grout appears at the ad Tighten the packer and mov- until 3-4 packers have beer the second time if necessar	crack width, but normal varies from the grout when it is introdued on a vertical crack, or at the f that the SikaFix <sup>®</sup> HH LV displace jacent packer hole. Stop pumpine the pump hose to the second particular disconnect and go hard second second particular disconnect and go hard secon	ackers in the holes and tighten. Spacing of the one 6" to 36". It is always necessary to flush the holes and crack. This will also ensure that the ced to the crack. Begin the injection of the grainst packer flushed for a horizontal crack. During and reinstall the packer in the adjacent horizonker and begin injection. Continue the proceed to the first packer and inject all the ports all grout, which will fill up and further densify the prepared crack is injected.	
	<b>Note:</b> Injection pressure wil concrete and condition of co		epending on the width of the crack, thickness	
Tooling & Finishir	will react with the resin left b flush with the concrete surfa	whind in the drill hole. After the in ace or can be removed from the	njection, the packers or injection ports can be of injection holes. Let SikaFix® HH LV complete	
Tooling & Finishir	will react with the resin left b flush with the concrete surfa cure before removing the pa smooth. Residual resin that has foar	ehind in the drill hole. After the in ace or can be removed from the ickers. Packer holes can be filled ned from the crack can be remov naterial has cured, remove with	alled packer with a small amount of water. The njection, the packers or injection ports can be of injection holes. Let SikaFix® HH LV complete with Sikadur® 31 or SikaSet® Plug and trowel wed with a scraper as long as it is not cured to a wire brush or hand held grinders. SikaFix® H	

SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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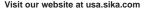
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Product Data Sheet Edition 2.24.2015 Sika CarboDur

## Sika CarboDur<sup>®</sup> Carbon fiber laminate for structural strengthening

	strengthening	concrete, timber	Sika CarboDur is a pultruded carbon fiber reinforced polymer (CFRP) laminate designed for strengthening concrete, timber and masonry structures. Sika CarboDur is bonded onto the structure as external reinforcement using Sikadur 30 epoxy resin as the adhesive.		
/here to Use	Load increase Increased liv Increased tr Installation of Vibrating str Changes of Damage to str Aging of cor Steel reinfor Vehicle imp Fire Serviceability Decrease ir Stress redu Crack width Change in str Removal of Design or con Insufficient	e loads in wareh affic volumes on of heavy machine uctures building utilizatio <b>uctural parts</b> istruction materia cement corrosion act improvements of deformation ction in steel reir	nouses bridges ery in industrial bu als n n nforcement	-	
dvantages	<ul> <li>Wery high st</li> </ul>				
	<ul> <li>Lightweight</li> <li>Typical Data</li> </ul>	U			
	Typical Data RESULTS M TEMPERAT Base Shelf Life Color Tensile Streng Desi Modulus of E Modulus of E Modulus of E Elongation at Design Strain Thickness Temperature Fiber Volumer Density	gth 1 Value gn Value lasticity 1 Value Break Resistance tric Content	ETHODS, TEST METHO Carbon fil Unlimited Black 4.49 x 10 4.06 x 10 23.9 x 10 23.2 x 10 1.69% 0.85% 0.047 in. >300°F ( >68%	. ,	ND CURING CONDITIONS. an epoxy resin matrix.
	Typical Data RESULTS M TEMPERAT Base Shelf Life Color Tensile Streng Modulus of E Modulus of E Modulus of E Elongation at Design Strain Thickness Temperature Fiber Volume	gth 1 Value gn Value lasticity 1 Value Break Resistance tric Content	ETHODS, TEST METHO Carbon fil Unlimited Black 4.49 x 10 4.06 x 10 23.9 x 10 23.2 x 10 1.69% 0.85% 0.047 in. >300°F ( >68%	2005, ACTUAL SITE CONDITIONS A ber reinforced polymer with a (no exposure to direct sunli <sup>5</sup> psi (3,100 MPa) <sup>5</sup> psi (2,800 MPa) <sup>3</sup> psi (165,000 MPa) <sup>5</sup> psi (160,000 MPa) (1.2 mm) >150°C)	ND CURING CONDITIONS. an epoxy resin matrix.

	<ul> <li>Non-corrosive</li> <li>Unlimited lengths</li> <li>Minimal preparation of laminates</li> <li>Very easy to install, especially overhead</li> </ul>
	<ul> <li>High modulus of elasticity</li> <li>Outstanding fatigue resistance</li> <li>Alkali resistant</li> </ul>
	<ul> <li>Simple laminate intersections or crossings</li> </ul>
Coverage	Coverage of Sikadur 30 epoxy resin with CarboDur: Type S 512: approx. 50 LF/gallon. Type S 812: approx. 32 LF/gallon. Type S 1012: approx. 22 LF/gallon.
Packaging	Available in any length up to 250 m (820 ft.). Type S 512 width 50 mm (approx. 2"). Type S 812 width 80 mm (approx. 3"). Type S 1012 width 100 mm (approx. 4").
How to Use	
Surface Preparati	<b>Solution</b> Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Existing uneven surfaces must be filled with an appropriate repair mortar (e.g. mixed Sikadur 30 epoxy with the addition of 1 part oven-dried sand). The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	<ul> <li>Surface Levelness/Irregularities: Maximum allowable deviation in 6 ft. shall be limited to 1/4" (6 mm) but no greater than 1/8" (3 mm) per foot. Any sharp edges (i.e. fins, form-marks, etc.) must be ground smooth and flush.</li> <li>Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture.</li> <li>CarboDur - Wipe clean with appropriate cleaner (e.g. MEK).</li> </ul>
	Cutting the CarboDur Laminate:
	<b>Preferred:</b> CarboDur laminates should be cut with tools using a "shearing" force (e.g. guillotine or heavy duty shears). Care must be taken to support both sides of the CarboDur laminate to avoid splintering.
	Alternate: A hack saw or other abrasive cutting method may be used. However, extra care must be taken to support the CarboDur laminate on both sides to avoid splintering. In addition, extra care must be taken to avoid exposure to carbon dust
Mixing	Consult Sikadur 30 technical data sheet for information on epoxy resin.
Application	Apply the neat mixed Sikadur 30 epoxy onto the concrete with a trowel or spatula to a nominal thickness of 1/16" (1.5 mm). Apply the mixed Sikadur 30 epoxy onto the CarboDur laminate with a "roof-shaped" spatula to a nominal thickness of 1/16" (1.5 mm). Within the open time of the epoxy, depending on the temperature, place the CarboDur laminate onto the concrete surface. Using a hard rubber roller, press the laminate into the epoxy resin until the adhesive is forced out on both sides. Remove excess adhesive. Glue line should not exceed 1/8 inch (3 mm). The external reinforcement must not be disturbed for a minimum of 24 hours. The epoxy will reach its design strength after 7 days.
Limitations	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer. Design guidelines are available from Sika Corporation.</li> </ul>
li S F T	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND NSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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Da me for	ior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product ata Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart- ent at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction r each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to oduct use.
thu BL E2 SF TH SA	KA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on e current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Jyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES (PRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA HALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR IE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. ALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY ALLING 201-933-8800.
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Construction



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Product Data Sheet Edition 2.24.2015 Sika CarboDur Rods

## Sika CarboDur<sup>®</sup> Rods Carbon fiber rods for structural strengthening

	Description	strengthening concrete, timber Near Surface Mounted (NSM) t	and masonry structures. The echnique by inserting into gro	olymer (CFRP) rods designed for rods are primarily installed using the oves cut into the substrate and bonded SikaWrap fabrics for positive attach-
	Where to Use	<ul> <li>Negative moment reinforcing i</li> <li>Anchoring of SikaWrap fabrics</li> <li>Strengthening of masonry wall</li> <li>Doweling applications</li> <li>Cathodic protection application</li> <li>Load increases</li> <li>Increased live loads in wareho</li> <li>Increased loading in parking de</li> <li>Installation of heavy machinery</li> <li>Vibrating structures</li> <li>Changes of building utilization</li> <li>Damage to structural parts</li> <li>Aging of construction materials</li> <li>Steel reinforcement corrosion</li> <li>Vehicle impact</li> <li>Fire</li> <li>Serviceability improvements</li> <li>Decrease in deformation</li> <li>Stress reduction in steel reinfo</li> <li>Crack width reduction</li> <li>Change in structural system</li> <li>Removal of slab sections for op</li> <li>Design or construction defects</li> <li>Insufficient reinforcements.</li> </ul>	s uses ecks / rcement penings	
	Advantages	<ul> <li>Very high strength</li> <li>Lightweight</li> <li>Non-corrosive</li> <li>Very easy to handle</li> <li>High modulus of elasticity</li> <li>Can accept traffic on surface (not strength st</li></ul>	rods are countersunk)	
		Typical Data RESULTS MAY DIFFER BASED UPON STU TEMPERATURE, APPLICATION METHOD		PON MIXING METHODS AND EQUIPMENT, DITIONS AND CURING CONDITIONS.
		Base Shelf Life Color Tensile Strength Tensile Modulus of Elasticity Strain (Elongation at Break) Fiber Volumetric Content Temperature Resistance Physical Properties	Carbon fiber reinforced Unlimited (no exposure Black 4.06 x 10 <sup>5</sup> (2,800 MPa 22.5 x 10 <sup>6</sup> psi (155,00 1.8% 65% >300°F (>150°C)	ı)
r		Diameter 1/4 in. 3/8 in.	Cross Sectional Area 0.05 sq. in. 0.11 sq. in.	Tensile Strength 12,500 lbs. 27,500 lbs.
F		STRUCTIONS ON THE PRODUCT'S MOS HEET WHICH ARE AVAILABLE ONLINE A	ST CURRENT PRODUCT DATA SH T HTTP://USA.SIKA.COM/ OR BY	READ AND FOLLOW THE WARNINGS AND HEET, PRODUCT LABEL AND SAFETY DATA CALLING SIKA'S TECHNICAL SERVICE DE- S RELIEVES THE USER OF THE OBLIGATION

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Constructi

	- High bond stron	ath due to full enconculation	22		
		gth due to full encapsulation sible once installed	וונ		
	<ul> <li>Outstanding fati</li> </ul>	gue resistance			
Coverage	<ul> <li>Alkali resistant</li> </ul>	dur 20 or Sikodur 22. Hi N	And anowy racin with Sike (	CarboDur Dada: 1/	1 in diam
Coverage of Sikadur 30 or Sikadur 32, Hi-Mod epoxy resin with Sika CarboDur Rods: 1 eter approx. 85 LF/gal. (1/2 x 1/2 in. slots); 3/8 in. diameter: approx. 60 LF/gal. (5/8 x 5/					
Packaging	Custom cut leng			<b>U</b>	, ,
How to Use					
Surface Preparatio	appropriate conc but free of standi waxes, foreign p	rete saw or diamond blade ng water and frost. Remove	It a groove into the concrete Surface must be clean and e dust, laitance, grease, curi erials and other bond inhibit sed air prior to installation.	l sound. It may be ng compounds, im	dry or damp, pregnations,
	roughened textu	clean, shotblast or use ot re.	her approved mechanical m	neans to provide a	n open
Cutting the Rods	Rods may be cu		vith a diamond blade on a c		er. The rods
		•	tting zone to minimize splin	•	
Mixing			echnical data sheet for info	rmation on epoxy	resin.
Application		ounted Application	ne substrate to receive the		_
	mixed Sikadur 30 Sikadur 30 has a 32, Hi-Mod has a AnchorFix is pac vertical, or overh press the Carbol in the grooves. S <b>Anchoring Sika</b> To provide additi tions, the fabric r into the concrete AnchorFix, depe the CarboDur Ro	D), Sikadur 32, Hi-Mod or S paste consistency and ma a honey-type consistency a kaged in cartridges and ca ead applications. Within th Dur Rods into the epoxy in Strike the surface with a tro Wrap Fabrics onal anchorage for SikaWin nay be positively attached as described above. Fill t nding on the orientation. F	ing and cleaning the surfac ikadur AnchorFix into the gr ay be use for vertical and or and may be used for horizon in be injected directly into the e open time of the epoxy, d the grooves. Apply additio owel to force out any air and rap Fabrics in shear or flexu into grooves in the concrete he grooves with either Sika Place the saturated fabric ov sitive attachment. Fill in an hat might be present.	rooves approximal verhead application ntal applications. S ne grooves for hor lepending on the to nal epoxy over the d provide a clean in ural strengthening e at the ends. Cut dur 30, Sikadur 32 ver the grooves, an	tely half-full. ns. Sikadur Sikadur izontal, emperature, e rods to fill nstallation. applica- t grooves 2 or Sikadur nd press
Limitations	Design calculation	ons must be made and cer	tified by an independent lice	ensed professiona	l engineer.
IN S P, T R KEE For act bef Pri Dat me for prc SIK	ISTRUCTIONS ON THE HEET WHICH ARE AVAIL ARTMENT AT 800.933.74 O READ AND FOLLOW T ENT PRODUCT DATA SH PCONTAINER TIGHTLY CLOSED. F further information and ad ual Safety Data Sheets conta ore using the product. In case or to each use of any Sika pro- ta Sheet, product label and S int at 800-933-7452. Nothing c each Sika product as set for duct use.	PRODUCT'S MOST CURRENT ABLE ONLINE AT HTTP://US, 52 NOTHING CONTAINED IN A HE WARNINGS AND INSTRUC IEET, PRODUCT LABEL AND S KEEP OUT OF REACH OF CHILDREN. NOT F vice regarding transportation, hanc ining physical, ecological, toxicolo se of emergency, call CHEMTREC a educt, the user must always read an afety Data Sheet which are availabl ontained in any Sika materials relie th in the current Product Data Sheet one year from date of installation to	SER MUST ALWAYS READ AN PRODUCT DATA SHEET, PRO A.SIKA.COM/ OR BY CALLING NY SIKA MATERIALS RELIEVE CTIONS FOR EACH SIKA PROD SAFETY DATA SHEET PRIOR T OR INTERNAL CONSUMPTION. FOR INDUST illing, storage and disposal of chem gical and other safety related data. R t 1-800-424-9300, International 703-5 d follow the warnings and instructior e online at http://usa.sika.com/ or by wes the user of the obligation to read at, product label and Safety Data Sh be free from manufacturing defects	DUCT LABEL AND S SIKA'S TECHNICAL S THE USER OF THE DUCT AS SET FORTH O PRODUCT USE. RIAL USE ONLY. FOR PROFES ical products, users shi ead the current actual S 527-3887. Ins on the product's most realling Sika's Technical and follow the warnings eet prior to s and to meet the technic	SAFETY DATA SERVICE DE- COBLIGATION IN THE CUR- SSIONAL USE ONLY. ould refer to the afety Data Sheet current Product I Service Depart- s and instruction
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Product Data Sheet Edition 9.23.2014 Sikadur® 30

## Sikadur<sup>®</sup> 30

High-modulus, high-strength, structural epoxy paste adhesive for use with Sika<sup>®</sup> CarboDur<sup>®</sup> reinforcement.

Description	Sikadur <sup>®</sup> 30 is a 2-component, 100% solids, moisture-tolerant, high-modulus, high-strength, structural epoxy paste adhesive. It conforms to the current ASTM C-881 Type I, IV Grade 3, Class C and AASHTO M-235 specifications.		
Where to use	<ul> <li>Adhesive for bonding external reinforcement to concrete, masonry, steel, wood, stone, etc.</li> <li>Structural bonding of composite laminates (Sika® CarboDur® CFRP) to concrete.</li> <li>Structural bonding of steel plates to concrete.</li> <li>Suitable for use in vertical and overhead configurations.</li> <li>As a binder for epoxy mortar repairs.</li> </ul>		
Advantages	<ul> <li>Long pot life.</li> <li>Long open time.</li> <li>Tolerant of moisture before, during and after cure.</li> <li>High strength, high modulus, structural paste adhesive.</li> <li>Excellent adhesion to concrete, masonry, metals, wood and most structural materials.</li> <li>Fully compatible and excellent adhesion to Sika® CarboDur® CFRP composite laminate.</li> <li>Paste consistency ideal for vertical and overhead applications of Sika® CarboDur®.</li> <li>High abrasion and shock resistance.</li> <li>Convenient easy mix ratio A:B=3:1 by volume.</li> <li>Solvent-free.</li> <li>Color-coded components to ensure proper mixing control.</li> </ul>		
Coverage	Type S 512 CarboDur®: approx. 50 LF/gal.; Type S 812 CarboDur: approx. 32 LF/gal.; Type S 1012 CarboDur®: approx. 22 LF/gal.		
Packaging	1 gal. units.		
	Typical Data (Material and curing conditions @ 73°F {23°C} and 50% R.H.)RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.Shelf Life2 years in original, unopened containers.		
	Storage Conditions         Store dry at 40°-95°F (4°-35°C). Condition material to 65°-85°F (1 29°C) before using.	8°-	
	Color Light gray		
	Mixing RatioComponent 'A': Component 'B' = 3:1 by volume.ConsistencyNon-sag paste.		
	Pot Life Approximately 70 minutes @ 73°F (23°C) (1 qt.)		
	Tensile Properties (ASTM D-638)		
	7 dayTensile Strength3,600 psi (24.8 MPa)Elongation at Break1%Modulus of Elasticity6.5 X 10⁵ psi (4,482 MPa)		
	Flexural Properties (ASTM D-790)		
	14 dayFlexural Strength (Modulus of Rupture)6,800 psi (46.8 MPa)Tangent Modulus of Elasticity in Bending1.7 X 106 psi (11,721 MPa)		
	Shear Strength (ASTM D-732) 14 day Shear Strength 3,600 psi (24.8 MPa)		
	Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete		
	2 day (moist cure)Bond Strength2,700 psi (18.6 MPa)2 day (dry cure)Bond Strength3,200 psi (22.0 MPa)14 day (moist cure)Bond Strength3,100 psi (21.3 MPa)Hardened Concrete to Steel2,600 psi (17.9 MPa)		
	2 day (moist cure)Bond Strength3,000 psi (20.6 MPa)2 day (dry cure)Bond Strength2,600 psi (17.9 MPa)14 day (moist cure)Bond Strength		
	Heat Deflection Temperature (ASTM D-648)		
	7 day[fiber stress loading=264 psi (1.8 MPa)]118°F (47°C)Water Absorption (ASTM D-570)7 day (24 hour impersion)0.03%		
	Water Absorption (ASTM D-570)       7 day (24 hour immersion)       0.03%		

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	Compressive Proper		Compressive Strength, p	
	4 ho	40°F* (4°C)	73°F* (23°C)	
	4 hot 8 hot		3,500 (24.1)	5,500 (37.9) 6,700 (46.2)
	16 hou		6,700 (46.2)	7,400 (51.0)
	1 day		,	7,800 (53.7)
	3 day	•	, , ,	8,300 (57.2)
	7 day		/ / / /	8,600 (59.3)
	14 day			8,900 (61.3)
	28 day		, , , , ,	9,000 (62.0)
	Compressive Modulu			9,000 (02.0)
		•	x 10⁵ psi (2,689 MPa)	
	*Material cured and tested at t	the temperatures indicated.		
How to Use Surface Preparation	ICRI surface-pr in. (1 mm). Surf Remove dust, la materials, and c an appropriate strength of the by ACI 503R, A with concrete s	ofile chips. Localized ou face must be clean and aitance, grease, curing other bond inhibiting mat repair mortar (e.g., Sika concrete must be verifu STM C1583) at the disc ubstrate failure.	ut-of-plane variations, includ sound. It may be dry or dan compounds, impregnations terials from the surface. Exis adur® 30 with the addition of ed after surface preparatior retion of the engineer. Minir	surface profile (CSP) 3 defined by th ding form lines, should not exceed 1/3 np, but free of standing water and fros , waxes, foreign particles, disintegrate sting uneven surfaces must be filled wit 1 part oven-dried sand). The adhesiv n by random pull-off testing (as define num tensile strength, 200 psi (1.4 MPa al means to provide an open roughene
		be cleaned and prepare /ipe clean with appropria	ed thoroughly by blast clean ate cleaner (e.g. MEK).	ing to a white metal finish.
Mixing	clean pail or ap speed (400-600	ppropriately sized mixing prom) drill until uniform	g container. Mix thoroughly in color. Mix only that quant	parts Component 'A' by volume into for 3 minutes with Sika paddle on lov ity which can be used within its pot life
		•••	add up to 1 part by loose v until uniform in consistency	olume of an oven-dried aggregate to
Application	or spatula to a laminate with a the epoxy, depe a hard rubber ro Remove excess not be disturbed	nominal thickness of 1 "roof-shaped" spatula ending on the temperatu oller, press the laminate s adhesive. Glue line sh d for a minimum of 24 h	//fö" (1.5 mm). Apply the r to a nominal thickness of 1 ure, place the CarboDur® lar into the epoxy resin until th bould not exceed 1/8 inch (3 bours. The epoxy will reach	dur <sup>®</sup> 30 onto the concrete with a trow nixed Sikadur <sup>®</sup> 30 onto the CarboDu /16" (1.5 mm). Within the open time i ninate onto the concrete surface. Usir le adhesive is forced out on both side mm). The external reinforcement mu its design strength after 7 days.
			atching: Work the material exceed 1 inch (25 mm).	l into the prepared substrate, filling th
Limitations	<ul> <li>Do not thin</li> <li>Use oven-o</li> <li>Maximum g</li> <li>Maximum a</li> <li>Porous sub</li> </ul>	<ul> <li>Addition of solvents wi dried aggregate only.</li> <li>glue line of neat epoxy i epoxy mortar thickness uge of concrete must be postrates must be tested</li> </ul>	s 1/8 inch (3 mm). is 1 inch (25 mm) per lift. 21-28 days, depending upo for moisture vapor transmis	on curing and drying conditions. ssion prior to mortar applications. lighting and/or UV exposure.
INST SHEI PART TO R RENT	RUCTIONS ON THE PROD ET WHICH ARE AVAILABLE TMENT AT 800.933.7452 NO EAD AND FOLLOW THE W T PRODUCT DATA SHEET, I	UCT'S MOST CURREN E ONLINE AT HTTP://US ITHING CONTAINED IN A VARNINGS AND INSTRU PRODUCT LABEL AND	T PRODUCT DATA SHEET, SA.SIKA.COM/ OR BY CALL ANY SIKA MATERIALS RELI CTIONS FOR EACH SIKA P SAFETY DATA SHEET PRO	D AND FOLLOW THE WARNINGS AN PRODUCT LABEL AND SAFETY DAT ING SIKA'S TECHNICAL SERVICE DI EVES THE USER OF THE OBLIGATIO RODUCT AS SET FORTH IN THE CUP OR TO PRODUCT USE.
For fur actual	ther information and advice reg Safety Data Sheets containing p	garding transportation, han hysical, ecological, toxicolo	dling, storage and disposal of	chemical products, users should refer to th ata. Read the current actual Safety Data She
Data Si ment a	heet, product label and Safety D t 800-933-7452. Nothing contain h Sika product as set forth in th	eata Sheet which are availab ed in any Sika materials reli	le online at http://usa.sika.com/	uctions on the product's most current Produ or by calling Sika's Technical Service Depa read and follow the warnings and instruction ta Sheet prior to
the cur Buyer's EXPRE SHALL THE US SALE	rent Product Data Sheet if used s sole remedy shall be limited to ESS OR IMPLIED SHALL APPLY I NOT BE LIABLE UNDER ANY LE SE OF THIS PRODUCT IN A MANN	as directed within shelf life. the purchase price or replace INCLUDING ANY WARRANT EGAL THEORY FOR SPECIA VER TO INFRINGE ON ANY P/	User determines suitability of pr cement of product exclusive of la I'Y OF MERCHANTABILITY OR F L OR CONSEQUENTIAL DAMAG ATENT OR ANY OTHER INTELLE(	fects and to meet the technical properties of roduct for intended use and assumes all risk bor or cost of labor. NO OTHER WARRANTIE ITNESS FOR A PARTICULAR PURPOSE. SIN ES. SIKA SHALL NOT BE RESPONSIBLE FC CTUAL PROPERTY RIGHTS HELD BY OTHER NILABLE AT HTTP://USA.SIKA.COM/ OR E
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Region Si 20 Ly	nal Information and Sales Cer       ika Corporation     S       01 Polito Avenue     6i       yndhurst, NJ 07071     P	<b>Sika Canada Inc.</b> 01 Delmar Avenue Pointe Claire	bur nearest Sika sales office, cc Sika Mexicana S.A. de C. Carretera Libre Celaya Km Fracc. Industrial Balvanera	ntact your regional center. V. . 8.5
	ax: 201-933-6225 P	Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792	Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800	RESPONSIBLE CARE March Comparison of March Address Ad



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**Product Data Sheet** Edition 4.26.2016 Sikadur® 300

Sikadur<sup>®</sup> 300

impregnating resin

High-modulus, high-strength,

Description	Sikadur <sup>®</sup> 300 is a two-compo epoxy.	onent 100% solids, moisture-tolerant, high strength, high modulus		
Where to Use		Sikadur <sup>®</sup> 300 is used as a seal coat and impregnating resin for horizontal and vertical		
Advantages	<ul> <li>High strength, high mod</li> <li>Excellent adhesion to co</li> <li>Fully compatible and de</li> <li>High temperature resist.</li> </ul>	<ul> <li>Long pot life.</li> <li>Long open time.</li> <li>Easy to mix.</li> <li>Tolerant of moisture before, during and after cure.</li> <li>High strength, high modulus adhesive.</li> <li>Excellent adhesion to concrete, masonry metals, wood and most structural materials.</li> <li>Fully compatible and developed specifically for the SikaWrap® System.</li> <li>High temperature resistance.</li> <li>High abrasion and shock resistance.</li> </ul>		
Coverage	As a sealer: 100 ft. <sup>2</sup> /gal.	·		
		120 ft²/gal 9 oz. per sq.yd. fabrics 60 ft²/gal 18 oz. per sq.yd. fabrics 30 ft²/gal 37 oz. per sq.yd. fabrics		
Packaging	4 gallon units.			
	RESULTS MAY DIFFER BASED UI	<b>ial and curing conditions @ 73°F (23°C) and 50% R.H.)</b> PON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, IETHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 2 years in original, unopened container. Store dry at 40°-95°F (4°-35°C). Condition material to		
		65°-75°F (18°-24°C) before using.		
	Color Mixing Ratio	Clear, amber. Mix entire unit, do not batch.		
	Viscosity (mixed)	approx. 500 cps		
	Reactivity Tack Free (30 mils) ByK Drying R	6-7 hours (time to reach 10,000 cps) 14-16 hours Recorder		
	Service Temperature R			
	Mechanical Proper Tensile Strength (ASTI Tensile Modulus (ASTI Elongation @ Break (A	<b>M D-638)</b> 2.5 x 10 <sup>5</sup> psi (1,724 MPa)		
	Flexural Strength (AST			
	Flexural Modulus (AST	<b>FM D-790)</b> 5 x 10⁵ psi (3,450 MPa)		

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R

How to Use	
Surface Preparation	The concrete surface should be prepared to a minimum concrete surface profile (CSP) 3 as defined by the ICRI-surface-profile chips. Localized out-of-plane variations, including form lines, should not exceed 1/32 in. (1 mm). Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e., sandblast-ing). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.
Mixing	Pre-mix each component. Mix entire unit, do not batch. Pour contents of part B to part A. Mix thoroughly for 5 minutes on low using a paddle style mixer on low speed (400-600 rpm) drill until uniformly blended.
Application	As a sealer: Apply mixed Sikadur <sup>®</sup> 300 epoxy to a properly prepared substrate using a brush, roller or airless sprayer. Sikadur <sup>®</sup> 300 should be applied at a sufficient rate to fully saturate the substrate without producing a surface film. Coverage rates are based on a substrate with normal porosity.
	As an impregnating resin: As an impregnating resin for vertical and horizontal applications, use Sikadur <sup>®</sup> 300. Resins may be applied to fabric by either manual or automatic means. For further information, consult installation guidelines.
Limitations	<ul> <li>Minimum substrate and ambient temperature 50°F (10°C).</li> <li>Do not thin with solvents.</li> <li>Material is a vapor barrier after cure.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

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Constru



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## **Sikadur<sup>®</sup> 301** High-modulus, high-strength, impregnating resin

**Mechanical Properties** 

7 day

7 day

**Tensile Properties (ASTM D-638)** 

Flexural Properties (ASTM D-790)

**Compressive Properties (ASTM D-695)** 

Description	Sikadur <sup>®</sup> 301 is a two-component 100% solids, moisture-tolerant, high strength, high modulus structural epoxy adhesive.			
Where to Use	For use as a priming sealer and/or an encapsulating resin with the SikaWrap® Structural Strengthen ing System fabrics.			
Advantages	<ul> <li>High strength, high me</li> <li>Excellent adhesion to</li> <li>Fully compatible and e</li> <li>High temperature resi</li> <li>High abrasion and she</li> </ul>	<ul> <li>Easy to mix.</li> <li>Tolerant of moisture before, during and after cure.</li> <li>High strength, high modulus adhesive.</li> </ul>		
Coverage	As a sealer: Approx. 75 ft²/g	gal. (1.84 m²/liter). As an impregnating resin: Approx. 50 ft²/gal. (1.23 m²/liter).		
Packaging	4 gallon unit (15.14 liters).	4 gallon unit (15.14 liters).		
	RESULTS MAY DIFFER BASED U	and curing conditions @ 73°F (23°C) and 50% R.H.) PON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, IETHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.		
	Shelf Life	2 years in original, unopened container.		
	Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°- 75°F (18°-24°C) before using.		
	Color	Light gray		
	Mixing Ratio	Component 'A' : Component 'B' = 3 : 1 by volume		
	Viscosity (mixed)	Approx. 2,700 cps		
	Pot Life	Approx. 40 minutes (1 gallon volume)		
	Contact Time	Approx. 90 minutes		
	Heat Deflection Temperat	ture (ASTM D-648) 7 day 117°F (47°C)		
	Glass Transition Tempera	ature (Tg) 7 day 120°F (49°C)		



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Tensile Strength Modulus of Elasticity

Elongation at break

Flexural Strength

Tangent Modulus

**Compressive Strength** 

**Compressive Modulus** 

Strain at Yield

1 day

3 day

7 day

8,000 psi (52.0 MPa)

290 ksi (2,000 MPa)

13,000 psi (90.0 MPa)

500 ksi (3,448 MPa)

3.5%

3.0%

4,000 psi (27.6 MPa)

11,900 psi (82.1 MPa)

13,900 psi (96.0 MPa)

250 ksi (1,725 MPa)

How to Use Surface Preparation	The concrete surface should be prepared to a minimum concrete surface profile (CSP) 3 as defir by the ICRI-surface-profile chips. Localized out-of-plane variations, including form lines, should exceed 1/32 in. (1 mm).				
	Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oi curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materia by mechanical means (i.e. sandblasting). For best results, substrate should be dry. However, saturated surface dry condition is acceptable.				
Mixing	Pre-mix 'A' component, ('B' component does not require mixing). Mix entire unit, do not batch. P contents of Part 'B' into Part 'A'. Mix thoroughly for 5 minutes using a paddle style mixer on speed (400-600 rpm) rotary drill until uniformly blended.				
Application	As a sealer: Apply mixed Sikadur <sup>®</sup> 301 epoxy to a properly prepared substrate using a brush roller. Sikadur <sup>®</sup> 301 should be supplied at a sufficient rate to fully saturate the substrate. Covera rates are based on a substrate with normal porosity.				
	As an impregnating resin: Saturate SikaWrap® fabrics until fibers are completely wet-out. vertical and overhead installations, Sikadur® 330 may be used first to prime/tack the substrate p to installing the fabric.				
	Sikadur <sup>®</sup> 301 can be applied in either Dry Lay-Up or Wet Lay-Up fabric installation procedur. Consult the SikaWrap fabric technical data sheet for more information. If used as an impregnative resin in the Wet Lay-Up procedure, Sikadur <sup>®</sup> 301 should be manually applied onto both sides the fabric using a brush or roller. After saturating, excess resin should be removed from the wetfabric using a squeegee.				
	Due to the mixed viscosity of Sikadur <sup>®</sup> 301, an automated fabric-saturating device sho not be used. If automated fabric-saturating device is intended for use, consult the techn data sheets for appropriate impregnating resins (i.e. Sikadur <sup>®</sup> 300 or Sikadur <sup>®</sup> Hex 300).				
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C). Maximum substrate and ambient temperature 95°F (35°C).</li> <li>Do not thin with solvents.</li> <li>Material is a vapor barrier after cure.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>At low temperatures and/or high relative humidity, a slight oily residue (blush) may form on surface of the cured Sikadur® 301 epoxy. If an additional layer of fabric or a coating is to be app onto the cured epoxy, this residue must first be removed to ensure adequate bond. The residue can be removed with either a solvent wipe or with water and detergent. In both cases, the surfashould be wiped dry prior to application of the next layer of fabric or coating.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>				
INSTRUCTIO SHEET WHIO PARTMENT / TO READ AN	ACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS A INS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY D CH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGAT ID FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE C UCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.				
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before using the Prior to each us Data Sheet, pro ment at 800-933	e of any Sika product, the user must always read and follow the warnings and instructional 703-527-3887. e of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Pro duct label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Dep -7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruc- oduct as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to				
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## Sikadur<sup>®</sup> 330 US

#### High-modulus, high-strength, impregnating resin

Description	Sikadur <sup>®</sup> 330 is a two-component, solvent-free, moisture-tolerant, high strength, high modulu structural epoxy adhesive.		
Where to Use	For use as an impregnating resin with the SikaWrap <sup>®</sup> Hex 106G, 113C, 117C, 230C and 430G Structural Strengthening Systems.		
Advantages	<ul> <li>Long pot life.</li> <li>Long open time.</li> <li>Easy to mix.</li> <li>Tolerant of moisture before, during and after cure.</li> <li>High strength, high modulus adhesive.</li> <li>Excellent adhesion to concrete, masonry, metals, wood and most structural materials.</li> <li>Fully compatible and developed specifically for the SikaWrap<sup>®</sup> Systems.</li> <li>High temperature resistance.</li> <li>High abrasion and shock resistance.</li> <li>Solvent-free, VOC compliant.</li> </ul>		
Coverage	First coat: 40-50 ft. <sup>2</sup> /gal.; Additional coats: 100 ft. <sup>2</sup> /gal.; Final coat: 160 ft. <sup>2</sup> /gal.		
Packaging	3.2 gal. kit / (2) two 1.25 gal. Component "A" pails, (2) two 0.35 gal. Component "B" pails		

#### **Typical Data** (*Material and curing conditions* @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,

TEMPERATURE,	APPLICATION METHOD	S, TEST METHODS, ACTU		CURING CONDITIONS.	
Shelf Life		2 years in original, unopened container.			
<b>Storage Conditions</b> Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.					
Color		Light gray.			
Mixing Rati	0	Component 'A' : C	Component 'B' = 4 :	: 1 by weight	
Consistenc	у	Non-sag paste.			
Pot Life		57 minutes (325 r	ml)		
Tack Free T	ïme	4-5 hours			
Heat Deflec	tion Temperatur	e (ASTM D-648)			
<b>7 day</b> [fil	ber stress loading	g=264 psi (1.8 MPa	i) 120°F (50°C	;)	
Mechanic	al Properties	- -			
Compressiv	ve Properties (A	STM D-695), psi (I	MPa)		
	40°F (4°C)	60°F (16°C)	73°F (23°C)	90°F (32°C)	
8 hour	-	-	-	8,000 (55.2)	
1 day	-	8,100 (55.8)	10,700 (73.7)	10,600 (73.1)	
	8,100 (55.8)	, , ,	, , ,	11,000 (75.8)	
	11,200 (77.2)	, , ,	, , ,	, , ,	
14 day	12,500 (86.2)	12,400 (85.5)	11,800 (81.3)	11,900 (82.0)	
Tensile Stre	ength (ASTM D-6	(38) 7 <b>(</b>	<b>dav</b> 4 900 psi (3)	3.8 MPa)	

# Iensile Strength (ASTM D-638) 7 day 4,900 psi (33.8 MPa) Elongation @ Break (ASTM D-638) 7 day 1.2% Flexural Strength (ASTM D-790) 7 day 8,800 psi (60.6 MPa) Flexural Modulus (ASTM D-790) 7 day 5.06 x 10<sup>5</sup> psi (3,489 MPa)



How to Use					
Surface Preparation	The concrete surface should be prepared to a minimum concrete surface profile (CSP-3) as defined by the ICRI-surface-profile chips. Localized out-of-plane variations, including form lines, should not exceed 1/32 in. (1 mm).				
	Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e. sandblasting). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.				
Mixing	Pre-mix each component. Mix entire unit, do not batch. Pour contents of part B to part A. Mix thor- oughly for 5 minutes with a 1/2 inch "Jiffy" mixer mounted on a rotary drill and set at a slow speed (400-600 rpm) until uniformly blended. Mix only that quantity that can be used within its pot life.				
Application	<b>Dry Lay-Up:</b> When installing a SikaWrap® Hex fabric in the dry lay-up process apply the mixed Sika- dur® 330 epoxy resin directly onto the substrate at a rate of 40-50 ft.²/gal. (0.95-1.18 m²/L). Coverage rate will depend on the actual surface profile. This equates to a thickness of approximately 32-40 mils. Carefully place the fabric into the applied resin with gloved hands and smooth out. Work out any irregularities or air pockets with a plastic laminating roller. Let the resin squeeze out between the rovings of the fabric. If more than one layer of fabric is required, apply additional Sikadur® 330 US at a rate of 100 ft.²/gal. (2.37 m²/L) and repeat as described above. This equates to a thickness of approximately 16 mils. Add a final layer of Sikadur® 330 US onto the exposed surface at a rate of 160 ft²/gal. (3.79 m²/L). This equates to a thickness of approximately 10 mils. <b>Wet Lay-Up:</b> When installing a SikaWrap® Hex fabric vertically or overhead in the wet lay-up process,				
	mixed Sikadur <sup>®</sup> 330 can be applied to the substrate as a primer/tack coat to prevent the impregnated fabric from sliding down the concrete. Due to its mixed viscosity, do not use Sikadur <sup>®</sup> 330 US with an automatic fabric saturating device. Consult the SikaWrap <sup>®</sup> Hex fabric technical data sheet for information on saturating/impregnating fabric in a wet lay-up installation.				
Limitations	<ul> <li>Minimum age of concrete is 21-28 days, depending on curing and drying conditions.</li> <li>All repairs required to achieve a level surface must be performed prior to application.</li> <li>Do not apply or cure Sikadur<sup>®</sup> 330 US in direct sunlight.</li> <li>Minimum substrate temperature 40°F (4°C). Maximum application temperature 95°C (35°C)</li> <li>Do not thin with solvents.</li> <li>Material is a vapor barrier after cure.</li> <li>Do not encapsulate saturated concrete in areas of freezing and thawing.</li> <li>Color of Sikadur 330 US may alter due to variations in lighting and/or UV exposure.</li> <li>Due to its mixed viscosity, do not use Sikadur 330 US with an automatic saturating device. Fabric must be saturated/impregnated manually when the wet lay-up process is used.</li> <li>At low temperatures and/or high relative humidity, a slight oily residue (blush) may form on the surface of the cured epoxy. If an additional layer of fabric, or a coating is to be applied onto the cured epoxy. This residue must first be removed to ensure adequate bond. The residue can be removed with either a solvent wipe (e.g. MEK) or with water and detergent. In both cases, the surface should be wiped dry prior to application of the next layer or coating.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>				

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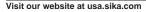
Fracc, Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

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### **Sikadur<sup>®</sup> 340** High-modulus, high-strength, primer for SikaWrap PreSaturated systems

Description	Sikadur 340 is a two-component 100% solids, moisture-tolerant, high strength, high modulus epoxy primer for use with SikaWrap PreSaturated systems		
Where to Use	<ul> <li>For use as a seal coat and primer with SikaWrap PreSatruated Structural Strengthening Systems for vertical, horizontal and overhead applications.</li> </ul>		
Advantages	<ul> <li>Long pot life.</li> <li>Long open time.</li> <li>Easy to mix.</li> <li>Moisture tolerant</li> <li>High strength, high modulus adhesive.</li> <li>Excellent adhesion to concrete, masonry metals, wood and most structural materials.</li> <li>Thixotropic version ideal for overhead applications.</li> <li>High temperature resistance.</li> <li>High abrasion and shock resistance.</li> <li>Solvent-free, VOC compliant.</li> </ul>		
Coverage	As a primer: 140 ft²/gal. (~10 mils)		
Packaging	1 gallon unit (1 pail of "A"; 2 cannisters of "B")		

#### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

	•			
		ACTUAL SITE	ING UPON MIXING METHODS AND EQUIPMENT, CONDITIONS AND CURING CONDITIONS. Container.	
Storage Conditions	Store dry at 40°-98 (18°-24°C) before	•	°C). Condition material to 65°-75°F	
Color	Clear, amber.			
Mixing Ratio	Mix entire unit, do	not batch.		
Viscosity	300 - 550 cps			
Gel Time	90 minutes			
Tack Free	3 hours			
Glass Transition Temp	. (Tg)	208°F (98	8°C)/140°F (60°C) post cure	
Service Temperature R	lange		-40° to 140°F (-40 to 83°C)	
Mechanical Properties (Min. 7 day cure @ 73°F (23°C) and 50% R.H.)				
Tensile Strength (ASTM D-638)5,580 psi (38.5 MPa)				
Tensile Modulus (ASTI	VI D-638)		2.7 x 10⁵ psi (1,862 MPa)	
Elongation @ Break (A	STM D-638)		1.5%	



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How to Use	
Surface Preparation	The concrete surface should be prepared to a minimum concrete surface profile (CSP) 3 as defined by the ICRI-surface-profile chips. Localized out-of-plane variations, including form lines, should not exceed 1/32 in. (1 mm). Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e. sandblasting). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.
Mixing	Pre-mix "A" component. Mix entire unit, do not batch. Pour contents of both cannisters of part 'B' to part 'A'. Mix thoroughly for 3 minutes using a jiffy style mixer on low speed (400-600 rpm) drill until uniformly blended.
Application	Apply mixed Sikadur 340 epoxy to a properly prepared substrate using a brush, roller or airless sprayer. Sikadur 340 should be applied at a rate of approximately 10 mils. Coverage rates are based on a substrate with normal porosity.
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not thin with solvents.</li> <li>Material is a vapor barrier after cure.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> <li>DO NOT LEAVE MIXED EPOXY IN MASS; MATERIAL MAY GET HOT</li> <li>Moisture content of the substrate must be 4% or less when measured using Tramex.</li> </ul>
Clean Up	Ventilate area. Confine spill. Collect with absorbent material. Dispose of in accordance with current, applicable local, state and federal regulations. Uncured material can be removed with approved solvent. Cured material can only be removed mechanically.

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## **Sikadur® Hex 300** High-modulus, high-strength, impregnating resin

Description	Sikadur <sup>®</sup> Hex 300 is a two-component 100% solids, moisture-tolerant, high strength, hig modulus epoxies. Sikadur <sup>®</sup> Hex 300 is compliant with the 2012 and 2009 International Build ing Codes (IBC) and the 1997 Uniform Building Code (UBC) per ICC-ES Evalutation Repo ESR-3288.			
Where to Use			/rap <sup>®</sup> Structural Strengthening System pregnating resin for horizontal and vert	
Advantages	<ul> <li>Long pot life.</li> <li>Long open time.</li> <li>Easy to mix.</li> <li>Tolerant of moisture before, during and after cure.</li> <li>High strength, high modulus adhesive.</li> <li>Excellent adhesion to concrete, masonry metals, wood and most structural material</li> <li>Fully compatible and developed specifically for the SikaWrap<sup>®</sup> System.</li> <li>High temperature resistance.</li> <li>High abrasion and shock resistance.</li> <li>Solvent-free, VOC compliant.</li> </ul>			
Coverage	As a sealer: 100 ft²/gal. As an impregnating resin:	120 ft²/gal 9 oz. per s	sa vd. fabrics	
	As an impregnating resin.	60 ft²/gal 18 oz. per		
		30 ft²/gal 37 oz. per s		
Packaging	4 gallon units.	50 ft /gai 57 62. per s	54.yu. labiles	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions	on statistical variations dep ethods, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-		
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed)	on statistical variations depiritors, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. Ened container -35°C). Condition material to 65°-75°F tch down	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity	on statistical variations depiritors, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reaction)	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. Ened container -35°C). Condition material to 65°-75°F tch down	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed)	on statistical variations depiritors, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reac ~12 - 14 hours	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. Ened container -35°C). Condition material to 65°-75°F tch down	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity Tack Free	on statistical variations depirthods, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reac ~12 - 14 hours e Range (cured)	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. ened container -35°C). Condition material to 65°-75°F tch down ch approx. 10,000 cps)	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity Tack Free In-Service Temperature Tensile Properties	on statistical variations depirthods, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°. (18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reac ~12 - 14 hours e Range (cured)	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. ened container -35°C). Condition material to 65°-75°F tch down ch approx. 10,000 cps) -40° to 140°F (-40° to 60°C) 7,500 psi (41.4 MPa) 3.2%	
	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity Tack Free In-Service Temperature Tensile Properties Tensile Strength (ASTM Elongation at Break (ASTM Elongation at Break (ASTM)	on statistical variations depirthods, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reac ~12 - 14 hours <b>e Range (cured)</b>	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. ened container -35°C). Condition material to 65°-75°F tch down ch approx. 10,000 cps) -40° to 140°F (-40° to 60°C) 7,500 psi (41.4 MPa) 3.2% 2.8 x 10 <sup>5</sup> psi	
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	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity Tack Free In-Service Temperature Tensile Properties Tensile Strength (ASTM Elongation at Break (ASTM Elongation at Break (ASTM Elongation at Break (ASTM) Flexural Strength (Modu Tangent Modulus of Elast	on statistical variations depiritors, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to reac ~12 - 14 hours <b>e Range (cured)</b> M D-638) STM D-638) lus of Rupture)(ASTM D-790 (actual descent desce	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. ened container -35°C). Condition material to 65°-75°F tch down ch approx. 10,000 cps) -40° to 140°F (-40° to 60°C) 7,500 psi (41.4 MPa) 3.2% 2.8 x 10 <sup>5</sup> psi	
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	RESULTS MAY DIFFER BASED UP TEMPERATURE, APPLICATION ME Shelf Life Storage Conditions Color Mixing Ratio Viscosity Pot Life (1 quart volume mixed) Reactivity Tack Free In-Service Temperature Tensile Properties Tensile Strength (ASTM Elongation at Break (ASTM) Strength (Modu	on statistical variations depirthods, test methods, actual 2 years in original, unope Store dry at 40°-95°F (4°-(18°-24°C) before using Clear, slightly amber Mix entire unit, do not bat ~500 - 750 cps ~3 - 4 hours ~6 - 7 hours (time to read ~12 - 14 hours <b>e Range (cured)</b> M D-638) STM D-638) lus of Rupture)(ASTM D-790 icity in Bending (ASTM D-790 ature (ASTM D 648) g = 264 psi (1.8 MPa)	ENDING UPON MIXING METHODS AND EQUIPMENT, SITE CONDITIONS AND CURING CONDITIONS. ened container -35°C). Condition material to 65°-75°F tch down ch approx. 10,000 cps) -40° to 140°F (-40° to 60°C) 7,500 psi (41.4 MPa) 3.2% 2.8 x 10 <sup>5</sup> psi 0) 11,500 psi (79.3 MPa)	
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Sika®

	Comprossive	reportion (ACTM D	COE)		
	Compressive S	Properties (ASTM D Strength	695)		
	3 days 7 days 28 days	<b>40°F* (4°C)</b> - 1,000 psi (7.1 MPa) -	<b>60°F * (15.5°C)</b> - 8,500 psi (58.6 MPa) -	<b>73°F* (23°C)</b> 8,300 psi (57.2 MPa) 12,000 psi (82.7 MPa) 11,300 psi (77.9 MPa)	<b>90°F* (32°C)</b> - 12,000 psi (82.7 MPa) -
	Compressive Mo 7 days * Material cured and tes	dulus 3.8 x 10 <sup>5</sup> psi (2,621 MPa) ted at the temperatures indica			
	Typical Data	(Material post cur	ed min. 48 hours @	₪ 140°F (60°C) an	d 50% R.H.)
		th (ASTM D-638)		0,200 psi (70.3 MF	Pa)
	Elongation at E Modulus of Ela	Break (ASTM D-638 Isticity	•	.8% .4 x 10⁵ psi (2,345	MPa)
	Flexural Streng	oth (Modulus of Rupture s of Elasticity in Bend	) <b>(ASTM D-790)</b> 1	7,800 psi (123 MP	a)
How to Use Surface Prepara	defined by the lines, should not moisture. Remov particles, coating	Irface should be pre ICRI-surface-profile exceed 1/32 in. (1 n vedust, laitance, grea gs and disintegrated strate should be dry.	chips. Localized ou nm). Substrate mus use, oils, curing comp materials by mecha	ut-of-plane variatic t be clean, sound, oounds, waxes, imp anical means ( i.e.	ns, including form and free of surface regnations, foreign sandblasting). For
Mixing		omponent. Mix entire or 5 minutes using a ed.			
Application	brush, roller or a	pply mixed Sikadur® airless sprayer. Sikac ostrate without produ al porosity.	lur® Hex 300 should	be applied at a su	ifficient rate to fully
	For vertical and rated fabric to p	ating resin: For ver overhead application revent it from sliding ans. For further inforr	ns use Sikadur <sup>®</sup> 330 off. Resins may be	) US as tack coat/ applied to fabric b	primer for the satu-
Limitations	<ul> <li>Do not thin v</li> <li>Material is a</li> <li>Minimum age conditions.</li> </ul>	bstrate and ambient vith solvents. vapor barrier after c e of concrete must b netic product. Color r	ure. e 21-28 days deper	nding on curing an	
	<ul> <li>Mechanically</li> </ul>	/ prepared, top side, 300. Vertical or over US.			
ŝ	PRIOR TO EACH USE OF AN NSTRUCTIONS ON THE PR SHEET WHICH ARE AVAILAE PARTMENT AT 800.933.7452 IO READ AND FOLLOW THE RENT PRODUCT DATA SHEE	ODUCT'S MOST CURRE BLE ONLINE AT HTTP://U NOTHING CONTAINED IN WARNINGS AND INSTR	NT PRODUCT DATA SH JSA.SIKA.COM/ OR BY ANY SIKA MATERIALS UCTIONS FOR EACH S	IEET, PRODUCT LABE CALLING SIKA'S TEC RELIEVES THE USEF IKA PRODUCT AS SE	EL AND SAFETY DATA HNICAL SERVICE DE- R OF THE OBLIGATION T FORTH IN THE CUR-
Fo	EP CONTAINER TIGHTLY CLOSED. KEEF or further information and advice tual Safety Data Sheets containin fore using the product. In case o	regarding transportation, h g physical, ecological, toxic	andling, storage and dispo ological and other safety rel	sal of chemical products, ated data. Read the currer	users should refer to the
Da m fo	ior to each use of any Sika produc ata Sheet, product label and Safet ent at 800-933-7452. Nothing cont r each Sika product as set forth i oduct use.	y Data Sheet which are avail ained in any Sika materials re	able online at http://usa.sika elieves the user of the obliga	a.com/ or by calling Sika's ation to read and follow the	<b>Technical Service Depart-</b>
th B E S S T T	KA warrants this product for one e current Product Data Sheet if us yer's sole remedy shall be limitec (RRESS OR IMPLIED SHALL APP HALL NOT BE LIABLE UNDER AN' HE USE OF THIS PRODUCT IN A MA ALE OF SIKA PRODUCTS ARE ALLING 201-933-8800.	ed as directed within shelf lif to the purchase price or rep LY INCLUDING ANY WARRA Y LEGAL THEORY FOR SPEC ANNER TO INFRINGE ON ANY	e. User determines suitabili acement of product exclusiv NTY OF MERCHANTABILIT JAL OR CONSEQUENTIAL D PATENT OR ANY OTHER INT	ty of product for intended ve of labor or cost of labor. VOR FITNESS FOR A PAR MAGES. SIKA SHALL NO ELLECTUAL PROPERTY I	use and assumes all risks. NO OTHER WARRANTIES TICULAR PURPOSE. SIKA DT BE RESPONSIBLE FOR RIGHTS HELD BY OTHERS.
	sit our website at usa.sika.con egional Information and Sales	Centers. For the location of			
Ka	Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225	Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792	Sika Mexicana S.A. Carretera Libre Cela Fracc. Industrial Balv Corregidora, Quereta C.P. 76920 Phone: 52 442 23855	ya Km. 8.5 yanera aro <u>RESPONSIBLE CARE</u> end constraints to instrumentary	BG BOT RC 14001

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	ES	$\checkmark$	ICC	ESR-3288
		$\checkmark$	IBC	2012 Compliance

## SikaWrap<sup>®</sup> Hex 103C Carbon fiber fabric for structural strengthening

Description	SikaWrap <sup>®</sup> Hex 103C is a high strength, unidirectional carbon fiber fabric. Material is field laminated using Sikadur <sup>®</sup> 300/Hex 300 epoxy to form a carbon fiber reinforced polyme (CFRP) used to strengthen structural concrete elements.
Where to Use	<ul> <li>Load Increases</li> <li>Increased live loads</li> <li>Increased traffic volumes on bridges</li> <li>Installation of heavy machinery in industrial buildings</li> <li>Vibrating structures</li> <li>Changes of building utilization</li> <li>Seismic Strengthening</li> <li>Column wrapping</li> <li>Masonry walls</li> <li>Damage to Structural Parts</li> <li>Aging of construction materials</li> <li>Vehicle impact</li> <li>Fire</li> </ul>
	<ul> <li>Blast resistance</li> <li>Change in Structural System</li> <li>Removal of walls or columns</li> <li>Removal of slab sections for openings</li> </ul>
	<ul> <li>Design or Construction Defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> </ul>
Advantages	<ul> <li>Approved by ICC ESR-3288</li> <li>Compliance with 2012 IBC</li> <li>Compliance with 2010 California Building Code</li> <li>Component of UL listed, fire-rated assembly</li> <li>Used for shear, confinement or flexural strengthening</li> <li>Flexible, can be wrapped around complex geometries</li> <li>High Strength</li> <li>Light Weight</li> <li>Non-corrosive</li> <li>Alkali Resistant</li> <li>Low aesthetic impact</li> </ul>
Packaging	Rolls: 25 in. x 50 ft.; 25 in. x 300 ft.

#### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Storage Conditions	Store dry at 40° - 95°F (4° - 35°C)
Shelf Life	10 years
Color	Black
Primary Fiber Direction	0° (unidirectional)
Areal Weight	18 oz./sq.yd. (618 g/m^2)



TYPICAL FIBER PROPERTIES				
Property	Typical Test Value			
Tensile Strength	5.5 x 10^5 psi (3,793 MPa)			
Tensile Modulus	34 x 10^6 (234,500 MPa)			
Elongation	1.5%			
Density	0.065 lbs./in^3 (1.8 g/cc)			
Nominal Fiber Thickness	0.0135 in. (0.34 mm)			

	Ava Illtim				
	Avg. Ultimate Value		Design	value	
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	180,000	1,241	(f* <sub>fu</sub> ) 153,000*	1,055*	D3039/D7565
Tensile Modulus	-	-	(E <sub>f</sub> ) 9,400,000	64,828	D3039/D7565
Tensile % Elongation	1.6	1.6	(ε* <sub>fu</sub> ) 1.0*	1.0*	D3039/D7565
140°F - Tensile Strength	123,000	848	90,600*	625*	D3039
140°F - Tensile Modulus	-	-	9,156,500*	63,148*	D3039
140°F - % Elongation	1.13	1.13	0.89*	0.89*	D3039
Compressive Strength	113,000	779	99,200*	684*	D695
Compressive Modulus	9,726,000	67,076	8,532,800*	58,847*	D695
90 deg Tensile Strength	3,500	24	1,700*	12*	D3039
90 deg Tensile Modulus	705,500	4,866	512,300*	3,533*	D3039
90 deg % Tensile Elongation	0.45	0.45	0.27*	0.27*	D3039
Shear Strength +/- 45 in plane	7,500	52	6,300*	43*	D3518
Shear Modulus +/- 45 in plane	362,500	2,500	340,000*	2,345*	D3518
Nominal Ply Thickness (in./mm)	0.04	1.016	0.04	1.016	-
Tensile Strength per in. width	7.2 kips/in. width	-	6.1 kips/in. width*	-	-
Stiffness (E <sub>f</sub> *A) per in. width	-	-	376 kips/in. width	-	-

#### How to Use

<ul> <li>Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface.</li> <li>Consult the current product data sheets for Sikadur 330, Sikadur 300/Hex 300 or Sikadur 301 for additional information on surface preparation.</li> <li>Existing uneven surfaces must be filled with an a ppropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ASTM D-4541) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.</li> <li>Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface.</li> <li>Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient.</li> </ul>
Consult Sikadur 300/Hex 300, Sikadur 301 or Sikadur 330 product data sheets for information.



ApplicationPrior to placing the fabric, the concrete surface is primed and sealed usin Sikadur® 330 US and/or Sikadur 300/Hex 300 epoxy. For overhead or verti prime concrete with Sikadur 330 US to improve tack. SikaWrap Hex impregnated using either the Sikadur 301 or Sikadur 300/Hex 300. On the impregnation process for Sikadur® 300/Hex 300 may be accommechanically driven fabric saturator similar device. The fabric may al saturated by hand for Sikadur 300/Hex 300 using a roller prior to place case, installation of this system should be performed only by a specially tra-			
<b>Tooling &amp; Finishing</b> Fabric can be cut to appropriate lengths by using a commercial quality he Since the dull or worn cutting implements can damage, weaken or fray the should be avoided.			
Limitations	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> <li>System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/ thaw.</li> <li>On projects governed by ICC regulations, use products listed on ESR-3288</li> <li>Do not place carbon fiber in direct contact with steel. Must be isolated (e.g. glass fabric) to protect against corrosion.</li> </ul>		

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Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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# SikaWrap<sup>®</sup> Hex 103C HM

High modulus carbon fiber fabric for structural strengthening

Description		high modulus, unidirectional carbon fiber fabric. Material is <sup>®</sup> 300/Hex 300 epoxy to form a carbon fiber reinforced then structural elements.				
Where to Use	Load Increases Increasing the live loads in w Increasing traffic volumes on Installation of heavy machine Vibrating structures Changes of building utilizatio Seismic Strengthening Column wrapping Masonry walls Damage to Structural Parts Aging of construction materia Vehicle impact Fire Blast Resistance Change in Structural System Removal of walls or columns Removal of slab sections for Design or Construction Defe Insufficient reinforcement	arehouses bridges ry in industrial buildings n Is				
	<ul> <li>Insufficient reinforcement</li> <li>Insufficient structural depths</li> </ul>					
Advantages	<ul> <li>Used for shear, confinement</li> <li>Flexible, can be wrapped aro</li> <li>High Strength</li> <li>Light Weight</li> <li>Non-corrosive</li> <li>Alkali Resistant</li> <li>Low Aesthetic Impact</li> </ul>					
Packaging	Rolls: 20" x 150' Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign					
How to Use Surface Preparation						
	Typical Data (Metarial and	curing conditions @ 73°F and 50% R.H.)				
	RESULTS MAY DIFFER BASED UPON ST	TATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIP- METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDI-				
	RESULTS MAY DIFFER BASED UPON ST MENT, TEMPERATURE, APPLICATION	TATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIP-				
	RESULTS MAY DIFFER BASED UPON ST MENT, TEMPERATURE, APPLICATION TIONS.	TATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIP- METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDI-				
	RESULTS MAY DIFFER BASED UPON ST MENT, TEMPERATURE, APPLICATION TIONS. Storage Conditions	TATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIP- METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDI- Store dry at 40°-95°F (4°-35°C)				
	RESULTS MAY DIFFER BASED UPON ST MENT, TEMPERATURE, APPLICATION TIONS. Storage Conditions Shelf Life	ratistical variations depending upon mixing methods and equip- methods, test methods, actual site conditions and curing condi- Store dry at 40°-95°F (4°-35°C) 10 years				

**Jika**®

TYPICAL FIBER PROPERTIES			
Property	Typical Test Value		
Tensile Strength	8.3 x 10^5 psi (5.723 MPa)		
Tensile Modulus	43 x 10^6 psi (296,475 MPa)		
Elongation	1.9%		
Density	0.065 lbs./in^3 (1.8 g/cc)		
Normal Fiber Thickness	0.0135 in (0.34 mm)		

Cured Laminate P					
	Avg. Ultimate Value		Design Value		
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	161,450	1,134	(f*fu) 138,200*	953	D3039/D7565
Tensile Modulus	-	-	(Ef) 12,400,000	85,517	D3039/D7565
Tensile % Elongation	1.2	1.2	(e*fu) 0.90*	0.90*	D3039/D7565
Nominal Ply Thickness (in./mm)	0.04	1.016	0.04	1.016	-
Tensile Strength per in. width	6.5 kips/in. width	-	5.5 kips/in. width	-	-
Stiffness (E <sub>f</sub> *A) per in. width	-	-	496 kips/in. width	-	-

particles, disintegrated materials, and other bond inhibiting materials from the surface. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi with concrete substrate failure.

**Concrete** - Blast clean, shotblast or use other approved mechanical means to provide an open, roughened texture. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand or water blasting is sufficient.

 Mixing
 Consult Sikadur® 300/Hex 300/330 data sheet for information on epoxy resin.

 Application
 Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur® 300/Hex 300. Material may be applied by spray, brush or roller. SikaWrap® Hex 103C HM can be impregnated using Sikadur® 300/Hex 300 epoxy. For best results on larger projects, the impregnation process should be accomplished using a mechanically driven saturator or similar device. In special cases where the size of the project does not justify the use of a saturator, the fabric may saturate by hand using a ruller prior to placement. In either case, installation of this system should be performed only by a specially trained and ap-proved contractor.

 For overhead and vertical applications, prime concrete with Sikadur® 300 or Sikadur® 330 to improve tack. Saturate fabric with Sikadur® 300/Hex 300. Coat the exposed surface of final fabric layer using Sikagard® 670W or Sikagard® 62.

 Tooling & Finishing
 Fabric can be cut to appropriate length by using a commercial quality, heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber their use should be avoided.

 Limitations
 DESIGN CALCULATIONS MUST BE MADE AND CERTIFIED BY AN INDEPEN 

#### DESIGN CALCULATIONS MUST BE MADE AND CERTIFIED BY AN INDEPEN-DENT LICENSED PROFESSIONAL ENGINEER.

SYSTEM IS A VAPOR BARRIER. CONCRETE SHOULD NOT BE FULLY ENCAP-SULATED IN AREAS OF FREEZE/THAW.



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Product Data Sheet Edition 5.18.2016 SikaWrap® Hex 103C 2X

### SikaWrap<sup>®</sup> Hex 103C-2X

High Strength, double thickness Carbon Fiber fabric for Structural Strengthening

	strengthen structural conc	rete elements.				
Where to Use	Load Increases					
	Increased live loads	o on bridges				
	<ul> <li>Increased traffic volume</li> <li>Installation of heavy ma</li> </ul>		uildings			
	<ul> <li>Vibrating structures</li> </ul>		ununigs			
	Changes of building utili	zation				
	Seismic Strengthening					
	Column wrapping					
	<ul> <li>Masonry walls</li> <li>Damage to Structural Parage</li> </ul>	arte				
	<ul> <li>Aging of construction mage</li> </ul>					
	Vehicle impact					
	■ Fire					
	Blast resistance					
	<ul> <li>Change in Structural Sy</li> <li>Removal of walls or column</li> </ul>					
	<ul> <li>Removal of slab section</li> </ul>					
	Design or Construction	Defects				
	Insufficient reinforcement					
	Insufficient structural de	•				
Advantages	Used for shear, confiner					
	<ul> <li>Flexible, can be wrappe</li> <li>High Strength</li> </ul>	a arouna complex geo	ometries			
	<ul> <li>High Tensile Modulus</li> </ul>					
	■ Non-corrosive					
	Alkali Resistant					
	Low aesthetic impact					
Packaging	Rolls: 25 in. x 150 ft					
	Typical Data (Mat	SED UPON STATISTICAL VA	ARIATIONS I	DEPENDING UPON	MIXING ME	THODS AND EQUIPMEN
	TEMPERATURE, APPLICAT Shelf Life:	10 years	HODS, ACT	UAL SITE CONDITION	JNS AND C	URING CONDITIONS.
	Storage Condition:	Store dry at 4	10°-95°F (	(4°-35°C).		
	Color:	Black		( )		
	Primary Fiber Direct					
	Area Weight: Cured Laminate Prop	37.22 oz./sq.			,	
	Cured Laminate i Topo		JISIKauui			
		Avg. Ultimate Value		Design Value		
	Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	Tanaila Strangth	psi	MPa	Design	MPa	D2020/D7565
	Tensile Strength	178,654	1,231	(f*fu) 124,832	860	D3039/D7565
	Tensile Modulus	-	-	(Ef) 11,200,000	77,221	D3039/D7565
		1.62	1.62	(e*fu) 1.0	1.0	D3039/D7565
	Tensile % Elongation			0.07	1.78	
	Nominal Ply Thickness (in./m	<b>m)</b> 0.07	1.78	0.07	1.70	-
		<b>m)</b> 0.07	-	8.9 kips/in. width	-	-
	Nominal Ply Thickness (in./m	<b>m)</b> 0.07	+		-	-
R	Nominal Ply Thickness (in./m	Implement         0.07           Implement         12.2 kips/in. width	-	8.9 kips/in. width	-	1

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

How to Use Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult the current product data sheets for Sikadur 330 US Sikadur 300/Hex 300 or Sikadur 301 for additional information on surface preparation. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ASTM D-4541) at the discretion of the engineer. Minimum tensilt strength, 200 psi (1.4 MPa) with concrete substrate failure. Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface. Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient.
Mixing	Consult the current product data sheets for Sikadur 300, Sikadur 330 US and/or Sikadur Hex 300 for information on epoxy resins.
Application	Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur 330 US and /or Sikadur 300/Hex 300 epoxy. For overhead or vertical applications, prime concrete with Sikadur 330 US to improve tack. SikaWrap Hex 103C 2X can be impregnated using either the Sikadur 300/Hex 300. Sika highly recommends using a mechanically driven fabric saturator in conjunction with Sikadur 300/Hex 300 for heavy weight fabrics. The fabric may also be manually saturated by hand for Sikadur 300/Hex 300 using a roller prior to placement though particular care must be taken to ensure complete saturation. In either case, installation of this system should be performed only by a specially trained contractor. NOTE: On Caltrans DOT projects, only mechanically driven saturation may be used.
Tooling and Finishing	Cutting of SikaWrap: Fabric can be cut to appropriate lengths by using a commercial quality heavy duty scissor. Since the dull or worn cutting implements can damage, weaken or fray the fabric, their use should be avoided.
Limitations	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> <li>System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/thaw.</li> <li>Do not place carbon fiber in direct contact with steel. Must be isolated (e.g. glass fabric) to protect against corrosion.</li> </ul>

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Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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Product Data Sheet Edition 5.17.2016 SikaWrap Hex 113C

## SikaWrap<sup>®</sup> Hex 113C Bi-directional Carbon fiber fabric for structural strengthening

Description		ional carbon fiber fabric. Material is field laminated using Sika- Sikadur Hex 330 epoxy to form a carbon fiber reinforced en structural elements.					
Where to Use	Load increases						
	<ul> <li>Increased live loads in wareh</li> </ul>						
	<ul> <li>Increased traffic volumes on</li> </ul>	•					
	<ul> <li>Installation of heavy machine</li> </ul>	ery in industrial buildings					
	<ul> <li>Vibrating structures</li> </ul>						
	<ul> <li>Changes of building utilization</li> </ul>	n.					
	Seismic strengthening						
	<ul><li>Column wrapping</li><li>Masonry walls</li></ul>						
	Damage to structural parts						
	<ul> <li>Aging of construction materia</li> </ul>	als					
	<ul> <li>Vehicle impact</li> </ul>						
	■ Fire						
	Change in structural system						
	<ul> <li>Removal of walls or columns</li> </ul>						
	<ul> <li>Removal of slab sections for</li> </ul>						
	Design or construction defect	ts					
	Insufficient reinforcements						
	<ul> <li>Insufficient structural depth</li> </ul>						
Advantages	<ul> <li>Lightweight fabric ideal for co</li> </ul>						
	<ul> <li>Can be applied in dry or wet lay-up process</li> </ul>						
	<ul> <li>Used for shear, confinement or flexural strengthening</li> <li>Elevible, can be wrapped around complex shapes</li> </ul>						
	<ul><li>Flexible, can be wrapped around complex shapes</li><li>High strength</li></ul>						
	<ul> <li>Non-corrosive</li> </ul>						
	<ul> <li>Alkali resistant</li> </ul>						
	<ul> <li>Low aesthetic impact</li> </ul>						
	Typical Data						
		N STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMEN HODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.					
	Storage Conditions	Store dry at 40°F-95°F					
	Color	Black					
	Primary Fiber Direction	0°/90° (bi-directional)					
	Weight per Square Yard	5.7 oz. (196 g/m²)					
	Weight Ratio (Warp:Weft)	1:1					
	Cured Laminate Propertie						
	Tensile Strength	66,000 psi (456 MPa)					
	Tensile Modulus	6.0 x 10 <sup>6</sup> psi (41,400 MPa)					
		1.2%					
	Elongation at Break						
	Thickness	0.010 in. (0.25 mm)					
	Strength per Inch Width	660 lbs./layer (2.92 kN)					
	Fiber Properties						
	Tensile Strength	5 x 10⁵ psi (3,450 MPa)					
	Tensile Modulus	33.4 x 10 <sup>6</sup> psi (230,000 MPa)					
A	Elongation	1.5%					
	Density	0.065 lbs./in. <sup>3</sup> (1.8 g/cc)					

Packaging	Rolls: 50 in. x 300 ft.
How to Use	
Surface Preparation	<ul> <li>Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult Sikadur Hex 300 and Sikadur 330 technical data sheets for additional information on surface preparation.</li> <li>Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.</li> <li>Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture.</li> </ul>
	In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand or water blasting is sufficient.
Mixing	Consult Sikadur 300/Hex 300, Sikadur 301 or Sikadur 330 product data sheets for information.
Application	SikaWrap Hex 113C can be applied using wet or dry lay-up methods.
	<b>Dry Lay-Up:</b> Apply the mixed Sikadur 330 or Sikadur 301 epoxy resin directly onto the substrate at a rate of 40-50 ft <sup>2</sup> /gal. (32-40 mils), depending on the surface profile. Carefully place the fabric into the resin with gloved hands and smooth out any irregularities or air pockets using a plastic laminating roller. Allow the resin to squeeze out between the rovings of the fabric. If more than one layer of fabric is required, apply additional Sikadur 330 or Sikadur 301 at a rate of 100ft <sup>2</sup> /gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 330 or Sikadur 301 to the exposed surface at a rate of 160ft <sup>2</sup> /gal. (10 mils).
	<b>Wet Lay-Up:</b> Seal the prepared concrete surface using Sikadur 300/Hex 300 or Sikadur 301. Material may be applied by spray, brush or roller. SikaWrap Hex 113C can be impregnated using the Sikadur 300/Hex 300 or Sikadur 301 epoxy. For best results, the impregnation process should be accomplished using an automated fabric saturator. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregulari-ties or air pockets using a plastic laminating roller. If required, apply additional layers of fabric while epoxy on previous layer is still tacky. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62. Installation of SikaWrap Products should be performed only by specially trained approved contrac- tors.
Cutting SikaWrap	Fabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided. Consult MSDS for proper handling procedures.
Limitations	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> <li>System is a vapor barrier. Concrete should not be encapsulated in areas of freeze/thaw.</li> </ul>

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Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

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## SikaWrap<sup>®</sup> Hex 115C Bi-directional carbon fiber fabric for structural strengthening

ated using Sikadur Hex 300 er (CFRP) used to strengthe increases reased live loads in warehou reased traffic volumes on br tallation of heavy machinery rating structures anges of building utilization <b>nic strengthening</b> lumn wrapping sonry walls <b>tige to structural parts</b> ing of construction materials nicle impact es ist resistance <b>ge in structural system</b> moval of slab sections for op <b>n or construction defects</b> utificient reinforcements utificient structural depth ed for shear, confinement or xible, can be wrapped around th strength. ht weight. n-corrosive. ali resistant. w aesthetic impact.	uses idges r in industrial buildings benings
reased live loads in warehour reased traffic volumes on but tallation of heavy machinery rating structures anges of building utilization <b>nic strengthening</b> lumn wrapping sonry walls <b>ng of construction materials</b> nicle impact est resistance <b>ge in structural system</b> moval of slab sections for op <b>n or construction defects</b> ufficient reinforcements ufficient structural depth ed for shear, confinement or xible, can be wrapped around h strength. ht weight. n-corrosive. ali resistant. w aesthetic impact.	idges r in industrial buildings benings
xible, can be wrapped arou h strength. ht weight. n-corrosive. ali resistant. v aesthetic impact.	
: 50 in. x 300 ft.	
ve dust, laitance, grease, cu I materials and other bond in	. It may be dry or damp, but free of standing water and frost. uring compounds, impregnations, waxes, foreign particles, disinte- nhibiting materials from the surface. Consult Sikadur 300, d Sikadur 330 technical data sheets for additional information on
	N STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, HODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
Storage Conditions Color Primary Fiber Direction Weight Per Square Yard	Store dry at 40°-95°F (4°-35°C) Black 0°/90° (bi-directional) 19.8 oz. (675 g/m²)
Fiber Properties Tensile Strength Tensile Modulus Elongation Density	5.5 x 10 <sup>5</sup> psi (3,793 MPa) 33 x 10 <sup>6</sup> psi (234,500 MPa) 4% 0.065 lbs./in. <sup>3</sup> (1.8 g/cc)
	ur 301, Sikadur Hex 300 and the preparation. Typical Data RESULTS MAY DIFFER BASED UPOI TEMPERATURE, APPLICATION METH Storage Conditions Color Primary Fiber Direction Weight Per Square Yard Fiber Properties Tensile Strength Tensile Modulus Elongation

TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

#### Cured Laminate Properties with Sikadur Hex 300 Epoxy Properties after standard cure followed by standard post cure. [70°-75°F (21°-24°C) - 5 days and 48 hour post cure at 140°F (60°C)]

	Average Value <sup>1</sup> Design			Value <sup>2</sup>	ASTM Test
Property	US Units	SI Units	US Units	SI Units	Method
	Psi	MPa	psi	MPa	
Tensile Strength*	83,980	579	70,870	489	D638
Tensile Modulus*	7,017,555	48,351	6,149,730	42,468	D638
Tensile % Elongation *	1.14	1.14	0.98	0.98	D638
140F - Tensile Strength	74,195	511	64,790	447	D638
140F - Tensile Modulus	6,340,680	43,688	6,203,025	43,739	D638
140F - % Elongation	1.12	1.12	0.96	0.96	D638
Compressive Strength	54,245	373	38,570	267	D695
Compressive Modulus	6,707,855	46,218	6,496,100	44,759	D695
90 deg Tensile Strength	83,980	579	70,870	489	D638
90 deg Tensile Modulus	7,017,555	48,351	6,930,773	47,753	D638
90 deg %Tensile Elongation	1.14	1.14	0.98	0.98	D638
Shear Strength-+/-45 In Plane	14,630	101	12,920	89	D3518
Shear Modulus +/-45 In Plane	0	0	0	0	D3518
Ply Thickness (inch/mm)	0.04	1			
Tensile Strength per inch width in each direction	2583	17.8	1854	12.7	D3039

#### Cured Laminate Properties with Sikadur Hex 306 Epoxy Properties after standard cure followed by standard post cure. [70°-75°F(21°-24°C) - 5 days and 48 hour post cure at 140°F(60°C)]

	Average	Value <sup>1</sup>	Design	Value <sup>2</sup>	ASTM Test
Property	US Units	SI Units	US Units	SI Units	Method
	Psi	MPa	Psi	MPa	
Tensile Strength*	82,080	565	69,825	481	D638
Tensile Modulus*	6,320,350	43,547	5,198,875	35,821	D638
Tensile % Elongation *	1.19	1.19	0.94	0.94	D638
140F - Tensile Strength	54,435	375	45,315	312	D638
140F - Tensile Modulus	4,704,875	32,417	3,779,765	26,044	D638
140F - % Elongation	1.13	1.13	0.76	0.76	D638
Compressive Strength	46,835	323	36,005	248	D695
Compressive Modulus	5,505,155	37,931	4,693,190	32,336	D695
90 deg Tensile Strength	82,080	565	69,825	481	D638
90 deg Tensile Modulus	6,320,350	43,547	5,198,875	35,821	D638
90 deg %Tensile Elongation	1.19	1.19	0.94	0.94	D638
Shear Strength-+/-45 In Plane	12,160	84	11,020	77	D3518
Shear Modulus +/-45 In Plane	416,480	2,870	380,570	2,623	D3518
Ply Thickness (inch/mm)	0.04	1			
Tensile Strength per inch width	3283	14.6	2793	12.4	D3039

24 sample coupons per test series; all other values based on 6 coupon test series

Average value of test series - based on year 2000 testing program

<sup>2</sup> Average value minus 3 standard deviations calculated from the year 2000 testing program

Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure

Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture.

In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand or water blasting is sufficient.

Mixing Consult Sikadur 300/Hex 300 or Sikadur 301 data sheets for information on epoxy resins.

Application Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur Hex 300 epoxy. Material may be applied by spray, brush or roller. SikaWrap Hex 115C can be impregnated using Sikadur 300/Hex 300 or Sikadur 301 epoxy. For best results on larger projects, the impregnation process should be accomplished using a mechanically driven fabric saturator or similar device. In special cases where the size of the project does not justify the use of a saturator, the fabric may saturate by hand using a roller prior to placement. In either case, installation of this system should be performed only by a specially trained, approved contractor. For overhead or vertical applications, prime concrete with Sikadur 30 or Sikadur 330 to improve tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. Cutting SikaWrap Fabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber their use should be avoided. Consult MSDS for proper handling procedures. Limitations

Design calculations must be made and certified by an independent licensed professional engineer. System is a vapor barrier. Concrete should not be encapsulated in areas of freeze/thaw.

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Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

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Product Data Sheet Edition 5.17.2016 SikaWrap Hex 117C

## SikaWrap<sup>®</sup> Hex 117C Carbon fiber fabric for structural strengthening

Where to Use Advantages	Load increases Increased live loads in wareho Increased traffic volumes on b Installation of heavy machiner Vibrating structures Changes of building utilization Seismic strengthening Column wrapping Masonry walls Damage to structural parts Aging of construction materials Vehicle impact Fire Change in structural system Removal of slab sections for o Design or construction defects Insufficient reinforcements Insufficient structural depth Lightweight fabric ideal for cor Filexible, can be wrapped arou	ridges y in industrial buildings s penings s ifined spaces r flexural strengthening
Advantages	<ul> <li>Increased traffic volumes on b</li> <li>Installation of heavy machiner</li> <li>Vibrating structures</li> <li>Changes of building utilization</li> <li>Seismic strengthening</li> <li>Column wrapping</li> <li>Masonry walls</li> <li>Damage to structural parts</li> <li>Aging of construction materials</li> <li>Vehicle impact</li> <li>Fire</li> <li>Change in structural system</li> <li>Removal of slab sections for o</li> <li>Design or construction defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for cor</li> <li>Used for shear, confinement o</li> </ul>	ridges y in industrial buildings s penings s ifined spaces r flexural strengthening
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Advantages	Damage to structural parts         Aging of construction materials         Vehicle impact         Fire         Change in structural system         Removal of walls or columns         Removal of slab sections for o         Design or construction defects         Insufficient reinforcements         Insufficient structural depth         Lightweight fabric ideal for cor         Used for shear, confinement o         Flexible, can be wrapped arout	penings s ifined spaces r flexural strengthening
Advantages	<ul> <li>Aging of construction materials</li> <li>Vehicle impact</li> <li>Fire</li> <li>Change in structural system</li> <li>Removal of walls or columns</li> <li>Removal of slab sections for o</li> <li>Design or construction defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for cor</li> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arout</li> </ul>	penings s ifined spaces r flexural strengthening
Advantages	<ul> <li>Fire</li> <li>Change in structural system</li> <li>Removal of walls or columns</li> <li>Removal of slab sections for o</li> <li>Design or construction defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for corr</li> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arout</li> </ul>	ifined spaces r flexural strengthening
Advantages	Change in structural system Removal of walls or columns Removal of slab sections for o Design or construction defects Insufficient reinforcements Insufficient structural depth Lightweight fabric ideal for cor Used for shear, confinement o Flexible, can be wrapped arou	ifined spaces r flexural strengthening
Advantages	<ul> <li>Removal of walls or columns</li> <li>Removal of slab sections for or</li> <li>Design or construction defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for corr</li> <li>Used for shear, confinement or</li> <li>Flexible, can be wrapped arout</li> </ul>	ifined spaces r flexural strengthening
Advantages	<ul> <li>Removal of slab sections for on Design or construction defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for corre</li> <li>Used for shear, confinement of Flexible, can be wrapped arout</li> </ul>	ifined spaces r flexural strengthening
Advantages	Design or construction defects Insufficient reinforcements Insufficient structural depth Lightweight fabric ideal for cor Used for shear, confinement o Flexible, can be wrapped arou	ifined spaces r flexural strengthening
Advantages	<ul> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for cor</li> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arou</li> </ul>	fined spaces r flexural strengthening
Advantages	<ul> <li>Insufficient structural depth</li> <li>Lightweight fabric ideal for cor</li> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arou</li> </ul>	r flexural strengthening
Advantages	<ul> <li>Lightweight fabric ideal for cor</li> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arou</li> </ul>	r flexural strengthening
Auvantages	<ul> <li>Used for shear, confinement o</li> <li>Flexible, can be wrapped arou</li> </ul>	r flexural strengthening
	<ul> <li>Flexible, can be wrapped arou</li> </ul>	
	High strength	
	<ul> <li>Non-corrosive</li> </ul>	
	<ul> <li>Alkali resistant</li> </ul>	
	<ul> <li>Low aesthetic impact</li> </ul>	
Packaging	Rolls: 12 in. x 300 ft. 24 in. x 300	ft.
	Typical Data	
	TEMPERATURE, APPLICATION METHO	STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, DDS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Storage Conditions	Store dry at 40°-95°F (4°-35°C)
	Color	Black
	Primary Fiber Direction	0° (unidirectional)
	Weight per Square Yard	9.0 oz. (300 g/m²)
	Cured Laminate Properties	Design Values
	Tensile Strength	1.05 x 10⁵ psi (724 MPa)
	Modulus of Elasticity	8.2 x 10 <sup>6</sup> psi (56,500 MPa)
	Elongation at Break	1.0%
	Thickness	0.02 in. (0.51 mm)
		2,100 lbs./layer (9.3 kN)
	Strength per Inch Width	2,100 IDS./IAYEL (8.3 KIN)
	Fiber Properties	
	Tensile Strength	550,000 psi (3,793 MPa)
	Tensile Modulus	34 x 10 <sup>6</sup> psi (234,000 MPa)
	Elongation	1.5%
	Density	0.065 lbs/in <sup>3</sup> (1.8 g/cc)
		T, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN



How to Use         Surface Preparation       Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disinte- grated materials and other bond inhibiting materials from the surface preparation. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.         Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the sub- strate using low pressure sand or water blasting is sufficient.         Mixing       Consult Sikadur Hex 300 or Sikadur 330 technical data sheet for information on epoxy resin.         Application       SikaWrap Hex 117C can be applied using wet or dry lay-up methods.         Dry Lay-Up: Apply the mixed Sikadur 330 or Sikadur 301 at arate of 100ft.*/gal. (16 mils) and repeat as above. Apply a diditional Sikadur 330 or Sikadur 301 at a rate of 100ft.*/gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 300 at arate of 100ft.*/gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 300 at a rate of 100ft.*/gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 300 wilk acts. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. For best results, the impregnation process should be accomplished using an automated saturation device. Once saturated		
ApplicationSikaWrap Hex 117C can be applied using wet or dry lay-up methods. Dry Lay-Up: Apply the mixed Sikadur 330 or Sikadur 301 epoxy resin directly onto the substrate at a rate of 40-50 ft.²/gal. (32-40 mils), depending on the surface profile. Carefully place the fabric into the resin with gloved hands and smooth out any irregularities or air pockets using a plastic laminating roller. Allow the resin to squeeze out between the rovings of the fabric. If more than one layer of fabric is required apply additional Sikadur 330 or Sikadur 301 to the exposed surface at a rate of 160ft.²/gal. (10 mils).Wet Lay-Up: Seal the prepared concrete surface using Sikadur 300/Hex 300 or Sikadur 301. Material may be applied by spray, brush or roller. SikaWrap Hex 117C can be impregnated using Sikadur 300/Hex 300 epoxy or Sikadur 301. For best results, the impregnation process should be accomplished using an automated saturation device. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregulari-ties or air pockets using a plastic laminating roller. If required, apply additional layers of fabric whi Sikadur 330 to improve tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62. Installation of SikaWrap Products should be performed only by specially trained approved contrac- tors.Tooling & Finishing Labric Can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided. Consult MSDS for proper handling procedures.Limitations• Design calculations must be made and certified by an independent licensed professional engineer.		<ul> <li>Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disinte- grated materials and other bond inhibiting materials from the surface. Consult Sikadur Hex 300 and Sikadur 330 technical data sheets for additional information on surface preparation.</li> <li>Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.</li> <li>Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the sub-</li> </ul>
Dry Lay-Up:Apply the mixed Sikadur 330 or Sikadur 301 epoxy resin directly onto the substrate at a rate of 40-50 ft.²/gal. (32-40 mils), depending on the surface profile. Carefully place the fabric into the resin with gloved hands and smooth out any irregularities or air pockets using a plastic laminating roller. Allow the resin to squeeze out between the rovings of the fabric. If more than one layer of fabric is required apply additional Sikadur 330 or Sikadur 301 at a rate of 100ft.²/gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 330 or Sikadur 301 to the exposed surface at a rate of 160ft.²/gal. (10 mils).Wet Lay-Up:Seal the prepared concrete surface using Sikadur 300/Hex 300 or Sikadur 301. Material may be applied by spray, brush or roller. SikaWrap Hex 117C can be impregnated using Sikadur 300/Hex 300 epoxy or Sikadur 301. For best results, the impregnation process should be accomplished using an automated saturation device. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregulari-ties or air pockets using a plastic laminating roller. If required, apply additional layers of fabric while epoxy on previous layer is still tacky. For overhead or vertical applications, prime concrete with Sikadur 330 to improve tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62. Installation of SikaWrap Products should be performed only by specially trained approved contrac- tors.Tooling & FinishingFabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided. Consult MSDS for proper handling procedures.Limitations• Design calculations must be made and certified by an independent	Mixing	Consult Sikadur Hex 300 or Sikadur 330 technical data sheet for information on epoxy resin.
Material may be applied by spray, brush or roller. SikaWrap Hex 117C can be impregnated using Sikadur 300/Hex 300 epoxy or Sikadur 301. For best results, the impregnation process should be accomplished using an automated saturation device. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregulari-ties or air pockets using a plastic laminating roller. If required, apply additional layers of fabric while epoxy on previous layer is still tacky. For overhead or vertical applications, prime concrete with Sikadur 330 to improve tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62. Installation of SikaWrap Products should be performed only by specially trained approved contrac- tors.Tooling & FinishingFabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided. Consult MSDS for proper handling procedures.Limitations• Design calculations must be made and certified by an independent licensed professional engineer.	Application	<b>Dry Lay-Up:</b> Apply the mixed Sikadur 330 or Sikadur 301 epoxy resin directly onto the substrate at a rate of 40-50 ft. <sup>2</sup> /gal. (32-40 mils), depending on the surface profile. Carefully place the fabric into the resin with gloved hands and smooth out any irregularities or air pockets using a plastic laminating roller. Allow the resin to squeeze out between the rovings of the fabric. If more than one layer of fabric is required apply additional Sikadur 330 or Sikadur 301 at a rate of 100ft. <sup>2</sup> /gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 330 or Slkadur 301 to the exposed surface at a rate of 160ft. <sup>2</sup> /gal. (10 mils).
dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided. Consult MSDS for proper handling procedures.         Limitations <ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> </ul>		Material may be applied by spray, brush or roller. SikaWrap Hex 117C can be impregnated using Sikadur 300/Hex 300 epoxy or Sikadur 301. For best results, the impregnation process should be accomplished using an automated saturation device. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregulari-ties or air pockets using a plastic laminating roller. If required, apply additional layers of fabric while epoxy on previous layer is still tacky. For overhead or vertical applications, prime concrete with Sikadur 330 to improve tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62. Installation of SikaWrap Products should be performed only by specially trained approved contrac-
	Tooling & Finishing	dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided.
	Limitations	

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. No OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCT IS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL NOT BE LONG AND A MANNER TO INFRINGE ON ANY PATENT OR ANY CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL NOT BE OF THIS PRODUCT IN A MONER TO INFRINGE ON ANY PATENT OR ANY CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL NOT BE AND A MANNER TO INFRINGE ON ANY PATENT OR ANY CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Fax: 52 442 2250537

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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera **V** Corregidora, Queretaro RESPONSIBLE CARE ISO 9001 RC 14001 Phone: 52 442 2385800



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## SikaWrap<sup>®</sup> Hex 230C Carbon fiber fabric for structural strengthening

**Tensile Modulus** 

Elongation

Density

Description		directional carbon fiber fabric. Material is field laminated using Sikadur Sikadur 330 epoxy to form a carbon fiber reinforced polymer (CFRP) elements.				
Where to Use	<ul> <li>Load increases</li> <li>Increased live loads in warehouses.</li> <li>Increased traffic volumes on bridges.</li> <li>Installation of heavy machinery in industrial buildings.</li> <li>Vibrating structures.</li> <li>Changes of building utilization.</li> <li>Seismic strengthening</li> <li>Column wrapping.</li> <li>Masonry walls.</li> <li>Damage to structural parts</li> <li>Aging of construction materials.</li> <li>Vehicle impact.</li> <li>Fire.</li> <li>Change in structural system</li> <li>Removal of walls or columns.</li> <li>Removal of slab sections for openings.</li> <li>Design or construction defects</li> <li>Insufficient reinforcements.</li> <li>Insufficient structural depth.</li> </ul>					
Advantages	<ul> <li>Approved by ICBO/ICC EF</li> <li>Lightweight fabric ideal for</li> <li>Can be applied in dry or w</li> <li>Used for shear, confineme</li> <li>Flexible, can be wrapped a</li> <li>High strength.</li> <li>Non-corrosive.</li> <li>Alkali resistant.</li> <li>Low aesthetic impact.</li> </ul>	confined spaces. et lay-up process. nt or flexural strengthening.				
Packaging	Rolls: 12 in. x 150 ft. 24 in. x	150 ft.				
	TEMPERATURE, APPLICATION METH	STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, HODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.				
	Storage Conditions Color Primary Fiber Direction Weight per Square Yard	Store dry at 40°-95°F (4°-35°C) Black 0° (unidirectional) 6.7 oz. (230 g/m²)				
	Fiber PropertiesTensile Strength5 x 10 <sup>5</sup> psi (3,450 MPa)					



PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

33.4 x 106 psi (230,000 MPa)

0.065 lbs./in.3 (1.8 g/cc)

1.5%

0		afte	er standard	cure [70° -7:	5° F (21° -24°	c) - 5 daysj		
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of stand-		Average Value <sup>1</sup>		Design Value <sup>2</sup>		1	
	ing water and frost. Remove dust,	Property	US Units psi	SI Units MPa	US Units psi	SI Units MPa	ASTM Test Method	
	laitance, grease, curing compounds, impregnations, waxes, foreign particles,	Tensile Strength*	129,800	894	104,000	715	D-3039	
	disintegrated materials, and other bond	Tensile Modulus*	9,492,300	65,402	8,855,000	61,012	D-3039	
	inhibiting materials from the surface. Consult Sikadur Hex 300 and Sikadur	Tensile %	1.33	1.33	1.09	1.09	D-3039	
	330 technical data sheets for additional information on surface preparation.	Elongation* 140° F (60° C) Tensile Strength	118,200	814	102,000	703	D-3039	
	Existing uneven surfaces must be filled	140° F (60° C)	9,789,000	67,450	8,693,000	59,896	D-3039	
	with an appropriate repair mortar. The adhesive strength of the concrete must	Tensile Modulus 140° F (60° C)	1.16	1.16	1.00	1.00	D-3039	
	be verified after surface preparation by	% Elongation Compressive	113,000	779	97,000	668	D-695	
	random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum	Strength Compressive	9,724,700	67,003	9,230,000	63,597	D-695	
	tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.	Modulus 90 deg Tensile		27	390			
	Preparation Work: Concrete - Blast	Strength 90 deg Tensile	3,965			23	D-3039	
	clean, shotblast or use other approved mechanical means to provide an open	Modulus 90 deg %	852,800	5,876	799,000	5,502	D-3039	
	roughened texture.	Tensile Elongation	0.46	0.46	0.40	0.40	D-3039	
	In certain applications and at the engi- neer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In	Shear Strength +/-45 in. Plane	9,100	63	8,100	56	D-3518	
		Shear Modulus +/-45 in. Plane	421,200	2,902	406,000	2,800	D-3518	
	these cases, a thorough cleaning of the	Ply Thickness	0.015	0.381				
	substrate using low pressure sand or water blasting is sufficient.	<ul> <li>* 24 sample coupons per test series; all other values based on 6 coupon test series.</li> <li><sup>1</sup> Average value of test series.</li> <li><sup>2</sup> Average value minus 2 standard deviations</li> </ul>						
Vixing	Consult Sikadur Hex 300 or Sikadur 330 technical data sheets for information	on epoxy resi	ns					
Application	SikaWrap Hex 230C can be applied using			nods.				
	<b>Dry Lay-Up:</b> Apply the mixed Sikadur 33 a rate of 40-50 ft. <sup>2</sup> /gal. (32-40 mils), dependent the resin with gloved hands and smooth of laminating roller. Allow the resin to squee: layer of fabric is required apply additional mils) and repeat as above. Apply a final cat a rate of 160ft. <sup>2</sup> /gal. (10 mils).	nding on the s out any irregul ze out betwee Sikadur 330 o oat of Sikadur	surface pr arities or en the rov or SIkadu 330 or S	ofile. Car air pocke ings of th r 301 at a Sikadur 3	efully plac ts using a le fabric. If a rate of 10 01to the e	the fab plastic f more the 00ft.²/gal. xposed s	oric into an one (16 surface	
	Wet Lay-Up: Seal the prepared concrete Material may be applied by spray, brush of either the Sikadur 300/Hex 300 epoxy or s should be accomplished using an automat concrete surface and smooth out any irreg required, apply additional layers of fabric or vertical applications, prime concrete wi Sikadur 300/Hex 300 or Sikadur 301. Coa 670W or Sikagard 62. Installation of SikaWrap Products should be	or roller. Sikav Slkadur 301. I ted saturator. gulari-ties or a while epoxy o th Sikadur 330 th exposed	Vrap Hex For best r Once sa air pocket n previou 0 to impro d surface	230C ca results, th turated, a s using a s layer is ove tack. of final fa	n be impre e impregr apply fabric plastic lar still tacky Saturate f bric layer	egnated ( nation pro- c to the s minating . For ove abric with using Sile	using ocess ealed roller. If rhead n kagard	
Tooling & Finishing	Fabric can be cut to appropriate length by dull or worn cutting implements can dama Consult MSDS for proper handling proces	ige, weaken o						
Limitations	<ul> <li>Design calculations must be made and on System is a yapar barrier. Congrete ab</li> </ul>						ineer.	
	<ul> <li>System is a vapor barrier. Concrete sł</li> </ul>	ioulu not be e	incapsula	lieu in are	eas of free	ze/thaw.		



KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

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Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

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## **SikaWrap® 1200C** High Modulus Carbon Fiber Fabric for Structural Strengthening

Description	eithe reinf over	er Sikadur <sup>®</sup> Hex 30 forced polymer (CF	00 or Sikadur® He FRP) used to stre her Sikadur® 30 or	ex 330 ep ngthen st	oxy as an impreg ructural elements	nating re . For app	ial is field laminated using sin to form a carbon fiber lications to vertical and/or prepared concrete surface
Where to Use	Seis 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	d Increases increasing the live increasing traffic v installation of heav Vibrating structure Changes of buildir smic Strengtheni Column wrapping Masonry walls nage to Structura Aging of constructiv Vehicle impact Fire Blast Resistance inge in Structura Removal of walls of Removal of slab si ign or Construct Insufficient reinford nsufficient structu	olumes on bridge y machinery in in s ig utilization ng I Parts ion materials I System or columns ections for openin ion Defects cement	es ndustrial l	buildings		
	R M T S S S S C P P A A T T T T E C N C C	Typical Data (Mate ESULTS MAY DIFFER E IENT, TEMPERATURE, A IONS. Shelf Life Storage Conditions Color Primary Fiber Direction Virimary Fiber Direction Colored Laminate Prope Properties after standard of Virial Viria	ASED UPON STATIST APPLICATION METHON 10 year Store dr Black on 0° (unid 36.50 or perties 580,000 35.0 x 1 1.7% 0.065 lb 0.064 lr 0.065 lb 0.064 lr rties with Sikadur 30 ure [70°-75°F (21°-24°C Avg. Ultimate	CAL VARIA S, TEST ME y at 40°-95 irectional) z/sq.yd (12 ) psi (4.00 ( 0° psi (240 /in^3 (1.80 . (1.63 mm 0/Sikadur H	rions depending up THODS, ACTUAL SITE °F (4°-35°C) 38 g/m²) GPa) GPa) g/cm3) ) tex 300 Epoxy	CON MIXING	METHODS AND EQUIP- NS AND CURING CONDI-
	-		Value				
		Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	-		psi	MPa	psi	MPa	
	-	Tensile Strength	168,591.9	1,162.4	(f*fu) 132,650*	914.6	D3039/D7565
	-	Tensile Modulus	-	-	(Ef) 10,098,776.6	7,575.8	D3039/D7565
		Tensile % Elonga- tion	1.4	1.4	(e*fu) 1.02*	1.02*	D3039/D7565
		Nominal Ply Thick- ness (in./mm)	0.075	1.9	0.075	1.9	
		Tensile Strength per in. width	12.6 kips/in. width	-	9.9 kips/in. width	-	-
		Stiffness (Ef*A) per in. width	-	-	823.8 kips/in. width	-	
	E E						



Advantages	<ul> <li>Used for shear, confinement or flexural strengthening</li> <li>Flexible, can be wrapped around complex shapes</li> <li>High Strength</li> <li>Light Weight</li> <li>Non-corrosive</li> <li>Alkali Resistant</li> <li>Low Aesthetic Impact</li> </ul>
Packaging	50 in. x 135 ft. (127 cm x 41.2 m)
How to Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials, and other bond inhibiting materials from the surface. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand blasting or water blasting is sufficient.
Mixing	Consult the current product data sheet(s) for recommendations on the specified Sikadur epoxy adhesive(s) needed.
Application	Prior to placing the fabric, the concrete surface is primed and sealed using the appropriate Sikadur <sup>®</sup> epoxy adhesive (e.g. Sikadur <sup>®</sup> 30, Sikadur <sup>®</sup> 330 US or Sikadur <sup>®</sup> Hex 300). Material may be applied by spray, brush or roller. SikaWrap <sup>®</sup> 1200C can be impregnated using Sikadur <sup>®</sup> Hex 300 epoxy. For best results on larger projects, the impregnation process should be accomplished using Sikadur <sup>®</sup> Hex 300 and a mechanically driven saturator or similar device. In special cases where the size of the project does not justify the use of a saturator, the fabric may be saturated by hand using a ruller prior to placement. In either case, installation of this system should be performed only by a specially trained contractor. For overhead and vertical applications, prime concrete with Sikadur <sup>®</sup> 30 or Sikadur <sup>®</sup> 330 US to improve tack. Saturate fabric with Sikadur <sup>®</sup> Hex 300. Coat the exposed surface of final fabric layer using Sikagard <sup>®</sup> 670W or Sikagard <sup>®</sup> 62.
Tooling & Finishing	Fabric can be cut to appropriate length by using a commercial quality, heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided.
Limitations	<ul> <li>DESIGN CALCULATIONS MUST BE MADE AND CERTIFIED BY AN INDEPENDENT LICENSED PROFESSIONAL ENGINEER.</li> <li>SYSTEM IS A VADOR PADRIED. CONCRETE SHOULD NOT BE ENCADED IN AREAS.</li> </ul>
	SYSTEM IS A VAPOR BARRIER. CONCRETE SHOULD NOT BE ENCAPSULATED IN AREAS OF FREEZE/THAW.
	Sika cannot and will not deternine the location, spacing, and orientation of the SikaWrap <sup>®</sup> system installation on actual projects.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Visit our website at usa.sika.com

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Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE





**Product Data Sheet** Edition 5.17.2016 Identification no. SikaWrap 600C

### **SikaWrap<sup>®</sup> 600C ± 45** Double Bias Carbon Fiber Fabric for Structural Strengthening

Description SikaWrap 600C is a high strength, bi-directional carbon fiber fabric. Material is field laminated using Sikadur 300/Hex 300, Sikadur 301 or Sikadur 330 epoxy to form a carbon fiber reinforced polymer (CFRP) used to strengthen structural elements. Where to Use Loading Increases Increasing the live loads in warehouses Increasing traffic volumes on bridges Installation of heavy machinery in industrial buildings Vibrating structures Changes of building utilization Seismic Strengthening Column wrapping Masonry walls Damage to Structural Parts Aging of construction materials Vehicle impact Fire Blast Resistance Change in Structural System Removal of walls or columns removal of slab sections for openings Design or Construction Defects Insufficient reinforcements Insufficient structural depths Advantages Provides high strength in multiple directions Used for shear, confinement or flexural strengthening Flexible, can be wrapped around complex shapes High Strength Light Weight Non-corrosive Alkali Resistant Low Aesthetic Impact Packaging Rolls: 50" x 225 ft

#### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Storage Conditions Shelf Life	Store dry at 40°-95°F (4°-35°C) 10 years
Product Conditioning	Condition fabric to same temperature as recommended for conditioning the specified Sikadur epoxy adhesive(s)
Color	Black
Primary Fiber Direction	+45/-45° (bidirectional)
Area Weight	17.11 oz/sq.yd (580 g/m2)
Typical Dry Fiber Properties	
Tensile Strength	711,000 psi (4900 MPa)
Tensile Modulus	33.4 x 10 <sup>6</sup> psi (230 GPa)
Elongation	2.1%
Density	0.065 lb/in^3 (1.80 g/cm3)

Cured Laminate Properties with Sikadur 300 tested in primary fabric direction Properties after standard cure  $(70^\circ-75^\circF (21^\circ-24^\circC) 7 days$ 

	Avg. Ultimate Value		Design Value		
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	Мра	Design	Мра	
Tensile Strength	117,186 psi	807	(f*fu) 80,166	552	D3039/D7565
Tensile Modulus	-	-	(Ef) 6,500,000	44,815	D3039/D7565
Tensile % Elongation	1.73	1.73	(e*fu) 1.4	1.4	D3039/D7565
Nominal Ply Thickness (in./mm)	0.073	1.85	0.073	1.85	
Tensile Strength per in. width	8.55 kips/in. width	-	5.85 kips/in. width	-	-

All stated values reported above are absolute values based on 20 test specimens

Appropriate safety factors should be applied for design values in accordance with design guide/code





How To Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, lai- tance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials, and other bond inhibiting materials from the surface. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand blasting or water blasting is sufficient.
Mixing	Consult the current product data sheet(s) for recommendations on the specified Sikadur epoxy adhesive(s) needed
Application	Prior to placing the fabric, the concrete surface is primed and sealed using the appropriate Sikadur epoxy adhesive (e.g. Sikadur 300/Hex 300, Sikadur 301 or Sikadur 330 US). Material may be applied by spray, brush or roller.
	SikaWrap 600C ±45 can be impregnated using Sikadur 300/Hex 300 or Sikadur 301 epoxy. For best results on larger projects, the impregnation process should be accomplished using Sikadur Hex 300 and a mechanically driven saturator or similar device. In special cases where the size of the project does not justify the use of a saturator, the fabric may be saturated by hand using a ruler prior to placement. In either case, installation of this system should be performed only by a specially trained contractor.
	For overhead and vertical applications, prime concrete with Sikadur 30 or Sikadur 330 US to improve tack. Saturate fabric with Sikadur Hex 300. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62.
Tooling & Finishing	Cutting SikaWrap
	Fabric can be cut to appropriate length by using a commercial quality, heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber, their use should be avoided.
Limitations	<ul> <li>DESIGN CALCULATIONS MUST BE MADE AND CERTIFIED BY AN INDEPENDENT LICENSED PROFESSIONAL ENGINEER</li> <li>SYSTEM IS A VAPOR BARRIER. CONCRETE SHOULD NOT BE ENCAPSULATED IN AREAS OF FREEZE/THAW</li> <li>Sika cannot and will not determine the location, spacing, and orientation of the SikaWrap system installation on actual projects.</li> </ul>

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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Product Data Sheet Edition 5.16.2015 Identification no. SikaWrap® FX-50 C

## SikaWrap<sup>®</sup> FX-50 C

Carbon fiber rope for structural connection and anchoring of SikaWrap strengthening systems

Description	SikaWrap <sup>®</sup> FX-50 C is a unidirect serves as fibre connector for the	ional carbon fibre string, encased in a plastic envelope, tha anchorage of SikaWrap <sup>®</sup> fabrics.	
Where to Use	<ul> <li>Anchoring SikaWrap<sup>®</sup> carbon and glass fibre fabrics on concrete or masonry</li> <li>Connecting SikaWrap<sup>®</sup> carbon or glass fibre fabrics through concrete or masonry structures</li> <li>Flexible near surface mounted strengthening (NSM)</li> </ul>		
Advantages	<ul> <li>Carbon fibre, corrosion resistant, durable</li> <li>Multifunctional use</li> <li>Easy to install</li> </ul>		
Coverage	Primer layer: 0.5 – 0.7 kg/m2 Anchor impregnation: 25 – 30 g/100 mm SikaWrap® fabrics: Please refer to the relevant product data sheet		
Packaging	82 ft (25m) rolls on plastic reel dis	spenser in a box	
		TISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.	
	Fibre Type Construction Packaging Storage Conditions/Shelf-Life Weight Fibre Cross Section Fibre Density Dry fibre properties Values in longitu Tensile Modulus Tensile Strength Elongation at break Composite Cross Section	Carbon Fiber Unidirectional carbon fiber rope encased in a plastic envelope 25 m roll on a plastic reel dispenser Unlimited, provided there is no exposure to direct sunlight (UV light), in dry conditions and at temperatures of max. 122°F (50°C) Transportation only in the original packaging, or otherwise adequately protected against any mechanical damage ≥ 15.24 g/ft (carbon fibre content) ≥ .034 in <sup>2</sup> (based on carbon fibre content) 1820 g/l udinal direction of the fibres 3.48 *10^7 psi (2.4x10 <sup>5</sup> MPa) 5.8 x 10^5 psi (4000 MPa) >1.6% (nominal) .086 sq.in. (assumption: 50% fibre content)	
	*Values according to ASTM D 4018 Composite Properties Impregnating Resin Composite Cross Section Tensile Modulus Tensile Strength	Sikadur <sup>®</sup> -300, Sikadur <sup>®</sup> -330 0.1 sq.in. (assumption: 50% fibre content) 3.33 *10^7 psi (2.3x10 <sup>5</sup> MPa) 3.04 x 10^5 psi (2100 MPa)	



nd fabric application details, please refer to the relevant Product Data Sheets and the
anding water, grease, oils, old surface treatments or coatings and any loosely adhering par- cles. Concrete must be cleaned and prepared to achieve a laitance and contaminant free, ben textured surface. epairs and levelling: If carbonized or weak concrete cover has to be removed or levelling of neven surfaces is needed, the following systems can be applied: Structural repair materials: ikadur®-41 epoxy repair mortar, Sikadur®-30 adhesive or the Sika® MonoTop®-412 (horizontal, ertical, overhead) or Sika® MonoTop®-438 (horizontal, top-side) range (cementitious). (Details in application and limitation see the relevant Product Data Sheets) or further details, see also the Method Statements of installation of SikaWrap® FX (Ref. 850 108), SikaWrap® manual dry application (Ref. 850 41 02) SikaWrap® manual wet application Ref. 850 41 03) or SikaWrap® machine wet application (Ref. 850 41 04). The system build-up and configuration as described must be fully complied with and may not e changed. Inchorage resin: Sikadur®-330, Sikadur®-300/Hex 300 or Anchorfix®-3001. hpregnating / laminating resin: Sikadur®-300/Hex 300 tructural strengthening fabric: SikaWrap® carbon or glass fibre fabric or detailed information on Sikadur®-330 or Sikadur®-300/Hex 300 together with the resin nd fabric application (Ref. 850 41 03) and Installation of SikaWrap® FX (Ref. 850 41 02), sikaWrap® manual dry application (Ref. 850 41 02), SikaWrap® anual wet application (Ref. 850 41 03) and Installation of SikaWrap® FX (Ref. 850 41 02). <b>pplication Method / Tools</b> the SikaWrap® FX can be cut with special scissors. Please refer to the Method Statement installation of SikaWrap® FX (Ref. 850 41 09) for the anchor installation and the Method tatement of SikaWrap® manual wet application (Ref. 850 41 03) or SikaWrap® machine wet
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plication (ref. 656 + 1 6+) for the impregnating / laminating procedure of the labres.
otes on Application / Limitations
nis product should only be used by trained and experienced professionals.
ne strengthening application is inherently structural and great care must be taken when noosing suitably experienced contractors.
otes and limitations mentioned in the Method Statement Installation of SikaWrap <sup>®</sup> FX (Ref. 50 41 08) must be taken into account.
ne SikaWrap <sup>®</sup> products are coated to ensure maximum bond and durability with the Sikadur <sup>®</sup> dhesives / impregnating / laminating resins. To maintain and ensure full system compatibility, o not interchange different system components.
he SikaWrap <sup>®</sup> system can be over coated with a cementitious overlay or other coatings for esthetic and / or protective purposes. The over coating system selection is dependent on the prosure and the project specific requirements. For additional UV light protection in exposed reas use Sikagard <sup>®</sup> -550 W or Sikagard 670W.
lease refer to the Method Statement of SikaWrap <sup>®</sup> manual dry application (Ref. 850 41 02), ikaWrap <sup>®</sup> manual wet application (Ref. 850 41 03) or SikaWrap <sup>®</sup> machine wet application Ref. 850 41 04) for further information, guidelines and limitations.

Limitations

- This product should only be used by trained and experienced professionals.
- The strengthening application is inherently structural and great care must be taken when choosing suitably experienced contractors.
- Notes and limitations mentioned in the Method Statement Installation of SikaWrap® Fibre Connectors (Ref. 850 41 08) must be taken into account.
- The SikaWrap<sup>®</sup> products are coated to ensure maximum bond and durability with the SikadurR adhesives / impregnating / laminating resins. To maintain and ensure full system compatibility, do not interchange different system components.
- The SikaWrap<sup>®</sup> system can be over coated with a cementitious overlay or other coatings for aesthetic and / or protective purposes. The over coating system selection is dependent on the exposure and the project specific requirements. For additional UV light protection in exposed areas use Sikagard®-550 W Elastic, Sikagard® ElastoColor-675 W or Sikagard®-680 S.
- Please refer to the Method Statement of SikaWrap<sup>®</sup> manual dry application (Ref. 850 41 02), SikaWrap® manual wet application (Ref. 850 41 03) or SikaWrap® machine wet.

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Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Product Data Sheet Edition 5.17.2016 SikaWrap Hex 100G

## SikaWrap Hex<sup>®</sup> 100G Glass fiber fabric for structural strengthening

Description	SikaWrap Hex 100G is a unidirectional E-glass fiber fabric. Material is field laminated using Sikadur 300/Hex 300 or Sikadur 301 epoxy to form a glass fiber reinforced polymer (GFRP) used to strengthen structural ele-ments.					
Where to Use	<ul><li>Damage to structural parts</li><li>Temporary strengthening</li><li>Change in structural system</li></ul>	<ul> <li>Seismic strengthening of columns and masonry walls</li> <li>Damage to structural parts</li> <li>Temporary strengthening</li> <li>Change in structural system</li> <li>Design or construction defects</li> </ul>				
Advantages	<ul> <li>Approved by ICBO/ICC ER-5558.</li> <li>Used for shear, confinement or flexural strengthening.</li> <li>Flexible, can be wrapped around complex shapes.</li> <li>Light weight.</li> <li>Non-corrosive.</li> <li>Acid resistant.</li> <li>Low aesthetic impact.</li> <li>Economical.</li> </ul>					
Packaging	Rolls: 50 in. x 30 ft., 50 in. x 150	ft.				
How to Use						
Surface Preparation	dust, laitance, grease, curing com rials and other bond inhibiting ma Hex 300/306 and Sikadur 330 teo	. It may be dry or damp, but free of standing water and frost. Remove pounds, impregnations, waxes, foreign particles, disintegrated mate iterials from the surface. Consult Sikadur 300, Sikadur 301, Sikadu chnical data sheets for additional information on surface preparation				
	Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified following surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.					
	Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture. In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand or water blasting is sufficient.					
	T 1 1 D (					
		N STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, HODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.				
	Storage Conditions Color Primary Fiber Direction Weight Per Square Yard	Store dry at 40°-95°F (4°-35°C) White 0° (unidirectional) 27 oz. (913 g/m²)				
	Fiber Properties Tensile Strength Tensile Modulus Elongation Density Nominal Thickness	3.3 x 10 <sup>5</sup> psi (2,276 MPa) 10.5 x 10 <sup>6</sup> psi (72,413 MPa) 4% 0.092 lbs./in. <sup>3</sup> (2.54 g/cc) 0.014 in. (0.359 mm)				

#### Cured Laminate Properties with Sikadur Hex 300 Epoxy Properties after standard cure followed by standard post cure [70°-75°F (21°-24°C) - 5 days, 48 hours at 140°F (60°C)]

	Average Value <sup>1</sup>		Design Value <sup>2</sup>		
Property	US Units, psi	SI Units, MPa	US Units, psi	SI Units, MPa	ASTM Test Method
Tensile Strength*	88,800	612	77,100	531	D-3039
Tensile Modulus*	3,790,800	26,119	3,426,300	23,607	D-3039
Tensile % Elongation*	2.45	2.45	2.12	2.12	D-3039
140°F - Tensile Strength	79,900	551	75,700	521	D-3039
140°F - Tensile Modulus	3,728,000	25,690	3,221,600	22,197	D-3039
140°F - % Elongation	2.28	2.28	2.07	2.07	D-3039
Compressive Strength	86,600	597	74,600	515	D-695
Compressive Modulus	4,312,700	29,715	3,903,800	23,384	D-695
90° Tensile Strength	4,400	30	2,900	20	D-3039
90° Tensile Modulus	965,000	6,649	892,700	6,159	D-3039
90° % Tensile Elongation	0.46	0.46	0.28	0.28	D-3039
Shear Strength, +/- 45 in. Plane	5,800	40	4,600	32	D-3518
Shear Modulus +/- 45 in. Plane	335,900	2,314	291,500	2,012	D-3518
Ply Thickness (in./mm)	0.04	1.016	0.04	1.016	

#### Cured Laminate Properties with Sikadur Hex 306 Epoxy Properties after standard cure followed by standard post cure [70°-75°F (21°-24°C) - 5 days, 48 hours at 140°F (60°C)]

	Average Value <sup>1</sup>		Design Value <sup>2</sup>		
Property	US Units, psi	SI Units, MPa	US Units, psi	SI Units, MPa	ASTM Test Method
Tensile Strength*	83,400	575	72,900	484	D-3039
Tensile Modulus*	3,672,000	25,300	2,999,900	20,044	D-3039
Tensile % Elongation*	2.31	2.31	1.89	1.89	D-3039
140°F - Tensile Strength	69,300	477	62,400	431	D-3039
140°F - Tensile Modulus	3,306,400	22,781	2,970,700	20,468	D-3039
140°F - % Elongation	2.19	2.19	1.92	1.92	D-3039
Compressive Strength	75,000	517	64,800	447	D-695
Compressive Modulus	4,248,200	29,270	2,902,400	24,446	D-695
90° Tensile Strength	5,000	34	3,200	22	D-3039
90° Tensile Modulus	819,800	5,648	710,300	4,895	D-3039
90° % Tensile Elongation	0.66	0.66	0.45	0.45	D-3039
Shear Strength, +/- 45 in. Plane	6,100	42	5,500	38	D-3518
Shear Modulus +/- 45 in. Plane	337,200	2,323	297,600	2,050	D-3518
Ply Thickness (in./mm)	0.04	1.016	0.04	1.016	

\* 24 sample coupons per test series; all other values based on 6 coupon test series <sup>1</sup> Average value of test series

<sup>2</sup> Average value minus 3 standard deviations

Mixing	Consult either Sikadur 300, Sikadur 301, or Sikadur Hex 300/306 data sheets for information on epoxy
	resins.

Application	Prior to placing the fabric, the concrete surface is sealed using Sikadur 300/Hex 300 or SIkadur 301 epoxy. Material may be applied by spray, brush or roller. SikaWrap Hex 100G can be impregnated using Sikadur Hex 300 epoxy. For best results on larger projects, the impregnation process should be accomplished using a mechanically driven fabric saturator or similar device. In special cases where the size of the project does not justify the use of a saturator, the fabric may be saturated by hand using a roller prior to placement. In either case, installation of this system should be performed only by a specially trained, approved contractor.
	For overhead and vertical applications, prime concrete with Sikadur 30 or Sikadur 330 to improve

tack. Saturate fabric with Sikadur 300/Hex 300 or Sikadur 301.

Cutting SikaWrap Fabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber their use should be avoided. Consult MSDS for proper handling procedures. Limitations

Design calculations must be made and certified by an independent licensed professional engi-neer System is a vapor barrier. Concrete should not be encapsulated in areas of freeze/thaw. 

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Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

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## SikaWrap<sup>®</sup> Hex 106G Bi-directional Glass fiber fabric for structural strengthening

Sił		ectional E-glass fiber fabric. Material is field laminated using dur 300/Hex 300 epoxy to form a glass fiber reinforced polymer ral elements.
	Load increases Seismic strengthening of: Columns Masonry walls Damage to structural parts Temporary strengthening Change in structural system Design or construction defects	s
Advantages	Approved by ICBO/ICC ER-55 Used for shear, confinement of Flexible, can be wrapped arou Light weight. Non-corrosive. Acid resistant. Low aesthetic impact. Economical.	r flexural strengthening.
Packaging Ro	Ils: 50 in. x 450 ft.	
		STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, ODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Store dry at 40°-95°F (4-35°C) White 0°/90° (bi-directional) 9.6 oz. (325 g/m <sup>2</sup> ) 1:1 <b>5 (0° &amp; 90°) Design Values</b> 35,300 psi (244 MPa) 2.35 x 10 <sup>6</sup> psi (16,215 MPa) 1.43% 0.013 in. (0.33 mm) 572 lbs./layer (2.53 kN) 3.3 x 10 <sup>5</sup> psi (2,276 MPa) 10.5 x 10 <sup>6</sup> psi (72,390 MPa) 4% 0.092 lbs/in <sup>3</sup> (2.54 g/cc)



How to Use	
Surface Preparation	<ul> <li>Surface must be clean and sound. It may be dry or damp, but free of standing water and frost.</li> <li>Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials, and other bond inhibiting materials from the surface. Consult Sikadur Hex 300 and Sikadur 330 technical data sheets for additional information on surface preparation.</li> <li>Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified following surface preparation by random pull-off testing (ACI 503R) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.</li> <li>Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide an open roughened texture.</li> </ul>
	In certain applications and at the engineer's discretion, the intimate contact between the substrate and the fabric may be determined to be non-critical. In these cases, a thorough cleaning of the substrate using low pressure sand or water blasting is sufficient.
Mixing	Consult Sikadur 330, Sikadur 301 or Sikadur 300/Hex 300 product data sheets for more information
Application	SikaWrap Hex 106G can be applied using wet or dry lay-up methods.
	<b>Dry Lay-Up:</b> Apply the mixed Sikadur 330 or Sikadur 301 epoxy resin directly onto the substrate at a rate of 40-50 ft <sup>2</sup> /gal. (32-40 mils), depending on the surface profile. Carefully place the fabric into the resin with gloved hands and smooth out any irregularities or air pockets using a plastic laminating roller. Al-low the resin to squeeze out between the rovings of the fabric. If more than one layer of fabric is required apply additional Sikadur 330/301 at a rate of 100ft <sup>2</sup> /gal. (16 mils) and repeat as above. Apply a final coat of Sikadur 330/301 to the exposed surface at a rate of 160ft <sup>2</sup> /gal. (10 mils).
	<b>Wet Lay-Up:</b> Seal the prepared concrete surface using Sikadur 300/Hex 300. Material may be applied by spray, brush or roller. SikaWrap Hex 106G can be impregnated using Sikadur 300/Hex 300 epoxy. For best results, the impregnation process should be accomplished using an automated fabric saturating device. Once saturated, apply fabric to the sealed concrete surface and smooth out any irregularities or air pockets using a plastic laminating roller. If required, apply additional layers of fabric while epoxy on previous layer is still tacky. For vertical and overhead applications, prime with Sikadur 330 for improved tack. Coat the exposed surface of final fabric layer using Sikagard 670W or Sikagard 62.
	Installation of SikaWrap products should be performed only by specially trained approved contrac- tors.
Cutting SikaWrap	Fabric can be cut to appropriate length by using a commercial quality heavy duty scissor. Since dull or worn cutting implements can damage, weaken or fray the fiber their use should be avoided. Consult MSDS for proper handling procedures.
Limitations	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> <li>System is a vapor barrier. Concrete should not be encapsulated in areas of freeze/thaw.</li> </ul>

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C.P. 76920

Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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# SikaWrap<sup>®</sup> Pre-saturated 103C Carbon fiber fabric for structural strengthening

Description	SikaWrap <sup>®</sup> Pre-saturated 103C is a high strength, unidirectional carbon fiber fabric pre-saturated to form a carbon fiber reinforced polymer (CFRP) used to strengthen structural concrete elements.		
Where to Use	<ul> <li>Load Increases</li> <li>Increased live loads</li> <li>Increased traffic volumes on bridges</li> <li>Installation of heavy machinery in industrial build</li> <li>Vibrating structures</li> <li>Changes of building utilization</li> </ul>	ings	
	Seismic Strengthening  Column wrapping Masonry walls		
	<ul> <li>Damage to Structural Parts</li> <li>Aging of construction materials</li> <li>Vehicle impact</li> </ul>		
	<ul> <li>Fire</li> <li>Blast resistance</li> <li>Change in Structural System</li> </ul>		
	<ul> <li>Removal of walls or columns</li> <li>Removal of slab sections for openings</li> </ul>		
	<ul> <li>Design or Construction Defects</li> <li>Insufficient reinforcements</li> <li>Insufficient structural depth</li> </ul>		
Advantages	<ul> <li>Used for shear, confinement or flexural strengthening</li> <li>Flexible, can be wrapped around complex geometries</li> </ul>		
	<ul><li>High Strength</li><li>Light Weight</li></ul>		
	<ul> <li>Non-corrosive</li> <li>Alkali Resistant</li> </ul>		
Packaging	■ Low aesthetic impact Rolls: 24 in. x 30 ft.; Box of 2 rolls		
	Typical Data		
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPEND AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METH TIONS AND CURING CONDITIONS.		
	Storage:       Store dry at 40°F - 9         Shelf Life:       1 year in original participation         Color:       Black         Primary Fiber Direction:       0°F (unidirectional Areal Weight:         18 oz. / sq. yd. (618)	ckaging at recommended storage condition	
	Open Time:     2 hrs. after foil is op       Typical Fiber Properties     Property       Property     Typical Test Value	pened	
	Toperty         Typical rest value           Tensile Strength         5.5 x 10^5 psi (3,7           Tensile Modulus         34 x 10^6 (234,500           Elongation         1.5%	93 MPa)	
R	Density 0.065 lbs./in^3 (1.4 Normal Fiber Thickness 0.0135 in. (0.34 mi PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS	m)	
ka	INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SH SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH S RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET	EET, PRODUCT LABEL AND SAFETY DAT CALLING SIKA'S TECHNICAL SERVICE D RELIEVES THE USER OF THE OBLIGATIO IKA PRODUCT AS SET FORTH IN THE CU	

	Avg. Ultim	Avg. Ultimate Value		Design Value	
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	147,594	1,018	(f* <sub>fu</sub> ) 120,589*	831*	D3039/D7565
Tensile Modulus	-	-	(E <sub>T</sub> ) 12,320,000	84,943	D3039/D7565
Tensile % Elongation	1.12	1.12	(ε* <sub>fu</sub> ) 1.0*	1.0*	D3039/D7565
Nominal Ply Thickness (in./mm)	0.035	0.889	0.035	0.889	-
Tensile Strength per in. width	5.17 kips/in. width	-	4.22 kips/in. width*	-	-
Stiffness (E *A) per in. width	-	-	431.2 kips/in. width	-	-

### How to Use

Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult the current product data sheets for Sikadur 340 for additional information on surface preparation.
	Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off test- ing (ASTM D-4541) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	<b>Preparation Work: Concrete</b> - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface.Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient.
Application	Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur® 340. In either case, installation of this system should be performed only by a specially trained contractor.
Tooling & Finishing	Fabric can be cut to appropriate lengths by using a commercial quality heavy duty scissor. Since the dull or worn cutting implements can damage, weaken or fray the fabric, their use should be avoided.
Limitations	<ul> <li>System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/thaw.</li> </ul>
	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> </ul>
	<ul> <li>Do not place carbon fiber in direct contact with steel. Must be isolated (e.g. glass fabric) to protect against corrosion.</li> </ul>

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Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

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# SikaWrap<sup>®</sup> Pre-saturated 117C

Carbon fiber fabric for structural strengthening

Description	SikaWrap <sup>®</sup> Pre-saturated 117C is a unidirectional carbon fiber fabric pre-saturated to form a carbon fiber reinforced polymer (CFRP) used to strengthen structural concrete elements.		
Where to Use	Load Increases		
	Increased live loads		
	Increased traffic volume	s on bridges	
		chinery in industrial buildings	
	<ul> <li>Vibrating structures</li> </ul>		
	<ul> <li>Changes of building utili</li> </ul>	zation	
		201011	
	Seismic Strengthening		
	Column wrapping		
	Masonry walls		
	Damage to Structural Pa		
	Aging of construction ma	aterials	
	Vehicle impact		
	■ Fire		
	Blast resistance		
	Change in Structural System	stem	
	Removal of walls or colu	umns	
	Removal of slab section	s for openings	
	Design or Construction		
	Insufficient reinforcements		
	Insufficient structural de	pth	
Advantages	Used for shear, confineme	•	
•	Flexible, can be wrapped a		
	High Strength		
	■ Light Weight		
	■ Non-corrosive		
	<ul> <li>Alkali Resistant</li> </ul>		
Pookoging	■ Low aesthetic impact	rollo	
Packaging	Rolls: 24 in. x 30 ft.; Box of 2	Tons	
	Typical Data		
		ATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS ICATION METHODS, TEST METHODS, ACTUAL SITE CONDI-	
	Storage:	Store dry at 40°F - 95°F (4° - 35°C)	
	Shelf Life:	1 year in original packaging at recommended storage condition	
	Color:	Black	
	Primary Fiber Direction: Areal Weight:	0 ℉ (unidirectional) 9 oz. / sg. yd. (300 g/m^2)	
	Open Time:	2 hrs. after foil is opened	
	Typical Fiber Properties		
	Property	Typical Test Value	
	Tensile Strength	5.5 x 10^5 psi (3,793 MPa)	
	Tensile Modulus	34 x 10^6 (234,500 MPa)	
	Elongation	1.5% 0.065 lbs /in42 (1.8 g/cs)	
	Density	0.065 lbs./in^3 (1.8 g/cc)	

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Construct

	Avg. Ultim	Avg. Ultimate Value		Design Value	
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	119,770	825	(f* <sub>fu</sub> ) 93,662*	645*	D3039/D7565
Tensile Modulus	-	-	(E <sub>T</sub> )8,973,997	61,873	D3039/D7565
Tensile % Elongation	1.22	1.22	(ε* <sub>fu</sub> ) 1.04*	1.04*	D3039/D7565
Nominal Ply Thickness (in./mm)	0.019	0.48	0.019	0.48	-
Tensile Strength per in. width	5.17 kips/in. width	-	1.78 kips/in. width*	-	-
Stiffness (E *A) per in. width -		-	170.5 kips/in. width	-	-
* Average ultimate value minus 3 standard deviations					

**Surface Preparation** Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult the current product data sheets for Sikadur 340 for additional information on surface preparation. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off test- ing (ASTM D-4541) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure. Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface. Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient. Application Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur 340. In either case, installation of this system should be performed only by a specially trained contractor. Tooling & Finishing Fabric can be cut to appropriate lengths by using a commercial quality heavy duty scissor.

- Since the dull or worn cutting implements can damage, weaken or fray the fabric, their use should be avoided. Limitations
  - System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/thaw.
    - Design calculations must be made and certified by an independent licensed professional engineer.
    - Do not place carbon fiber in direct contact with steel. Must be isolated (e.g. glass fabric) to protect against corrosion.

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# SikaWrap<sup>®</sup> Pre-saturated 100G Glass fiber fabric for structural strengthening

Description	SikaWrap <sup>®</sup> Pre-saturated 100G is a high strength, unidirectional glass fiber fabric pre-saturated to form a glass fiber reinforced polymer (GFRP) used to strengther structural concrete elements.				
Where to Use	Load Increases Increased live loads Increased traffic volumes on Installation of heavy machine Vibrating structures	ery in industrial buildings			
	Changes of building utilizatio Seismic Strengthening	n			
	■ Column wrapping				
	Masonry walls				
	Damage to Structural Parts				
	Aging of construction materia	als			
	Vehicle impact				
	■ Fire				
	<ul> <li>Blast resistance</li> </ul>				
	Change in Structural System				
	Removal of walls or columns				
	Removal of slab sections for				
	Design or Construction Defe	cts			
	Insufficient reinforcements				
	Insufficient structural depth				
Advantages	Used for shear, confinement or				
	Flexible, can be wrapped around complex geometries				
	High Strength				
	■ Light Weight				
	Non-corrosive				
		<ul> <li>Alkali Resistant</li> <li>Low aesthetic impact</li> </ul>			
	•				
Packaging	Rolls: 24 in. x 30 ft.; Box of 2 rolls				
	Typical Data				
		CAL VARIATIONS DEPENDING UPON MIXING METHODS ON METHODS, TEST METHODS, ACTUAL SITE CONDI-			
	Storage:	Store dry at 40°F - 95°F (4° - 35°C)			
	Shelf Life: Color:	1 year in original packaging at recommended storage conditions White			
	Primary Fiber Direction:	0°F (unidirectional)			
	Areal Weight: Open Time:	27 oz. / sq. yd. (913 g/m^2) 2 hrs. after foil is opened			
		·			
	Typical Fiber Properties Property	Typical Test Value			
	Tensile Strength	3.3 x 10^5 psi (3,793 MPa)			
	Tensile Modulus	10.5 x 10^6 (234,500 MPa)			
	Elongation Density	4.0% 0.092 lbs./in^3 (2.54 g/cc)			
	Nominal Fiber Thickness	0.014 in (0.359 mm)			
ka®	INSTRUCTIONS ON THE PRODUCT'S MOST CURI SHEET WHICH ARE AVAILABLE ONLINE AT HTTP PARTMENT AT 800.933.7452 NOTHING CONTAINED TO READ AND FOLLOW THE WARNINGS AND INS	HE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT ://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DI D IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO ITRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUI AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.			

Construct

Cured Laminate Properties					
	Avg. Ultim	ate Value	Design V	/alue	
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	71,457	492	(f* <sub>fu</sub> ) 64,226*	442*	D3039/D7565
Tensile Modulus	-	-	(E <sub>T</sub> )3,807,839	26,254	D3039/D7565
Tensile % Elongation	1.85	1.85	(ε* <sub>fu</sub> ) 1.69*	1.69*	D3039/D7565
Nominal Ply Thickness (in./mm)	0.050	1.27	0.050	1.27	-
Tensile Strength per in. width	3.57 kips/in. width	-	3.21 kips/in. width*	-	-
Stiffness (E *A) per in. width	-	-	190 kips/in. width	-	-
* Average ultimate value minus 3 sta	* Average ultimate value minus 3 standard deviations				

#### How to Use

Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult the current product data sheets for Sikadur 340 for additional information on surface preparation. Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off test- ing (ASTM D-4541) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	Preparation Work: Concrete - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface.Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient.
Application	Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur 340. In either case, installation of this system should be performed only by a specially trained contractor.
Tooling & Finishing	Fabric can be cut to appropriate lengths by using a commercial quality heavy duty scissor. Since the dull or worn cutting implements can damage, weaken or fray the fabric, their use should be avoided.
Limitations	<ul> <li>System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/thaw.</li> </ul>
	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> </ul>

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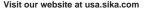
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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# SikaWrap<sup>®</sup> Pre-saturated 430G Glass fiber fabric for structural strengthening

Description	SikaWrap <sup>®</sup> Pre-saturated 430G is a unidirectional glass fiber fabric pre-saturated to form a glass fiber reinforced polymer (GFRP) used to strengthen structural concrete elements.		
Where to Use	Load Increases Increased live loads Increased traffic volume Installation of heavy mad Vibrating structures Changes of building utili Seismic Strengthening Column wrapping Masonry walls Damage to Structural Pa Aging of construction ma Vehicle impact	chinery in industrial buildings zation <b>rts</b>	
	<ul> <li>Fire</li> <li>Blast resistance</li> <li>Change in Structural System</li> <li>Removal of walls or colution</li> <li>Removal of slab section</li> <li>Design or Construction Insufficient reinforcement</li> <li>Insufficient structural depine</li> </ul>	imns s for openings <b>Defects</b> its	
Advantages	<ul> <li>Used for shear, confinement</li> <li>Flexible, can be wrapped and</li> <li>High Strength</li> <li>Light Weight</li> <li>Non-corrosive</li> <li>Alkali Resistant</li> <li>Low aesthetic impact</li> </ul>		
Packaging	Rolls: 24 in. x 30 ft.; Box of 2	rolls	
	Typical Data		
		ATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS ICATION METHODS, TEST METHODS, ACTUAL SITE CONDI-	
	Storage: Shelf Life: Color: Primary Fiber Direction: Areal Weight: Open Time:	Store dry at 40°F - 95°F (4° - 35°C) 1 year in original packaging at recommended storage conditions White 0°F (unidirectional) 13 oz. / sq. yd. (440 g/m <sup>2</sup> ) 2 hrs. after foil is opened	
	Typical Fiber Properties <u>Property</u> Tensile Strength Tensile Modulus Elongation Density	<u>Typical Test Value</u> 3.3 x 10^5 psi (3,793 MPa) 10.5 x 10^6 (234,500 MPa) 4.0% 0.092 lbs./in^3 (2.54 g/cc)	
ka®	INSTRUCTIONS ON THE PRODUCT'S MOST SHEET WHICH ARE AVAILABLE ONLINE AT PARTMENT AT 800.933.7452 NOTHING CONT TO READ AND FOLLOW THE WARNINGS AN	0.0068 in (0.173 mm) JCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE AINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION ID INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR ABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.	

Cured Laminate Properties					
	Avg. Ultim	ate Value	Design V	alue	
Property	US Units	SI Units	US Units	SI Units	ASTM Test Method
	psi	MPa	psi	MPa	
Tensile Strength	62,985	434	(f* <sub>fu</sub> ) 51,328*	353*	D3039/D7565
Tensile Modulus	-	-	(E <sub>T</sub> )4,357,548	30,044	D3039/D7565
Tensile % Elongation	1.44	1.44	(ε* <sub>fu</sub> ) 1.40*	1.40*	D3039/D7565
Nominal Ply Thickness (in./mm)	0.025	0.64	0.025	0.64	-
Tensile Strength per in. width	1.57 kips/in. width	-	1.28 kips/in. width*	-	-
Stiffness (E *A) per in. width	-	-	109 kips/in. width	-	-
* Average ultimate value minus 3 standard deviations					

#### How to Use

Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and other bond inhibiting materials from the surface. Consult the current product data sheets for Sikadur 340 for additional information on surface preparation.
	Existing uneven surfaces must be filled with an appropriate repair mortar. The adhesive strength of the concrete must be verified after surface preparation by random pull-off test- ing (ASTM D-4541) at the discretion of the engineer. Minimum tensile strength, 200 psi (1.4 MPa) with concrete substrate failure.
	<b>Preparation Work: Concrete</b> - Blast clean, shotblast or use other approved mechanical means to provide a roughened, open-textured surface.Round all corners to 1/2" radius in certain "contact critical" applications and at the engineers discretion, a thorough cleaning of the substrate using low pressure sand or water blasting may be sufficient.
Application	Prior to placing the fabric, the concrete surface is primed and sealed using Sikadur 340. In either case, installation of this system should be performed only by a specially trained contractor.
Tooling & Finishing	Fabric can be cut to appropriate lengths by using a commercial quality heavy duty scissor. Since the dull or worn cutting implements can damage, weaken or fray the fabric, their use should be avoided.
Limitations	<ul> <li>System is a vapor barrier. Concrete should not be fully encapsulated in areas of freeze/thaw.</li> </ul>
	<ul> <li>Design calculations must be made and certified by an independent licensed professional engineer.</li> </ul>

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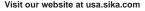
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

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# Sikadur<sup>®</sup> 31, Hi-Mod Gel LPL

High-modulus, high-strength, structural, extended pot life, epoxy paste adhesive

Description	Sikadur <sup>®</sup> 31, Hi-Mod Gel LPL is a 2-component, 100% solids, moisture-insensitive, high-modulus, high-strength, structural epoxy paste adhesive. It conforms to the current ASTM C-881, Types I and IV, Grade-3, Class-C and AASHTO M-235 specifications.
Where to Use	<ul> <li>Structural bonding of concrete, masonry, metals, wood, etc. to a maximum glue line of 1/8 in. (3mm).</li> <li>Seals cracks and around injection ports prior to pressure-injection grouting.</li> <li>Interior, vertical, and overhead repair of concrete as an epoxy mortar binder.</li> <li>As a pick-proof sealant around windows, doors, lock-ups etc. inside correctional facilities.</li> </ul>
Advantages	<ul> <li>Extended pot life.</li> <li>Moisture-tolerant before, during, and after cure.</li> <li>High-modulus, high-strength, structural paste adhesive.</li> <li>Excellent adhesion to concrete, masonry, metals, wood, and most structural materials.</li> <li>Paste consistency ideal for vertical and overhead applications.</li> <li>Fast-setting and strength-producing adhesive.</li> <li>Convenient easy mix ratio A:B = 2:1 by volume.</li> </ul>
Coverage	1 gal. yields 231 cu. in. of epoxy paste adhesive and grout. 1 gal. mixed with 1 gal. by loose volume of oven-dried aggregate yields approximately 346 cu. in. of epoxy mortar.
Packaging	3-gal. units.

#### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Shelf Life 2 years in original, unopened containers. Storage Conditions Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using. Color Concrete gray **Mixing Ratio** Component 'A': Component 'B' = 2:1 by volume Consistency Non-sag paste Pot Life Approximately 120 minutes @ 73°F (23°C) (gallon volume) Approximately 60 minutes @ 90°F (32°C) (gallon volume) **Tack-Free Time** 6-8 hours Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete Bond Strength 2,000 psi (20.7 MPa) 2 day 14 day Bond Strength 2,300 psi (20.0 MPa) (moist cure) Heat Deflection Temperature (ASTM D-648) [fiber stress loading = 264 psi (1.8 MPa)] 124°F (51°C) 7 day **Compressive Properties (ASTM D-695)** Compressive Strength, psi (MPa) 73°F (23°C) 36 hour 6,400 (41.4) 2 day 7,000 (41.4) 9,000 (48.3) 3 day



How to Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and any other contaminants. <b>Preparation Work:</b> Concrete - Sandblast or use other approved mechanical methods. <b>Steel</b> - Blast clean or use other equivalent mechanical means to achieve a white metal finish.
Mixing	<b>Pre-mix each component.</b> Proportion 1 part Component 'B' to 2 parts Component 'A' by volume into a clean pail. Mix thoroughly for 3 minutes with Sika paddle on low-speed (400 - 600 rpm) drill unti uniform in color. Mix only that quantity that can be used within its pot life.
	<b>To prepare an epoxy mortar:</b> Slowly add up to 1 part by loose volume of an oven-dried aggregate to 1 part of the mixed Sikadur <sup>®</sup> 31, Hi-Mod Gel LPL and mix until uniform in consistency.
Application	As a structural adhesive - Apply the neat mixed Sikadur <sup>®</sup> 31, Hi-Mod Gel LPL, to the mating or non- mating prepared substrates. Work into the substrate for positive adhesion. Secure the bonded uni firmly into place until the adhesion has cured. Glue line should not exceed 1/8 in. (3 mm).
	To seal cracks for injection grouting - Place the neat mixed material over the cracks to be pressure injected and around each injection port. Allow sufficient time to set before pressure injecting.
	For interior vertical and overhead patching - Place the prepared mortar in void, working the materia into the prepared substrate, filling the cavity. Strike off level. Lifts should not exceed 1 in. (25 mm).
	As a pick-proof sealant - Use automated or manual method. Apply an appropriate size bead of material around the area being sealed. Seal with neat Sikadur <sup>®</sup> 31, Hi-Mod Gel LPL.
Limitations	<ul> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not thin. Addition of solvents will prevent proper cure.</li> <li>Use oven-dried aggregate only.</li> <li>Maximum epoxy mortar thickness is 1 in. (25 mm) per lift.</li> <li>Epoxy mortar is for interior use only. Material is a vapor barrier after cure.</li> <li>Minimum age of concrete must be 21-28 days, depending upon curing and drying conditions, for mortar applications.</li> <li>Porous substrates must be tested for moisture-vapor transmission prior to mortar applications.</li> <li>Not for sealing cracks under hydrostatic pressure at the time of application.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

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C370

# Sikadur 31<sup>®</sup>, SBA Normal Set

Segmental Bridge Adhesive, Normal Set High-modulus, high-strength, moisture tolerant, epoxy paste adhesive

Description	Sikadur 31, SBA is a unique high-modulus 2- component, moisture-tolerant, solvent-free, epoxy resin system available in three application temperature ranges. A unique high-modulus, structural adhesive for bonding hardened concrete to hardened concrete for segmental bridge construction. The mixed material has the consistency of paste and is a concrete gray color. It conforms to the current ASTM C-881, Type VI requirements, and ASBI guidelines.
Where to Use	<ul> <li>Structural bonding of post-tensioned precast concrete bridge segments.</li> </ul>
	Sealing joints between concrete segments.
	For use in segment-by-segment erection.
	<ul> <li>Supplied in three temperature grades to meet project requirements. (For cold weather condi- tions, refer to separate technical data sheet on Sikadur 31, SBA [20°-45°F].)</li> </ul>
Advantages	<ul> <li>Moisture tolerant before, during and after cure.</li> </ul>
	<ul> <li>High-modulus, high-strength, structural paste adhesive.</li> </ul>
	Range of curing times to meet assembly and strength gain requirements.
	Easy to apply, non-sag paste for vertical applications.
	Excellent adhesion to concrete, steel and most construction materials.
	Convenient easy to mix ratios. A:B=2:1 by volume.
	<ul> <li>Color-coded components to ensure proper mixing control.</li> </ul>
Coverage	Approximately 12 sq. ft./gal. or 36 sq. ft./3 gal. unit.
Packaging	3 gal. units.

**Typical Data** (*Material and curing conditions* @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original, unopened containers.				
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 70°-75°F (21°-24°C) before using.				
Color	Concrete gray				
Consistency	Non-sag paste				
Product name Normal Set (40°-60°F) Normal Set (55°-95°F) Normal Set (80°-115°F)	<b>Temp. Range</b> 40°-60°F (4°-15° 55°-95°F (13°-35 80°-115°F (27°-4	°C) 2 5°C) 2	••	:B by volur	ne
Property		ASTM	SBA NS	SBA NS	SBA NS

Property	C881 Spec.	5BA NS 40°- 60°F	55°- 95°F	80°-115°F
Pot life, 1 gal., min (ASTM C881)		~ 60	~ 60	~ 60
Compressive Strength, psi (ASTM D695)				
24 hr	2000	2000	2000	2000
48 hr	6000	6000	6000	6000
Open Time (ASTM C881) Contact Strength after open time, 2 day, psi	1 hour 1000	1 hour 1000	1 hour 1000	1 hour 1000
Bond strength, 2 day, psi (ASTM C882)	1000	1000	1000	1000
Heat deflection Temp., °F (ASTM D648)	<u>≥</u> 120	<u>≥</u> 120	<u>≥</u> 120	<u>≥</u> 120



How to Use Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disinte- grated materials and any other contaminants.
Mixing	<b>Pre-mix each component</b> . Wear chemical resistant gloves and safety goggles. Mix all of Part 'A' with all of Part 'B'. Mix thoroughly for a minimum of 3 minutes with a low-speed (400-600 rpm) drill fitted with a mixing Sika paddle until a uniform gray color is achieved. Scrape down the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying. Mix only that quantity which can be used within its pot life.
Application	Apply the neat mixed Sikadur 31, SBA to the concrete surface using a trowel, spatula or glove pro- tected hand; work into surface, especially if it is damp. Spread to a thickness of 1/8" (3 mm) to one face or 1/16" (1.5 mm) on both faces, depending upon project requirements. Segments must be post-tensioned within the open time of the epoxy.
Removal	Ventilate area. Confine spill. Collect with absorbent material, flush area with water. Dispose of in accordance with current, applicable local, state and federal regulations. Uncured material can be removed with approved solvent. Follow solvent manufacturer's instructions for use and warnings. Cured material (when combined with component 'B') can only be removed mechanically.
Limitations	<ul> <li>Do not thin Sikadur 31, SBA. Solvents will prevent proper cure.</li> <li>Use correct temperature range material for prevailing conditions.</li> <li>Use correct setting material (normal or slow) depending on method of erection.</li> <li>Not for use as an adhesive for fresh, plastic portland cement concrete or mortar.</li> <li>Lower temperatures will prolong cure time. Higher temperatures will rapidly accelerate cure time.</li> <li>Use of product outside of designated temperature range is not recommended.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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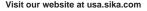
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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Product Data Sheet Edition 11.18.2014 Sikadur<sup>®</sup> 31, SBA Slow-Set

## Sikadur<sup>®</sup> 31, SBA Slow-Set

**Segmental Bridge Adhesive** High-modulus, high-strength, moisture tolerant, epoxy paste adhesive

Description	Sikadur <sup>®</sup> 31, SBA Slow-Set is a unique high-modulus 2-component, moisture-tolerant, solvent-free, epoxy-resin system available in three application temperature ranges. A unique high-modulus, structural adhesive for bonding hardened concrete to hardened concrete for segmental bridge construction. The mixed material has the consistency of paste and is a concrete gray color. It conforms to the current ASTM C-881, Type VII requirements, and ASBI guidelines.					
Where to Use	<ul> <li>Structural bonding of post-tensioned precast concrete bridge segments.</li> <li>Sealing joints between concrete segments.</li> <li>Slow-set version for span-by-span erection.</li> <li>Supplied in three temperature grades to meet project requirements.</li> </ul>					
Advantages	<ul> <li>Moisture tolerant before, during and after cure.</li> <li>High-modulus, high-strength, structural paste adhesive.</li> <li>Range of curing times to meet assembly and strength gain requirements.</li> <li>Easy to apply, non-sag paste for vertical applications.</li> <li>Excellent adhesion to concrete, steel and most construction materials.</li> <li>Convenient easy to mix ratios.</li> <li>Color-coded components to ensure proper mixing control.</li> </ul>					
Coverage	Approximately 12 ft <sup>2</sup> /gal.	or 36 ft²/3 gal. unit.				
Packaging	3 gal. units.					
	Shelf Life2 years in original, unopened containers.Storage ConditionsStore dry at 40°-95°F (4°-35°C). Condition material to 70°-75°F (21°-24°C) before using.ColorConcrete gray.ConsistencyNon-sag paste.Product Name Slow Set (40°-61°F) Slow Set (55°-75°F)Mix Ratio, A:B by Volume 25°-75°F (13°-24°C)Slow Set (55°-75°F) Slow Set (70°-90°F)70°-90°F (21°-32°C)					
	Property		ASTM C881 Spec.	SBA SS 40°- 61°F	SBA SS 55°-75°F	SBA SS 70°-90°F
	Pot life, 1 gal., hrs (ASTM	A C881)	-	~ 2	~ 2	~ 2
	Compressive Strength, p	si (ASTM D695)				
		36 hr	1000	1800	3000	6400
		72 hr	2000	4500	6500	9000
	Open Time (ASTM C881 Contact Strength after op		8 hours 1000	8 hours 1500	8 hours 2000	8 hours 1500
	Bond strength, 14 day, psi	, ,	1000	1800	2000	2300
	Heat deflection Temp., °F	= (ASTM D648)	120	122	124	124



How to Use	
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water and frost Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles disintegrated materials and any other contaminants.
Mixing	<b>Pre-mix each component.</b> Wear chemical resistant gloves and safety goggles. Mix all of Part 'A' with all of Part 'B'. Mix thoroughly for a minimum of 3 minutes with a low-speed (400-600 rpm) drill fitted with a mixing Jiffy paddle until a uniform gray color is achieved. Scrape dowr the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying Mix only that quantity which can be used within its pot life.
Application	Apply the neat mixed Sikadur <sup>®</sup> 31, SBA Slow-Set to the concrete surface using a trowel, spatula or glove protected hand; work into surface especially if it is damp. Spread to a thickness of 1/8' (3 mm) to one face or 1/16" (1.5 mm) on both faces, depending upon project requirements Segments must be post-tensioned within the open time of the epoxy.
Limitations	<ul> <li>Do not thin Sikadur<sup>®</sup> 31, SBA Slow-Set. Solvents will prevent proper cure.</li> <li>Use correct temperature range material for prevailing conditions.</li> <li>Use correct setting material (normal or slow) depending upon method of erection.</li> <li>Not for use as an adhesive for fresh, plastic, portland cement concrete or mortar.</li> <li>Lower temperatures will prolong cure time. Higher temperatures will rapidly accelerate cure time.</li> <li>Use of product outside of designated temperature range is not recommended.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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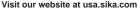
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Phone: 52 442 2385800 Fax: 52 442 2250537

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## Sikadur<sup>®</sup> 21, Lo-Mod LV Low-modulus, low-viscosity, epoxy resin binder

Description				lids, moisture-tolerant, epox C and AASHTO M-235 spe	y resin binder. It conforms to cifications.
/here to Use	Use as a binder for epoxy mortar for patching and overlays.				
dvantages	<ul> <li>Tolerant to moist</li> <li>Convenient easy</li> <li>Excellent strengt</li> <li>Low viscosity giv</li> <li>Material is USDA</li> </ul>	/ mix ratio A:B = th development. /es you easy har	1:1 by volume. ndling, high-yield		
overage	Prime Coat - appro Mortar Binder - 1 g oven-dried sand, yie	gal. of mixed Sik	adur <sup>®</sup> 21, Lo-Mo	od LV with the addition of 6	parts by loose volume of an
ackaging	4 gallon units. Note LV is a universal c			lod, Sikadur 22 Lo-Mod FS ucts.	and Sikadur 21 Lo-Mod
	Typical Data (Mat	erial and curing	conditions @	73°F (23°C) and 50% R.H.)	
				S DEPENDING UPON MIXING MET CTUAL SITE CONDITIONS AND CU	
	Shelf Life	2 years in	original, unopene	ed containers.	
	Storage Condition	ns Store dry a before usir	· · ·	5°C). Condition material to	65°-85°F (18°-29°C)
	Color	Clear, amb	er.		
	Mixing Ratio	Componer	t 'A':Component	'B' = 1:1 by volume.	
	Viscosity	Approxima	tely 1,000 cps.		
	Pot Life	Approximately 25 minutes. (200 gram mass)			
	Tack-Free Time     Approximately 3 hours; @ 90°F (32°C) Approximately 2 hours				2 hours
	Traffic Time 4-5 hours.				
	Tensile Properties	Tensile Properties (ASTM D-638) MORTAR 1:6 NEA			NEAT
	Elc	nsile Strength ongation at Brea odulus of Elastici		1,300 psi (8.9 MPa) 0.2 % 6.6 x 10 <sup>5</sup> psi (4,551 MPa)	5,800 psi (40.0 MPa) 5.5 % 1.43 x 10⁵ psi (986 MPa)
	Flexural Propertie		<b>)</b> ulus of Rupture)	MORTAR 1:6 2,300 psi (15.8 MPa) 1.2 x 10 <sup>6</sup> psi (8,274 MPa)	NEAT 9,600 psi (66.2 MPa) 2.98 x 10 <sup>5</sup> psi (2,055 MPa)
	Shear Strength (/			<u>MORTAR 1:6</u> 2,000 psi (13.7 MPa)	<u>NEAT</u> 5,670 psi (39 MPa)
	Water Absorption	0		2,000 por (10.7 wir d)	NEAT 0.26%
	Bond Strength (A 2 day (dr	STM C-882): Ha ry cure)	Bond Strength	te to hardened concrete 1,100 psi (7.5 MPa	)
	Abrasion (Taber		Bond Strength	1,600 psi (11 MPa)	MORTAR 1:6
	-	•	•	eel; 1,000 gm. weight)	4.1 gm
	Compressive Pro	perties (ASTM		ssive Strength, psi (MPa)	
	40'	°F*(4°C)	Mortar 1:6 73°F*(23°C)	(ASTM D-695) <b>90°F* (32°C)</b>	73°F (23°C) NEAT
	4 hour	-	-	500 (3.4)	-
	8 hour	-	400 (2.7)	2,200 (15.1)	-
		(0.13) (0.27)	2,100 (14.4) 2,600 (17.9)	4,600 (31.7) 4,700 (32.4)	116 (0.80) 1,900 (13.1)
		400 (9.6)	4,900 (33.7)	5,500 (37.9)	6,700 (46.2)
	7 day 3,5	500 (24.1)	5,400 (37.2)	6,200 (42.7)	9,000 (62.1)
		500 (31.0)	6,000 (41.3)	6,200 (42.7)	9,100 (62.7)
	<b>28 day</b> 4,6	600 (31.7)	6,100 (42.0)	6,200 (42.7)	9,200 (63.4)
					OLLOW THE WARNINGS AND
					T LABEL AND SAFETY DATA
	ET WHICH ARE AVAIL	ABLE ONLINE AT	" HTTP://USA.SIK/ TAINED IN ANY SI	DUCT DATA SHEET, PRODUC A.COM/ OR BY CALLING SIK/ KA MATERIALS RELIEVES TH	A'S TECHNICAL SERVICE I IE USER OF THE OBLIGATI

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	Compressive Modulus	MORTAR	NEAT		
	28 day	7.6 x 10⁵ psi (5,240 MPa)	2.58 x 10⁵ psi (1,779 MPa)		
	* Material cured and tested at the temperatures in	ndicated.			
How to Use					
Surface Preparation	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance grease, curing compounds, impregnations, waxes and any other contaminants.				
	Preparation Work:				
	<b>Concrete</b> - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means.				
	Steel - Should be cleaned and prepared thoroughly by blast cleaning to white metal finish.				
Mixing	Proportion equal parts by volume of Component 'A' and 'B' into clean pail. Mix thoroughly for 3 min. with Sik paddle on low-speed (400-600 rpm) drill until uniformly blended. Mix only that quantity that can be used with pot life.				
	To prepare epoxy mortar - Slowly add 6 parts by loose volume of oven-dried sand aggregate to 1 part o mixed Sikadur® 21, Lo-Mod LV. Mix until uniform in consistency.				
Application	<b>Epoxy Mortar -</b> Prime prepared surface with mixed Sikadur <sup>®</sup> 21, Lo-Mod LV. Apply epoxy mortar by trowel vibrating screed while primer is still tacky. Finish with finishing trowel.				
Limitations	<ul> <li>Minimum substrate and ambient te</li> <li>Porous substrates must be tested b</li> <li>D-4263).</li> <li>Minimum age of concrete before a</li> <li>Do not apply to exterior slab on gradients</li> </ul>	for moisture-vapor transmission pplication is 21-28 days depend	prior to application. (Ref. ASTM		
	<ul> <li>Do not apply to extend size on gra</li> <li>Maximum application thickness on</li> <li>Do not dilute. Addition of solvents of</li> <li>Use oven-dried aggregates only.</li> <li>Material is a vapor barrier after cur</li> <li>Not an aesthetic product. Color ma</li> </ul>	exterior substrates exposed to a will prevent proper cure.	с ( <i>, , ,</i>		

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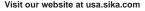
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> Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 6.27.2016 Sikadur<sup>®</sup> 22, Lo-Mod

# Sikadur<sup>®</sup> 22, Lo-Mod

Low-modulus, medium-viscosity, epoxy resin binder

cription	Sikadur <sup>®</sup> 22, Lo-Mod is a 2-component, 100% solids, moisture-tolerant, epoxy resin binder. It conforms to the current ASTM C-881, Type III, Grade-2, Class-C and AASHTO M-235 specifications.					
ere to Use	Use neat as the binder resin for a skid-resistant broadcast overlay. Use also as the binder resin for epoxy mortar and concrete for patching and overlays.					
antages	<ul> <li>Tolerant to moisture both before and after cure.</li> <li>Convenient easy mix ratio A:B = 1:1 by volume.</li> <li>Excellent strength development.</li> <li>Leveling viscosity for easy, efficient application of a broadcast overlay.</li> <li>Material is USDA-certifiable.</li> </ul>					
erage	1 gal. yields 231 in <sup>3</sup>					
	Mortar Binder - 1 ga dried sand, yields app				f 5 gal. by loose volume of an ove	
kaging	4 gallon units / 110 ga Mod FS and Sikadur				adur 22 Lo-Mod, Sikadur 22 Lo- e three products.	
	Typical Data [Mate	erial and curing	conditions @ 73	°F (23°C) and 5	0% R.H.]	
		ED UPON STATISTIC	AL VARIATIONS DEPE	NDING UPON MIXIN	G METHODS AND EQUIPMENT,	
	Shelf Life Storage Conditions Color		( , , , , , , , , , , , , , , , , , , ,		to 65°-85°F (18°-29°C) before using	
	Mixing Ratio Component 'A':Component 'B' = 1:1 by volume.					
	Viscosity Approximately 2,000 cps.					
	Pot Life         Approximately 30 minutes (200 gram mass).					
	Tack-Free Time	<b>40°F (4°C)</b> 24 hours	<b>73°F (23°C)</b> 5 hours	<b>90°F (32°C)</b> 2.5 hours		
	Traffic Time	6-8 hours				
	Elonga Modul	STM D-638) e Strength ation at Break us of Elasticity tested @ 0.5 in/m		15.2 MPa)	<b>Neat</b> 5,700 psi (39.3 MPa) >30 % 1.9 x 10⁵ psi (1,310 MPa)	
	Tensile Strength (AS		/ Mortar 1:3		Neat	
	14 day		1400 psi (9		2800 psi (19.3 MPa)	
	Shear Strength (AST 7 day Shear	M D-732) Strength	<b>Mortar 1:3</b> 3,000 psi (		<b>Neat</b> 5,700 psi (37.2 MPa)	
	Water Absorption (A) 7 day (24 ho	STM D-570) our immersion)			<b>Neat</b> 0.26 %	
	Direct Tensile (ASTM 7 day	C-1503; ACI 503	3): Mortar 1:: 510 psi co		<b>Neat</b> 570 psi concrete fail	
	•	a <b>der)</b> t loss, 1,000 cycl wheel; 1,000 gm	0	3	Neat .030 gm	



Const

	Compressive Properties (ASTM D-695) Mortar 1:3				
	8 hour 16 hour 1 day 3 day 7 day 14 day 28 day Compressive Mo 28 day	rength, psi (MPa) 40°F* (4°C) - - 2,200 (15.2) 6,500 (44.8) 7,900 (59.5) 8,800 (60.7) 9,500 (65.5) odulus 6.6 x 10 <sup>4</sup> psi (455 sted at the temperatures indicated	,	<b>90°F* (32°C)</b> 2,800 (19.3) 5,000 (34.5) 5,200 (35.9) 5,900 (40.7) 6,100 (42.1) 6,100 (42.1) 6,100 (42.1)	<b>73°F* (23°C) NEAT</b> - 480 (3.3) 2,200 (15.2) 3,400 (23.4) 3,400 (23.4) 3,400 (23.4)
How to Use					
Surface Preparation		clean and sound. It may mpounds, impregnations			Remove dust, laitance,
	Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free				
	open textured surface (CSP 3-4 as per ICRI) by blast cleaning or equivalent mechanical means. <b>Steel</b> - Should be cleaned and prepared thoroughly by blast cleaning to white metal finish.				
Mixing	Proportion equal parts by volume of Component 'A' and 'B' into clean pail. Mix thoroughly for 3 min. with Sika paddl on low-speed (400-600 rpm) drill until uniformly blended. Mix only that quantity that can be used within pot life.				
	<b>To prepare epoxy mortar -</b> Slowly add 5 parts by loose volume of oven-dried sand to 1 part of mixed Sikadur <sup>6</sup> 22 Lo-Mod until uniform in consistency.				
Application	mixed Sikadur <sup>®</sup> 2 aggregate slowly to excess at a rate	ay - Prime the prepared s 2 Lo-Mod with a 3/16 in. I allowing it to settle in the e of 2 lbs./ft <sup>2</sup> Remove exc cast overlay applications.	notched squeegee. epoxy binder. Ultima ess broadcast aggre	When material levels, brately the broadcast aggre	roadcast the oven-dried egate should be applied
	primer is still tack	Prime prepared substrate (y, apply epoxy mortar by using the 22 Lo Mod as	y trowel or vibrating		
Limitations	<ul> <li>For on grade, moisture limita</li> <li>Minimum age</li> <li>Do not use on</li> <li>Maximum thicl</li> <li>Do not dilute. A</li> <li>Use oven-dried</li> <li>Material is a value</li> </ul>	trate and ambient tempe split-slab and unvented n tions. of concrete before applic exterior slab on grade. kness 1/2 in. (13 mm) ext Addition of solvents will p d aggregates only. apor barrier after cure. tic product. Color may alt	netal pan deck, plea ation is 21-28 days terior exposed to the revent proper cure.	depending upon curing ermal change.	and drying conditions.

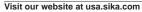
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# Sikadur<sup>®</sup> Epoxy Broadcast Overlay System

F S S C M N F T C C T	resin binder for a trai by the broadcast me The Sikadur Epoxy E Epoxy Broadcast ove conforms to the curre Use for exterior, abor requiring a protective mance. Typical Data [Mate RESULTS MAY DIFFER BASE] TEMPERATURE, APPLICATION Shelf Life Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile	Broadcast Overlay System uses Sikadur 22 Lo-Mod as the binder coat. Soverlay System can be used with and without a primer as needed. The system tASTM C-881 and AASHTO M-235 specifications.         Dove grade, i.e., bridge decks, parking structures, ramps and interior applitive, abrasion- and skid-resistant overlay with long-term durability and performent and curing conditions @ 73°F (23°C) and 50% R.H.J         Eerial and curing conditions @ 73°F (23°C) and 50% R.H.J         Ee upon statisticAL variations depending upon mixing methods and equipment, on methods, test methods, actual site conditions and curing conditions.         2 years in original, unopened containers.         Store dry at 40°-95°F (4-35°C). Condition material to 65°-85°F (18-29 before using.         Clear, light amber.         Component 'A': Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.       90°F (32°C): 2 hrs.         Light foot traffic: 4-6 hrs. Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
7 5 5 5 6 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	Use for exterior, abo requiring a protective mance. Typical Data [Mate RESULTS MAY DIFFER BASE] TEMPERATURE, APPLICATIO Shelf Life Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	ove grade, i.e., bridge decks, parking structures, ramps and interior applive, abrasion- and skid-resistant overlay with long-term durability and performance of the period statistical variations of the period statistical variations depending upon Mixing METHODS and Equipment, on METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         2 years in original, unopened containers.         Store dry at 40°-95°F (4-35°C). Condition material to 65°-85°F (18-29 before using.         Clear, light amber.         Component 'A': Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.         90°F (32°C): 2 hrs.         Light foot traffic: 4-6 hrs. Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
F S S C M N F T C C T	RESULTS MAY DIFFER BASE TEMPERATURE, APPLICATIO Shelf Life Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	ED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, ON METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         2 years in original, unopened containers.         Store dry at 40°-95°F (4-35°C). Condition material to 65°-85°F (18-29 before using.         Clear, light amber.         Component 'A' : Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.         Jight foot traffic: 4-6 hrs.         Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
S C M V F T C C T	Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	Store dry at 40°-95°F (4-35°C). Condition material to 65°-85°F (18-29)         before using.         Clear, light amber.         Component 'A' : Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.         Jight foot traffic: 4-6 hrs.       Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
S C M V F T C C T	Storage Conditions Color Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	Store dry at 40°-95°F (4-35°C). Condition material to 65°-85°F (18-29)         before using.         Clear, light amber.         Component 'A' : Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.         Jight foot traffic: 4-6 hrs.       Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
M F T C T	Mixing Ratio Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	Clear, light amber.         Component 'A' : Component 'B' 1:1 by volume.         Approximately 2,500 cps.         Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.         90°F (32°C): 2 hrs.         Light foot traffic: 4-6 hrs.         Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)         Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
V F T C T	Viscosity (Mixed) Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	Approximately 2,500 cps.Approximately 30 minutes (200 gram mass)40°F (4°C): 21 hrs.73°F (23°C): 4 hrs.90°F (32°C): 2 hrs.Light foot traffic: 4-6 hrs.Rubber-wheel traffic: 8-10 hrs.ASTM D-638)Broadcast 1:2.25e Strength2,200 psi (15.2 MPa)ution at Break1.1%
F T C T	Pot Life Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	Approximately 30 minutes (200 gram mass)         40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.       90°F (32°C): 2 hrs.         Light foot traffic: 4-6 hrs.       Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
T C T	Tack-Free Time Open Time Tensile Properties (As 14 day Tensile Elongat	40°F (4°C): 21 hrs.       73°F (23°C): 4 hrs.       90°F (32°C): 2 hrs.         Light foot traffic: 4-6 hrs.       Rubber-wheel traffic: 8-10 hrs.         ASTM D-638)       Broadcast 1:2.25         e Strength       2,200 psi (15.2 MPa)         ation at Break       1.1%
C T F	Open Time Tensile Properties (A 14 day Tensile Elongat	Light foot traffic: 4-6 hrs. Rubber-wheel traffic: 8-10 hrs.ASTM D-638)Broadcast 1:2.25e Strength2,200 psi (15.2 MPa)ution at Break1.1%
F	Tensile Properties (A 14 day Tensile Elongat	ASTM D-638) Broadcast 1:2.25 e Strength 2,200 psi (15.2 MPa) 1.1%
F	14 day Tensile Elongat	Strength2,200 psi (15.2 MPa)ation at Break1.1%
	modulu	us of Elasticity 4.7 x 10 <sup>5</sup> psi (3,240 MPa)
	Flexural Properties (A	
S	14 day Flexura	al Strength (Modulus of Rupture)4,300 psi (29.7 MPa)nt Modulus of Elasticity in Bending9.0 x 105 psi (6,205 MPa)
	Shear Strength (AST	<b>M D-732)14 day</b> 3,300 psi (22.7 MPa)
E	2 day (dry cure)	M C-882): Hardened Concrete to Hardened ConcreteBond Strength1,100 psi (7.5 MPa)re)Bond Strength1,600 psi (11 MPa)
ŀ		<b>ader)</b> (H-22 wheel; 1,000 gm weight) t loss, 1,000 cycles 1.61 gm
	Compressive Propert Compressive Strengt	th, psi
	40°F* (2 8 hour - 16 hour - 1 day 60 (0.4) 3 day 1,700 (1 7 day 6,700 (2 14 day 8,400 (5 28 day 8,450 (5) Compressive Modulu	70 (0.48) $3,500$ (24.1)1,850 (12.8) $4.400$ (30.3)3,150 (21.7) $4,600$ (31.7)(11.7) $6,900$ (47.6) $5,000$ (34.5)(46.2) $7,500$ (51.7) $5,400$ (37.2)(58.0) $7,800$ (53.8) $5,900$ (40.7)(58.3) $7,850$ (54.1) $6,300$ (43.4) <b>T day:</b> $1.25 \times 10^5$ psi (862 MPa) <b>28 day:</b> $1.66 \times 10^5$ psi (1,145)
*	Material cured and tested at the	ne temperatures indicated.

Advantages	<ul> <li>System is moisture-tolerant before, during, and after cure.</li> <li>Excellent adhesive properties to most substrates.</li> <li>Convenient, easy mix ratio A:B = 1:1 by volume.</li> <li>Superior, long-term abrasion resistance and durability even at elevated temperatures.</li> <li>Easy care, skid-resistant overlay for bridge decks, parking structures, ramps, loading docks, indu trial floors, etc.</li> </ul>				
Coverage	Prime coat: approximately 200-250 sq. ft./gal. Binder coat: approximately 32 sq. ft./gal. (50 mils) Broadcast aggregate: 2 lb./sq. ft. to excess. Seal coat: approximately 150-200 sq. ft. /gal.				
Packaging	Sikadur 22 Lo-Mod 4-gal. units.				
How to Use Surface Preparatio	Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles and disinte- grated materials. <b>Preparation Work: Concrete -</b> Sandblast or use other approved mechanical means. <b>Steel -</b> Should be cleaned and prepared thoroughly by blast cleaning.				
Mixing	<b>Pre-mix each component.</b> Proportion equal parts by volume of Components 'A' and 'B' into a clear mixing container. Mix with a low-speed (400-600 rpm) drill and Sika paddle for 3 minutes, until uniform. Mix only that quantity that can be used within its pot life.				
Application	<b>Priming:</b> Use of primer is optional but highly recommended. Primer should be used where sealing of non-moving existing cracks is desired. Sikadur 21 Lo-Mod LV or Sikadur 22 Lo-Mod can be used as primer coats. Prime the prepared substrate with neat Sikadur 21, Lo-Mod LV or Sikadur 22 Lo-Mod using a roller or flat squeegee. Coverage should be approximately 200-250 sq. ft./gal. While the primer is still tacky, apply the binder material with a 3/16 in. notched-rubber squeegee. Allow the binder to self-level.				
	Cracks: Static (non-moving) cracks ≤1/8 in., gravity feed with an appropriate sealer/healer materia Dynamic cracks ≥1/8 in. should be treated as joints and sealed with an appropriate joint sealer. Broadcast: Slowly broadcast an oven-dried sand so that the sand falls vertically into the binder (a a rate of 2 lbs./sf). Other sources of aggregate may be used but must conform to the minimum gradation standard. Continue to broadcast lightly making several passes, allowing the binder to bleed through the sand before making next pass. Cover completely with sand before binder becomes tack-free.				
	Typical gradation:         Mesh         16         20         30         40         50         70           %         0-5         35-50         40-55         3.0-8.0         ≥1         ≥.75				
	Hardness: Mohs scale, min. ≥ 6 After broadcast system has reached sufficient cure as not to be damaged, remove excess sand (this will be dependent on material, air and substrate temperatures). After all excess sand has been removed apply a seal coat of neat Sikadur 22, Lo Mod** over the entire area. Care should be exercised to eliminate voids or bare spots. Sealer coat of Sikadur 22, Lo Mod may be applied at recommended coverage of 150-200 sq. ft./gal.) or to desired finish. Unless otherwise specified, a seal coat is optional, especially on surfaces where a reduction in skid resistance is not optimal (i.e bridge decks, ramps). **Aliphatic urethanes or other compatible sealer coats may be used. Please contact Sika's Technical Service Department before use.				
	When applying multiple courses: The subsequent binder coat is applied to the preceding course after it has reached sufficient cure, so as not to be damaged and the excess broadcast aggregate he been removed. Note that the consumption and coverage rate of the additional binder coat will vary depending upon the type, size and gradation of the aggregate being used. A reduction factor of approximately 10-20% is customary.				
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% an substrate temperature must be at least 5°F (3°C) above measured dew point temperature.</li> <li>For on grade, split-slab and unvented metal pan deck, please consult Sika Technical Service regarding moisture limitations.</li> <li>Minimum substrate and ambient temperature 40°F (4°C).</li> <li>Do not store materials outdoors exposed to sunlight for prolonged periods.</li> </ul>				
	<ul> <li>Use properly graded, oven dried aggregates only.</li> <li>Do not apply over wet, glistening surface.</li> <li>Material is a vapor barrier after cure.</li> <li>Minimum age of concrete prior to application is 21-28 days, depending on curing and drying contions.</li> </ul>				
	<ul> <li>Do not apply to exterior, on-grade substrates, unvented metal pan decks, split/sandwich slabs, o buried membrane conditions.</li> <li>Use oven-dried aggregate only.</li> <li>Do not thin with solvents.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>				
	Any repairs required to achieve a level surface must be performed prior to application (consult a lor to EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AL STRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DA				
SHI PAI TO	EET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE I RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATI READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CU NT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.				

Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.

- Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not
  proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate
  to dry after rain or inclement weather as there is the potential for bonding problems.
- When applying over existing coatings, compatibility and adhesion testing is recommended.
- Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.
- Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.

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C.P. 76920

Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

Carretera Libre Celaya Km. 8.5

Visit our website at usa.sika.com

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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# Sikadur<sup>®</sup> 22 Lo-Mod FS

Low-modulus, fast setting, medium-viscosity, epoxy resin binder

Description		FS is a 2-component, 1 ent ASTM C-881 and AA			epoxy resin binder. It
Where to Use		er resin for a skid-resis or patching and overlay		ay. Use also as the l	binder resin for epoxy
Advantages	<ul> <li>Fast Setting for quick turn around.</li> <li>Meets 3 hr/1000 psi requirement when mixed as an epoxy mortar.</li> <li>Tolerant to moisture both before and after cure.</li> <li>Convenient easy mix ratio A:B = 1:1 by volume.</li> <li>Excellent strength development.</li> <li>Leveling viscosity for easy, efficient application of a broadcast overlay.</li> <li>Successfully used in HFST applications. Refer to local DOT specs. for product acceptance.</li> </ul>				
Coverage	1 gal. yields 231 in <sup>3</sup>				
		. of mixed Sikadur <sup>®</sup> 22 L proximately 808 cu. in. c		ddition of 5 gal. by loo	ose volume of an oven
Cure Mechanism	Chemical.				
Packaging		allon unit / 660 gallon to r <b>21 Lo-Mod LV is a un</b>			
How to Use					
	Typical Data (Mat	erial and curing condi	tions @ 73°F (23°C	and 50% R.H.1	
	RESULTS MAY DIFFER BAS	ED UPON STATISTICAL VAR	IATIONS DEPENDING UPO	ON MIXING METHODS AND	
	Shelf Life Storage Conditions Condition material Color Mixing Ratio	2 years in original, un Store dry at 40°-95°F ( 65°-85°F (18°-29°C) bu Clear to light amber. Component 'A':Compo	4°-35°C). efore using.	ume.	
	VOC:	<20 g/L			
	Viscosity	Approximately 2,000	cps.		
	Pot Life	Approximately 15-20	minutes (60 gram ma	ass; ASTM C881).	
	Tack-Free Time		<b>40°F (4°C)</b> 150 min.	<b>73°F (23°C)</b> 85 min.	<b>90°F (32°C)</b> 75 min.
	Traffic Time		8 hours	3 hours	2 hours
	Tensile Properties (A 7 day Tensile Stre Elongation at Bre	ength, psi	<b>Mortar 1:3</b> 1200 40%	<b>Neat</b> 2650 55%	
	Shear Strength (AST 7 day Shear Stre		2600	3430	
	Water Absorption (A) 7 day (24 hour im			<0.20%	
	Abrasion (Taber Abra 14 day Weight loss, (H-22 wheel; 1,000 gr C-17 wheel, 1,000 gr	1,000 cycles, grams m weight for mortar/	2.0	0.030	
	Hardness (ASTM D-2	240: Shore D)		72	
	Rapid Chloride Perme	ability (AASHTO T-277)		0 coulombs	
	Direct Pull Off Bond (ASTM C1583; ACI 50				
	1 day 7 day			>550 psi (concr	,
	RIOR TO EACH USE OF A ISTRUCTIONS ON THE PR HEET WHICH ARE AVAILA ARTMENT AT 800.933.7452	ODUCT'S MOST CURREN BLE ONLINE AT HTTP://U	NT PRODUCT DATA S ISA.SIKA.COM/ OR BY	HEET, PRODUCT LAB CALLING SIKA'S TEC	THE WARNINGS AND EL AND SAFETY DATA CHNICAL SERVICE DE-
	O READ AND FOLLOW THE		UCTIONS FOR EACH	SIKA PRODUCT AS SE	T FORTH IN THE CUR-

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

	Thermal Compatibility (ASTM C884)		Pass		
	Compressive Strength (ASTM C-579), p				
	3 hour	40°F* (4°C)	<b>73°F * (23°C)</b> 1750 psi	<b>90°F* (32°C)</b> 3600 psi	
	8 hour	- 2000 psi	4400 psi	6400 psi	
	1 day	4500 psi	6500 psi	8000 psi	
	3 day	5500 psi	7500 psi	8500 psi	
	7 day	8500 psi	8500 psi	9000 psi	
	14 day	9000 psi	9000 psi	9000 psi	
	28 day	9000 psi	9000 psi	9000 psi	
	Compressive Modulus				
	7 day		40,000 psi		
	28 day		40,000 psi		
	* Material cured and tested at the temp	eratures indicated.	10,000 poi		
Surface Preparation	Surface must be clean and sound. It may grease, curing compounds, impregnations			emove dust, laitance,	
	Preparation Work: Concrete - Should be open textured surface by blast cleaning o			and contaminant free,	
	Steel - Should be cleaned and prepared thoroughly by blast cleaning to white metal finish.				
Mixing	Mixing Pre-mix each component. Proportion equal parts by volume of Component 'A' and 'B' into clean pail. I thoroughly for 3 min. with Sika paddle on low-speed (400-600 rpm) drill until uniformly blended. Mix only that quan that can be used within pot life.				
	To prepare epoxy mortar - Slowly add 5 parts by loose volume of oven-dried sand to 1 part mixed				
Application	plication Broadcast Overlay - Prime the prepared substrate with is still tacky, spread mixed Sikadur 22 Lo-Mod FS with a terial levels, broadcast the oven-dried aggregate slowly a er. Ultimately the broadcast aggregate should be applied			ueegee. When ma- in the epoxy bind-	
	Remove excess broadcast aggregate after epoxy has set. Priming is an optional step in the broadcast overlay applications.				
	<b>Epoxy Mortar -</b> Prime prepared substrate epoxy mortar by trowel or vibrating screed 22 Lo Mod FS as an epoxy mortar.				
Limitations	<ul> <li>Minimum substrate and ambient temper</li> <li>Minimum age of concrete before applid</li> <li>For on grade, split-slab and unvented remoisture limitations.</li> <li>Maximum thickness 1/2 in. (13 mm) ex</li> <li>Do not dilute. Addition of solvents will p</li> <li>Use oven-dried aggregates only.</li> <li>Material is a vapor barrier after cure.</li> <li>Not an aesthetic product. Color may al</li> <li>For HFST applications, system and aption.</li> </ul>	cation is 21-28 days deper metal pan deck, please co sterior exposed to thermal prevent proper cure. ter due to variations in ligh	nsult Sika Technical change. nting and/or UV expo	Service regarding	
INS SH PAI TO RE KEEP For f actua befo Data ment for e: prod SIKA	OR TO EACH USE OF ANY SIKA PRODUCT, TRUCTIONS ON THE PRODUCT'S MOST CUE EET WHICH ARE AVAILABLE ONLINE AT HTTI RTMENT AT 800.933.7452 NOTHING CONTAINE READ AND FOLLOW THE WARNINGS AND IN NT PRODUCT DATA SHEET, PRODUCT LABEL CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDRE urther information and advice regarding transportation al Safety Data Sheets containing physical, ecological, to re using the product. In case of emergency, call CHEM to each use of any Sika product, the user must always is Sheet, product label and Safety Data Sheet which are a at 800-933-7452. Nothing contained in any Sika materia ach Sika product as set forth in the current Product Da uct use. warrants this product for one year from date of install urrent Product Data Sheet if used as directed within she	RENT PRODUCT DATA SH P://USA.SIKA.COM/ OR BY ( DIN ANY SIKA MATERIALS STRUCTIONS FOR EACH SI AND SAFETY DATA SHEET N. NOT FOR INTERNAL CONSUMPTION on, handling, storage and dispos oxicological and other safety rela TREC at 1-800-424-9300, Internal read and follow the warnings and available online at http://usa.sika als relieves the user of the obliga ata Sheet, product label and Safe ation to be free from manufactur	EET, PRODUCT LABE CALLING SIKA'S TEC RELIEVES THE USEF KA PRODUCT AS SE PRIOR TO PRODUCT FOR INDUSTRIAL USE ONLY. F al of chemical products, ted data. Read the currer tional 703-527-3887. Instructions on the prod .com/ or by calling Sika's tion to read and follow the ty Data Sheet prior to ing defects and to meet t	EL AND SAFETY DATA HNICAL SERVICE DE- ROF THE OBLIGATION T FORTH IN THE CUR- USE. FOR PROFESSIONAL USE ONLY. USERS should refer to the at actual Safety Data Sheet uct's most current Product Technical Service Depart- e warnings and instruction the technical properties on	
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**Product Data Sheet** Edition 2.2.2016 Sikadur<sup>®</sup> 25 Lo-Mod

## Sikadur<sup>°</sup> 25 Lo-Mod

Description				moisture-tolerant, low v e III, Grade 1, Class-C spe	/iscosity, epoxy-urethane resin cifications.
Where to Use				roadcast overlay or high ortar and concrete for pa	n friction surface on bridges or atching and overlays.
Advantages	<ul> <li>Tolerant to moist</li> <li>Convenient easy</li> <li>Excellent strengt</li> <li>Leveling viscosit</li> <li>Material is USDA</li> </ul>	mix ratio A:B = 1:1 h development. y for easy, efficier	by volume.	of a broadcast overlay.	
Coverage	1 gal. yields 231 cu. in. Mortar Binder - 1 gal. of mixed Sikadur 25 Lo-Mod with the addition of 5 gal. by loose volume of an ovend sand, yields approximately 808 cu. in. of epoxy mortar.			y loose volume of an ovendried	
Packaging	4 gallon units				
		2 years in origina Store dry at 40°-9 65°-85°F (18°-29° Clear to light aml Component 'A':Co <50gm/L Approximately 1,9	AL VARIATIONS E METHODS, ACTU 5°F (4°-35°C). C) before using. Der. Der. Dimponent 'B' =	EPENDING UPON MIXING ME AL SITE CONDITIONS AND Cl tainers.	JRING CONDITIONS.
	Traffic Time	24 hours	2.5 hours		
		<b>M D-638)</b> e Strength ation at Break			<b>Neat</b> 3000 psi (20.7MPa) >30%
	Water Absorption (AST 7 day (24 ho	<b>M D-570)</b> ur immersion)			<b>Neat</b> <0.20 %
	Abrasion (Taber Abrado 14 day Weigh	e <b>r)</b> t loss, 1,000 cycles	<b>Mortar</b> 2.0 gm H-22 w	<b>1:3</b> heel; 1,000 gm weight	<b>Neat</b> .030 gm C-17 wheel; 1,000 gm weight
	Hardness (ASTM D-224	0)			Neat 72
	Chloride Permeability		0 coulo	mbs	
	Direct Pull Off Bond Test 1 Day	(ASTM C1583; ACI 5		<b>1:3</b> si (concrete failure)	
	Thermal Compatibility	(ASTM C884)		Pass	



CONST

	Compressive Properties (ASTM D-695)	Mortar 1:3		
	Compressive Strength, psi (MPa)	40°F* (4°C)	73°F * (23°C)	90°F* (32°C)
	3 hour	2 0 0 0	800	3,600
	8 hour	2,000	2,000	6,400
	1 day	4,500	5,000	8,000 8,500
	3 day 7 day	5,500 8,500	7,500 8,500	9,000
	14 day	9,000	9,000	9,000
	28 day	9,000	9,000	9,000
	Compressive Modulus	3,000	3,000	5,000
	<b>7 day</b> 40,000 psi			
	<b>28 day</b> 40,000 psi * Material cured and tested at the temperatures indicated	L		
How to Use				
Surface Preparat	Surface must be clean and sound. It m grease, curing compounds, impregna Preparation Work: Concrete - Should open textured surface by blastcleaning prepared thoroughly by blastcleaning	tions, waxes and an be cleaned and pre ng or equivalent m	ny other contaminants pared to achieve a lait echanical means. <b>Ste</b>	s. ance and contaminant fre <b>el -</b> Should be cleaned a
Mixing	Pre-mix each component. Take care a			
	equal parts by volume of Component on low-speed (400-600 rpm) drill unt pot life. <b>To prepare epoxy mortar -</b> Sic Sikadur 22 Lo-Mod until uniform in co	'A' and 'B' into clea il uniformly blende owly add 5 parts by l	n pail. Mix thoroughly d. Mix only that quan	for 3 min. with Sika pade tity that can be used with
Application	Broadcast Overlay- Prime the prepa spread mixed Sikadur 25 Lo-Mod wit oven-dried aggregate slowly allowing should be applied to excess at a rate set. Priming is an optional step in the	h a 3/16 in. notcheo g it to settle in the e of 2 lbs./sq. ft. Rem	d squeegee. When ma poxy binder. Ultimate nove excess broadcast	aterial levels, broadcast t ly the broadcast aggrega
	<b>Epoxy Mortar -</b> Prime prepared subst epoxy mortar by trowel or vibrating so the Sikadur 25 Lo Mod as an epoxy m	rate with mixed Sik creed. Finish with fi	adur 25 Lo-Mod. Whi	
Limitations	<ul> <li>Minimum substrate and ambier</li> <li>For on grade, split-slab and unvermoisture limitations.</li> <li>Minimum age of concrete before conditions.</li> <li>Do not use on exterior slab on graMaximum thickness 1/2 in. (13 mr Do not dilute. Addition of solvent</li> <li>Use oven-dried aggregates only.</li> <li>Material is a vapor barrier after cu</li> <li>Not an aesthetic product. Color material solvent.</li> </ul>	nted metal pan deck application is 21-28 de. n) exterior exposed s will prevent prope rre.	k, please consult Sika days depending upon to thermal change. r cure.	curing and drying
	PRIOR TO EACH USE OF ANY SIKA PRODUC INSTRUCTIONS ON THE PRODUCT'S MOST C SHEET WHICH ARE AVAILABLE ONLINE AT H PARTMENT AT 800.933.7452 NOTHING CONTAI TO READ AND FOLLOW THE WARNINGS AND RENT PRODUCT DATA SHEET, PRODUCT LAB	URRENT PRODUCT I ITP://USA.SIKA.COM NED IN ANY SIKA MA INSTRUCTIONS FOR	DATA SHEET, PRODUC / OR BY CALLING SIKA TERIALS RELIEVES THI EACH SIKA PRODUCT	T LABEL AND SAFETY DA 'S TECHNICAL SERVICE D E USER OF THE OBLIGATIC AS SET FORTH IN THE CU
	KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHIL	DREN. NOT FOR INTERNAL CO	INSUMPTION. FOR INDUSTRIAL U	SE ONLY. FOR PROFESSIONAL USE ON
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## Sikadur<sup>®</sup> Balcony System

Description	slip resistant, seamle Balcony System use and Sikalastic 748 P	ess, protective of s Sikadur 21, Lo A as the sealer he Sikadur Balo	overlay system, ap o-Mod LV as the p coat. The Sikadu	oplied by th orimer, Sika r Balcony S	Ivent free epoxy resin binder for e broadcast method. The Sikadur adur 22, Lo-Mod as the binder coat, system can be used with or without current ASTM C-881 and AASHTO
		FER BASED UPON S	TATISTICAL VARIATION	NS DEPENDING	and 100% R.H.J 3 UPON MIXING METHODS AND EQUIPMENT, ONDITIONS AND CURING CONDITIONS.
	Shelf Life		inal, unopened co		
	Storage Conditions	Store dry at 40 before using.		. Conditio	n material to 65°-85°F (18°-2°9C)
	Color	Depends on a	ggregate selectio	n.	
	Mixing Ratios	Component 'A Sikadur 22, Lo	': Component 'B' o-Mod; Sikalastic	1:1 by volu 748 PA.	me for Sikadur 21, Lo-Mod LV and
		;	Sikadur 21, Lo-M		Sikadur 22, Lo-Mod
	Viscosity (Mixed)		1,000 cp		2,500 cps
	Pot Life (200 g mass)		25 min.		30 min.
	Tack-Free Time		3 hrs.		4 hrs.
	Open Time		•		r final sealer coat.
	Compressive propert Compressive Strengt		22 (ASTM D-695 Broadcast (1:2.2		
	compressive otrengt	40°F* (4°C)	73°F* (23°C)	90°F* (32	°C)
	8 hour	-	70 (0.48)	3,500 (24	,
	16 hour	-	1,850 (12.8)	4,400 (30	
	1 day 3 day	60 (0.41) 1,700 (11.7)	3,150 (21.7) 6,900 (47.6)	4,600 (31 5,000 (34	,
	7 day	6,700 (46.2)	7,500 (51.7)	5,400 (37	,
	14 day	8,400 (58.0)	7,800 (53.8)	5,900 (40	.7)
	28 day	8,450 (58.3)	7,850 (54.1)	6,300 (43	.4)
	*Material cured and tested at the Compressive Modulu Tensile Properties of	is 7 day: 1	.25 x 10⁵ psi (862		<b>28 day:</b> 1.66 x 10⁵ psi (1,145 MPa)
	14 day		Tensile Stre		2,200 psi (15.2 MPa)
			Elongation a Modulus of	at Break	1.1% 4.7 x 10⁵ psi (3,240 MPa)
	Flexural Properties o	f Sikadur 22. L	o-Mod (ASTM D-	790)	
			ulus of Rupture)		300 psi (29.7 MPa)
	Tangen	t Modulus of Ela	asticity in Bending	g 9.0	0 x 10⁵ psi(6,205 MPa)
	Shear Strength (AST	VI D-732) 14 da	у	3,3	300 psi (22.8 MPa)
	Bond Strength (ASTM 2 day (dry cure) 14 day (moist cure)		ned Concrete to 1,100 psi (7.5 MP 1,600 psi (11.0 M	Pa)	Concrete
	Abrasion (Taber Abra	der) (H-22 whe	el; 1,000 gm weig	ght)	
	14 day Weight	loss, 1,000 cycl	es 1.61 gm		
	Water Absorption Ne	•	))		
	<b>14 day</b> (24 hou	r immersion)	0.23%		
					AD AND FOLLOW THE WARNINGS AND I, PRODUCT LABEL AND SAFETY DATA
					LING SIKA'S TECHNICAL SERVICE DE-



Where to Use	Use for interior or exterior, above grade application requiring a protective, decorative, abrasion- and slip-resistant overlay with long-term durability and performance.
Advantages	<ul> <li>System is moisture tolerant before, during and after cure.</li> <li>Excellent adhesion to most substrates.</li> <li>Convenient, easy mix A:B 1:1 ratio by volume for Sikadur 21 Lo-Mod LV and Sikadur 22 Lo-Mod.</li> <li>Superior, long-term abrasion resistance and durability.</li> <li>Easy care, slip-resistant overlay for balconies.</li> <li>Can be combined with solid or blended colored aggregates for large color selection.</li> </ul>
Coverage	Prime coat: 200-250 sq. ft./gal. Binder coat: 80-100 sq. ft./gal. (15-20 mils). Broadcast aggregate: 0.5 lbs./sq. ft. Sealer coat: 65-75 sq. ft./gal. Allowance must be made for surface profile, unavoidable variations in application thickness, loss and waste.
Packaging	Sikadur 21, Lo-Mod LV - 4 gal. units. Sikadur 22, Lo-Mod - 4 gal. units. Sikalastic 748 PA - 4 gal. units.
How to Use Surface Preparat	<ul> <li>Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials or any bond breaking materials.</li> <li>Preparation Work: Concrete-Should be cleaned and prepared to achieve a laitance and contaminant-free, open textured surface by blastcleaning or equivalent mechanical means. All projections, rough spots, etc. should repaired to achieve a uniform surface prior to the application. Surface should be level for best cosmetic finish.</li> </ul>
Mixing	Sikadur 21 Lo-Mod LV & Sikadur 22 Lo-Mod: Pre-mix each component. Proportion equal parts by volume of Component 'A' and 'B' into a clean mixing container. Mix with a low-speed (400-600 rpm) drill and Sika paddle for 3 minutes, until uniform. Mix only that quantity that can be used within its pot life. Do not whip in air during mixing.
Application	Priming: Use of primer is optional but highly recommended. Primer should be used where sealing of non-moving existing cracks is desired.         Prime the prepared substrate with neat Sikadur 21, Lo-Mod LV, using a roller. Coverage should be 200-250 sq. ft./gal. While the primer is still tacky, apply the binder material with a roller to approximately 80-100 sq. ft./gal. (15-20 mils) or to desired thickness.         Cracks: Static (non-moving) cracks ≤1/8 in. wide gravity feed with an appropriate sealer healer material. Dynamic cracks ≥1/8 in. should be treated as joints and sealed with appropriate joint sealant.         Broadcast: Slowly broadcast oven-dried colored aggregate* so that the sand falls vertically and uniformly into the binder coat (at a rate of 0.5 lbs./sf). (Sources of aggregate must conform to Sika requirements for broadcast aggregate; please contact our Technical Service Department.) (Broadcast Quartz Blends from Sika can also be considered.) Continue to broadcast lightly mak-
	ing several passes, allowing the binder to bleed through the sand before making next pass. Cover completely with sand before binder becomes tack-free. *Typical Gradation Mesh 20 30 40 50 70 % 9 12.4 54 22 1.9 After broadcast system has reached sufficient cure as not to be damaged (this will be dependent on material, air, and substrate temperatures), remove excess sand. Seal Coat: After all excess sand has been removed apply a roller seal coat of Sikalastic 748 PA** over the entire area. Care should be exercised to eliminate voids or bare spots. Sealer coat of Sikalastic 748 PA may be applied at recommended coverage (75-125 sq. ft./gal.) or to desired finish; remove all excess with a clean, dry roller. Heavy seal coat will produce smoother but less slip resistant system. The type and size of the aggregate will influence the coverage. **Aliphatic urethanes or other compatible sealer coats may be used. Please contact Sika's Technical Service Department before use. Refer to the current Technical Data Sheet for Sikalastic 748 PA for additional application information.
Removal	Collect with absorbent material; flush area with water. Dispose of in accordance with current, appli- cable local, state and federal regulations. Uncured material can be removed with approved solvent. Cured material can only be removed mechanically.
Limitations	<ul> <li>Minimum substrate temperature for application is 40°F (4°C) and rising.</li> <li>Do not apply over wet or damp surfaces.</li> <li>Material is a vapor barrier after cure.</li> <li>Do not apply to porous surfaces exhibiting moisture-vapor transmission during the application. Consult Technical Service.</li> <li>Minimum age of concrete prior to application is 21-28 days, depending on curing and drying conditions.</li> <li>Refer to the current individual product Technical Data Sheets for Sikadur 21, Lo-Mod LV, Sikadur 22 Lo-Mod and Sikalastic 748 PA for application and use warnings.</li> <li>Do not apply to exterior, on-grade substrates.</li> <li>Use oven-dried, broadcast aggregate only.</li> <li>Do not thin with solvents.</li> </ul>
ka	Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure. PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

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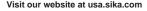
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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C450

## Sikagard<sup>®</sup> Duochem 7500

Chemical Resistant, Epoxy-Novolac Floor Coating, Topping or Containment Lining

	lining which possesses acid and oxygenated s	7500 is a two-component, h s outstanding resistance to s solvents.		
Where to Use	<ul> <li>As a smooth, cher</li> </ul>	mical-resistant lining on con	crete or steel substrates	s subject to concen
	trated acids.			
	Protection of conta	ainment tanks, machine bas	es, plant floors and wal	Is exposed to ag-
	gressive chemical	s.		
	<ul> <li>As a broadcast, but</li> </ul>	uild-up system to provide a	slip resistant and durab	le wearing surface
	in pedestrian area	is where aggressive chemic	als are present.	
dvantages	The material is co	nvenient to proportion, 2:1 b	v volume. Component	A to Component B
a. a. a. a. gee	ratio.		, , , , , , , , , , , , , , , , , , ,	
		em 7500 may be applied as	a smooth system or as	a broadcast build-
		prating silica sand.		
		em 7500 provides a high bui	Id and effective barrier	of protection for
		against a wide range of ag		
		em 7500 exhibits excellent A		rasion Resistance.
	and Compressive			
		ide excellent protection for s	steel and concrete agair	nst a wide range of
		oduct specific Chemical Re		•
		a Technical Services.		
ackaging	3 gal. (11.34 l) unit			
	<b>3</b> ( )			
overage	106 ft²/gal. (2.6 m²/l) fo	or neat application; 80 ft²/ga	I. (2 m <sup>2</sup> /l) for broadcast	application
		al and curing conditions @ 7		
		METHODS, ACTUAL SITE CONDITIONS AND		MENT, TEMPERATURE, (
	Packaging	3 US gal. (11.34 L) units		
	Color	RAL 7046 Tele Grey, RAL 3	009 Oxide Red, Clear	
	Yield Concrete Substra			
	Primer Coat	Sikadur <sup>®</sup> WDE Primer	160 ft²/US gal. (4 m²/L)	10 mils w.f.t.
	1st Coat	Sikagard <sup>®</sup> Duochem 7500	106 ft²/US gal. (2.6 m²/L)	15 mils w.f.t.
	2nd Coat	Sikagard <sup>®</sup> Duochem 7500	106 ft²/US gal. (2.6 m²/L)	15 mils w.f.t.
	Maximum build per co	at for Sikagard <sup>®</sup> Duochem 7500 o	n vertical surfaces:	
	7 mils w.f.t. Three coats	may be required for the smooth coa	ating to be produced vertically.	
	Broadcast Build-Up Sy	vstem		
	Primer Coat	Sikadur <sup>®</sup> WDE Primer	160 ft²/US gal. (4 m²/L)	10 mils w.f.t.
	Broadcast Coat	Sikagard <sup>®</sup> Duochem 7500	80 ft²/US gal. (2 m²/L)	20 mils w.f.t.
	Aggregate	Oven dried silica sand	0.6 - 1 lb/ft <sup>2</sup>	
		#32 mesh (spherical)	(3 - 5 kg/m²)	
		0.3 - 0.85 mm		
		or #16 mesh (angular)		
		0.6 - 2.0 mm		
	Top Coat	Sikagard <sup>®</sup> Duochem	7500 80 - 106 ft <sup>2</sup> /U	S gal.
		Colored or Clear	(2 - 2.6 m²/L)	
			15 - 20 mils w.f.t.	
	Steel Substrates Smoo	•		
	1st Coat	Sikagard <sup>®</sup> Duochem 7500	106 ft²/US gal. (2.6 m²/L)	15 mils w.f.t.
	2nd Coat	Sikagard <sup>®</sup> Duochem 7500	106 ft²/US gal. (2.6 m²/L)	
		Colored or Clear	15 mils w.f.t.	
		at for Sikagard® Duochem 7500 of		
	/ mils. Inree coats may	be required for the smooth coating	inish to be produced vertically	/.
R F		SIKA PRODUCT, THE USER MUS		

TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



Broadcast Build-Up System						
Primer Coat	Sikagard <sup>®</sup> Du	ochem 7500	106 ft <sup>2</sup> /U	S gal. (2.6	m²/L)	15 mils w.f.t.
Broadcast Coat	Sikagard <sup>®</sup> Du	ochem 7500	80 ft²/US	5 gal. (2 m <sup>2</sup>	/L)	20 mils w.f.t.
Aggregate	Oven dried si	ilica sand	0.6 - 1 lb	/ft² (3 - 5 k	g/m²)	
	#32 mesh (sr	oherical)	0.3 - 0.8	5 mm		
	or #16 mesh	,	0.6 - 2.0			
Top Coat	Sikagard® Du				(2 - 2.6 m <sup>2</sup>	/L)
	Colored or Cl		15 - 20 n	0	(	
For Optimum Chemical Resis						
	uochem 7500	-	6 ft <sup>2</sup> /LIS a	al. (2.6 m²/	1)	
			mils w.f.t		L)	
Barrier Coat (Clear) Actual coverage rates and mater must be also made for variation white) or bright colors (ie reds a correct coverage.	in film thickne	tion will depend	upon por of coats re	osity and p quired to a	chieve opa	city with light (ie
Shelf Life	2 years when	stored in origir	nal, unope	ned packa	ging.	
Store	dry at 41 - 90	°F (5 - 32°C).		•		
Condition		een 65 - 86°F (	18 - 30°C)	before use	9.	
Mix Ratio	A:B= 2:1 by	volume				
Waiting Time Between Coats	at 23°C (73°F	) Minimum I	Dry to the	Touch	Maxim	um 24 hours
Properties at 25°C (77°F) Solids Content		,	,			
	By volume		ļ	Approx. 95	%	
	By weight			Approx. 96		
Pot Life	8.8 oz (250 g	)		Approx. 60		
Drying Times	0.0 02 (200 g	/				
	Foot traffic		1	1 day		
	Light traffic			2 days		
	Full chemical	resistance		7 days		
Drying times will vary according						
Properties at 28 days	,	SMOOTH CO			BROADC	AST SYSTEM*
Tensile Strength ASTM D638,	Type IV	2,960 psi (20.4	4 MPa)		1,595 psi (	11.0 MPa )
Elongation at Break ASTM De	•••	28%	,		8.4%	,
Compressive Strength ASTM		8,380 psi (57.	8 MPa)		3,435 psi (	23.7 MPa)
Water Absorption ASTM D570	)					
24 h		0.42%			0.11%	
7 days		1.02%			0.34%	
2 h boiling	water	-0.57%			-0.10%	
Bond Strength to Concrete A	STM D4541	406 psi (2.8 N	/IPa)		520 psi (3	.6 MPa )
		substrate failu	re		substrate f	ailure
Abrasion Resistance ASTM D	4060					
Taber Abraser, CS-17 and H-22	2 Wheels/	170 mg			833 mg **	
1000 g (2.2 lb)/1000 cycles		(CS-17)			(H-22)	
Impact Resistance ASTM D30	)29					
Microscopic cracks		51.3 lb/in ( 5.8	3 J)		15.2 lb/in (	1.5 J)
Major cracks		54.8 lb/in ( 6.2	2 J)		91.9 lb/in (	
Hardness (Shore D) ASTM D2	2240	67	,		72	,
Water Vapor Transmission AS						
(Water method)		nr/ft² (0.19 g/hr/i	m²) (	).00023 oz	./hr/ft² (0.07	7 a/hr/m²)
(**************************************	30 mils film		,	64 mils		9,
Water Permeance ASTM E96						
(Water method)	0.48 perm			0.12 pe	erm	
(11410) (1104)	30 mils film			64 mils		
Thermal Compatibility with C				••••••		
ASTM C884 (from -23 to 23°C		Substrate Fail	ure ***		Substrate	Failure ***
Static Coefficient of Friction	-	and a difference of the				
Dry surface		0.75			1.26	
Wet surface		0.75			0.94	
Linear Shrinkage ASTM C531		-			0.94	
Coefficient of Linear Thermal					0.20	
ASTM C531, in/in/°F		_			1.25 x 10-	5/°F
cm/cm/°C					2.26 x 10-	
*24 mesh silica sand used for b	roadcasting				2.20 × 10-	
	addadaning.					



\*\*Standard 4,060 psi (28 MPa) concrete exhibits 3,872 mg loss when tested as per this procedure.

\*\*\*Failure occurs in underlying concrete.



	How To Use	
	Surface Preparation	<b>Concrete:</b> Concrete substrates must be clean and sound. Remove any dust, laitance, grease, oil, dirt, curing agents, impregnations, wax, foreign matter, coatings and any loose particles from the surface by appropriate mechanical means, in order to achieve a profile equivalent to ICRI CSP 3-4. The compressive strength of the concrete substrate should be at least 3,500 psi (24 MPa) at 28 days and at least 215 psi (1.5 MPa) in tension at the time of application of Sikadur <sup>®</sup> WDE Primer & Sikagard <sup>®</sup> Duochem 7500.
		<b>Steel:</b> All steel to be coated must be dry, clean and stable before applying the primer or coating. Remove all existing treatments such as coatings, sealers, wax, and contaminants (i.e. dirt, dust, grease, oils, and foreign matter) which will interfere with the adhesion of Sikagard <sup>®</sup> Duochem 7500. Prepare steel substrates by appropriate mechanical means such as abrasive blast-cleaning. Achieve clean white metal profile equivalent to SSPC-SP10, Near White Metal, 2 to 4 mils anchor profile. Apply primer or coating immediately, before oxidation of the steel occurs.
	Mixing	Thoroughly pre-mix each component separately to ensure that all solids are distributed throughout and components are consistent within themselves. Empty the complete contents of Component B into the partially filled Component A container. When mixing a partial unit, ensure that the com- ponents are proportioned in the correct ratio and empty both into a suitably sized, clean mixing vessel.
		Mix the combined components for at least 3 minutes, using a low-speed drill (200-300 rpm) to minimize entrapping air. Use an Exomixer type or Jiffy mixing paddle (recommended model) suited to the volume of the mixing container. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once, to ensure complete mixing. When completely mixed, Sikagard <sup>®</sup> Duochem 7500 should be uniform in color and consistency. Mix only that quantity which can be used within its pot life.
		Never use a thickening agent such as Sikafloor® Extender T, Cabosil or any other filler to increase product viscosity as this will greatly reduce chemical resistance.
	Application	Concrete:
		Smooth Coating:
		Primer Coat: Apply Sikadur <sup>®</sup> WDE Primer onto prepped concrete substrates using a brush, roller or squeegee to a uniform coverage without ponding. Refer to the current product data sheet for Sikadur <sup>®</sup> WDE Primer for published recommendations and further information.
		1st Coat: Once the primer is tack free apply Sikagard <sup>®</sup> Duochem 7500 using a brush, roller or squeegee to a uniform coverage without ponding.
		2nd Coat: Once first coat is tack free, apply a second coat of Sikagard <sup>®</sup> Duochem 7500 using a brush, roller or squeegee to a uniform coverage without ponding.
		Broadcast Build-Up System:
		Primer Coat: Apply Sikadur <sup>®</sup> WDE Primer onto prepped concrete substrates using a brush, roller or squeegee to a uniform coverage without ponding. Refer to the current product data sheet for Sikadur <sup>®</sup> WDE Primer for published recommendations and further information.
		Broadcast Coat: Once the primer is tack free apply the broadcast coat of Sikagard <sup>®</sup> Duochem 7500 using a notched squeegee or trowel and backroll to a uniform coverage. Broadcast the selected sand (shape and size to be selected in accordance with required texture/slip resistance) into the wet resin to rejection.
		Top Coat: Once the broadcast coat has sufficiently cured to allow foot traffic, sweep-up and vacuum-off all loose, unbounded sand. Apply the top coat of Sikagard <sup>®</sup> Duochem 7500 using a squeegee, followed by back rolling to provide a uniform texture and finish.
		Steel: Priming, consolidation or sealing of common steel substrates with Sikadur <sup>®</sup> WDE Primer is not usually required under typical circumstances. However, due to variations in steel quality, surface condition, surface preparation and ambient conditions, reference test areas are recommended to determine whether priming is required to prevent the possibility of issues with adhesion, compatibility, or other defects. Consult Sika Technical Services for advice.
		Application of Sikagard <sup>®</sup> Duochem 7500 onto properly prepared steel surfaces is typically the same procedure as outlined above for smooth coatings and broadcast build-up systems onto concrete, excluding the use of Sikadur <sup>®</sup> WDE primer, unless determined otherwise.
		See Typical Data section of this product data sheet above for coverage rates, specific application thicknesses and number of coats recommended.
1	INST SHE PAR' TO F	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND IRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



### Limitations

- Sikagard<sup>®</sup> Duochem 7500, as a primary or secondary containment coating system, is best installed by skilled and experienced applicators. Consult Sika Technical Services for advice and recommendations.
- Not recommended for use on slab-on-grade concrete substrates.
- Minimum/Maximum substrate temperature; 59°F /86°F (15°C /30°C ).
- Observe minimum application temperature of 15°C (59°F) and product conditioning temperatures of 65° 86°F (18° 30°C) as high viscosity coatings exhibit reduced smoothing properties and greater tendency to display application marks at low temperatures.
- Substrate temperature must be at least 5.5°F (3°C) above the measured dew point.
- Moisture content of concrete substrates must be < 6% (Tramex CME/CMExpert type concrete moisture meter measurement) before application of Sikadur<sup>®</sup> WDE Primer other wise use Sikagard<sup>®</sup> 75 EpoCem as an initial barrier.
- Do not apply onto porous surfaces where moisture vapor transmission will occur during application.
- Maximum relative humidity during application and cure; 85%.
- Do not hand mix Sikagard<sup>®</sup> materials; mechanically mix only.
- Should maximum waiting time between coats be exceeded, abrade surface of applied material (removing all gloss) vacuum-off all dust and debris, and wipe with solvent. Allow solvent to completely flash off and dry before proceeding with subsequent coats.
- Protect from dampness, condensation and water contact during the initial 24 hour cure period (curing times will be lengthened at cold temperatures and protection should therefo remain for longer).
- Not recommended for areas subject to frequent thermal cycles.
- Surface may discolor in areas exposed to ultraviolet light.
- Not designed as an aesthetic product.

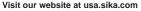
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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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C460



### Sikagard<sup>®</sup> Duochem 7500 Thixo

Chemical-Resistant, Epoxy-Novolac-Based and Textured Floor Coating

Where to Use Advantages	<ul> <li>Protection of cochemicals.</li> <li>Protection agai</li> <li>As a broadcast</li> </ul>	ontainment tanks, mach	n concrete or steel substrates subje ine bases, plant floors and walls e	
Advantages		, build-up system to pro re aggressive chemicals	nination resulting from uncontaine vide a slip resistant and durable w s are present.	d chemical spills.
Huvaniages	<ul> <li>Sikagard<sup>®</sup> Duod Compressive S</li> <li>Provides excell</li> </ul>	chem 7500 Thixo exhibitrength values.	n, 2:1 by volume, Component A to is excellent Adhesion, Hardness, A and concrete against a wide range	Abrasion Resistance, and
Coverage	106 ft²/gal. (2.6 m²/	)		
Packaging	3 gal. (11.34 l) unit			
Chemical Resistance	See Chemical Resi	stance Chart available a	at usa.sika.com or by contacting S	ika Technical Services
	RESULTS MAY DIFFER	BASED UPON STATISTICAL VARIA	nditions @ 73°F (22.7°C) and 50 and 50 and 50 and 50 conditions and curing conditions. 1.34L)	
	Color	RAL 7038 A		
		ubstrates Smooth Coatir		
	Primer Coat	Sikadur <sup>®</sup> WDE Primer	160 ft²/US gal. (4 m²/L)	10 mils w.f.t.
	1st Coat	Sikagard <sup>®</sup> Duochem 7500	• • • •	
	2nd coat	Sikagard <sup>®</sup> Duochem 750	0 106 ft²/US gal. (2.6 m²/L	) 15 mils w.f.t.
	Steel Floors 1st Coat	Sikagard® Duochem 750	0 106 ft2/US gal. (2.6 m2/L	.) 15 mils w.f.t.
	2nd Coat	Sikagard® Duochem 750	<b>e</b> (	
	must be also mad	le for variation in film thickn lors (ie reds and yellows) a	ation will depend upon porosity and pro- tess or number of coats required to ach and dark substrates. Test sections are r	nieve opacity with light (ie
	Shelf Life	2 years whe	n stored in original, unopened packagir	ıg.
	Store	-	0°F (5 - 32°C).	
	Condition Mix Ratio	product betv A:B= 2:1 by	veen 65 - 86°F (18 - 30°C) before use.	
		tween Coats@ 23°C (73°I		Maximum 24 hours
	Solids Content	By volume	Approx. 95 %	
	D. (1)	By weight	Approx. 96 %	
	Pot Life Drying Times	8.8 oz (250 g Foot traffic	g) Approx. 60 m 1 day	in
	Drying Times	Light traffic	2 days	
		Full chemica		
	Drying times will Properties at 28	, ,	bstrate temperature and humidity.	
	-	ASTM D638, Type IV	2,960 psi (20.4 MPa)	
	-	eak ASTM D638, Type IV	28% 8 380 pci (57 8 MPa)	
	Compressive St	rength ASTM D695	8,380 psi (57.8 MPa)	
			E USER MUST ALWAYS READ AND ENT PRODUCT DATA SHEET, PROD	

TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

	Water Absorption ASTM D570				
	24 h	0.42%			
	7 days	1.02%			
	2 h boiling water Bond Strength to Concrete ASTM D4 Abrasion Resistance ASTM D4060	-0.57% 541	406 psi (2.8 MPa )	substrate fa	ilure
	Taber Abraser, CS-17 and H-22 Wheels	3	170 mg 1000 g (2.2 lb)/1000	) cycles	(CS-17)
	Impact Resistance ASTM D3029 Microscopic cracks		51.3 lb/in ( 5.8 J)	,	· · · ·
	Major cracks Hardness (Shore D) ASTM D2240		54.8 lb/in ( 6.2 J) 67		
	Water Vapor Transmission ASTM E96 (Water method)	5	0.19 g/hr/m <sup>2</sup>	30 mils	film
	Water Permeance ASTM E96 (Water method)		0.48 perm	30 mils t	film
	Thermal Compatibility with Concrete ASTM C884 (from -9 to 73°F [-23 to 23	3°C])	Substrate Failure *		
	Static Coefficient of Friction ASTM C	1028	0.75		
	Dry surface Wet surface		0.75 0.55		
	*Failure occurs in underlying concrete. Product properties are typically average		er laboratory condition		
	expected on-site due to local factors, inc	cluding environm	ient, preparation, appl	ication, curi	ng and test methods.
How To Use					
Surface Preparation	Concrete: Concrete substrates must be agents, impregnations, wax, foreign ma mechanical means, in order to achieve concrete substrate should be at least 3, at the time of application of Sikadur <sup>®</sup> W	atter, coatings a profile equiv ,500 psi (24 Mi	and any loose partic alent to ICRI CSP 3 Pa) at 28 days and a	cles from tl -4. The co at least 21	he surface by appro mpressive strength 5 psi (1.5 MPa) in t
	Steel: All steel to be coated must be dr existing treatments such as coatings, sr matter) which will interfere with the adh appropriate mechanical means such as to SSPC-SP10, Near White Metal, 2 t oxidation of the steel occurs.	ealers, wax, ar nesion of Sikag s abrasive blas to 4 mils anch	nd contaminants (i.e. ard® Duochem 7500 t-cleaning. Achieve or profile. Apply pri	e. dirt, dust 0 Thixo. Pr clean whit mer or coa	, grease, oils, and f epare steel substra ie metal profile equ ating immediately,
Mixing	Thoroughly pre-mix each component throughout and components are consis			sure that a	all solids are disti
	Empty the complete contents of Compo partial unit, ensure that the component sized, clean mixing vessel.			•	
	Mix the combined components for at le trapping air. Use an Exomixer type or mixing container. During the mixing ope or straight edge trowel at least once, to e 7500 Thixo should be uniform in color a life.	Jiffy mixing pao eration, scrape ensure comple	ddle (recommendec e down the sides an te mixing. When cor	d model) so d bottom o mpletely m	uited to the volume of the container with ixed, Sikagard <sup>®</sup> Due
	Never use a thickening agent such as viscosity as this will greatly reduce che			any other	filler to increase p
Application	Concrete:				
	Primer Coat: Apply Sikadur <sup>®</sup> WDE Prim to a uniform coverage without ponding. published recommendations and furthe	. Refer to the c		0	· · ·
	<u>1st Coat</u> : Once the primer is tack free ap to a uniform coverage without ponding.		Duochem 7500 Thi	xo using a	brush, roller or squ
	2nd Coat: Once first coat is tack free, a roller or squeegee to a uniform coverage			Duochem 7	7500 Thixo using a
	<b>Steel:</b> Priming, consolidation or sealing required under typical circumstances. I preparation and ambient conditions, rel required to prevent the possibility of issu cal Services for advice.	However, due ference test ar	to variations in stee eas are recommend	el quality, s ded to dete	surface condition, s ermine whether prir

<ul> <li>See Typical Data section of this product data sheet above for coverage rates, specific application thickness and number of coats recommended.</li> <li>Initiations</li> <li>Not suitable for use on exterior, slab-on-grade concrete substrates.</li> <li>Minimum / Maximum substrate temperature; 60°F / 85°F (15°C / 30°C ).</li> <li>Observe minimum application temperature of 59°F (15°C) and product conditioning temperatures of 65° - 85°F (18° - 30°C) as high viscosity coatings exhibit reduced smoothing properties and greater tendency to display application marks at low temperatures.</li> <li>Substrate temperature must be at least 5.5°F (3°C) above the measured dew point.</li> </ul>	and number of coats recommended.  Not suitable for use on exterior, slab-on-grade concrete substrates.  Minimum / Maximum substrate temperature; 60°F / 85°F (15°C / 30°C ).  Observe minimum application temperature of 59°F (15°C) and product conditioning temperators 65° - 85°F (18° - 30°C) as high viscosity coatings exhibit reduced smoothing properties and		onto concrete, excluding the use of Sikadur <sup>®</sup> WDE primer, unless determined otherwise. Sir Duochem 7500 Thixo, is applied onto Sikagard <sup>®</sup> Duochem 7500 using the same technique producing a textured coating onto concrete substrates.	
<ul> <li>Minimum / Maximum substrate temperature; 60°F / 85°F (15°C / 30°C ).</li> <li>Observe minimum application temperature of 59°F (15°C) and product conditioning temperatures of 65° - 85°F (18° - 30°C) as high viscosity coatings exhibit reduced smoothing properties and greater tendency to display application marks at low temperatures.</li> </ul>	<ul> <li>Minimum / Maximum substrate temperature; 60°F / 85°F (15°C / 30°C ).</li> <li>Observe minimum application temperature of 59°F (15°C) and product conditioning temperature of 59°F (15°C) and product conditioning temperature of 50° - 85°F (18° - 30°C) as high viscosity coatings exhibit reduced smoothing properties and</li> </ul>	tion thicknesse		
<ul> <li>Moisture content of concrete substrates must be &lt; 6% (Tramex CME/CMExpert type concrete moistur meter measurement) before application of Sikadur®WDE Primer otherwise use Sikagard® 75 Epo-Cem as an initial barrier up to a maximum moisture content of 12%.</li> <li>Do not apply onto porous surfaces where moisture vapor transmission will occur during application.</li> <li>Maximum relative humidity during application and cure; 85%.</li> <li>Do not hand mix Sikagard® materials; mechanically mix only.</li> <li>Should maximum waiting time between coats be exceeded, abrade surface of applied material (remoing all gloss) vacuum-off all dust and debris, and wipe with solvent. Allow solvent to completely flash or and dry before proceeding with subsequent coats.</li> <li>Protect from dampness, condensation and water contact during the initial 24 hour cure period (curing times will be lengthened at cold temperatures and protection should therefore remain for longer).</li> <li>Not recommended for areas subject to frequent thermal cycles.</li> <li>Surface may discolor in areas exposed to ultraviolet light.</li> </ul>	<ul> <li>Substrate temperature must be at least 5.5°F (3°C) above the measured dew point.</li> <li>Moisture content of concrete substrates must be &lt; 6% (Tramex CME/CMExpert type concremeter measurement) before application of Sikadur®WDE Primer otherwise use Sikagard® 75 Cem as an initial barrier up to a maximum moisture content of 12%.</li> <li>Do not apply onto porous surfaces where moisture vapor transmission will occur during apple Maximum relative humidity during application and cure; 85%.</li> <li>Do not hand mix Sikagard® materials; mechanically mix only.</li> <li>Should maximum waiting time between coats be exceeded, abrade surface of applied materiang all gloss) vacuum-off all dust and debris, and wipe with solvent. Allow solvent to complete and dry before proceeding with subsequent coats.</li> <li>Protect from dampness, condensation and water contact during the initial 24 hour cure perior times will be lengthened at cold temperatures and protection should therefore remain for lor</li> <li>Not recommended for areas subject to frequent thermal cycles.</li> </ul>	and greater ncrete moistur d <sup>®</sup> 75 Epo- application. naterial (remov upletely flash of period (curing	<ul> <li>Minimum / Maximum substrate temperature; 60°F / 85°F (15°C / 30°C).</li> <li>Observe minimum application temperature of 59°F (15°C) and product conditioning ter 65° - 85°F (18° - 30°C) as high viscosity coatings exhibit reduced smoothing properties tendency to display application marks at low temperatures.</li> <li>Substrate temperature must be at least 5.5°F (3°C) above the measured dew point.</li> <li>Moisture content of concrete substrates must be &lt; 6% (Tramex CME/CMExpert type cometer measurement) before application of Sikadur®WDE Primer otherwise use Sikagar Cem as an initial barrier up to a maximum moisture content of 12%.</li> <li>Do not apply onto porous surfaces where moisture vapor transmission will occur during Maximum relative humidity during application and cure; 85%.</li> <li>Do not hand mix Sikagard® materials; mechanically mix only.</li> <li>Should maximum waiting time between coats be exceeded, abrade surface of applied r ing all gloss) vacuum-off all dust and debris, and wipe with solvent. Allow solvent to com and dry before proceeding with subsequent coats.</li> <li>Protect from dampness, condensation and water contact during the initial 24 hour cure times will be lengthened at cold temperatures and protection should therefore remain fe Not recommended for areas subject to frequent thermal cycles.</li> </ul>	imitations

Application of Sikagard® Duochem 7500 Thixo onto properly prepared steel surfaces is typically the same

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

> Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Construction

### Product Data Sheet Edition 10.30.2015 Sikadur WDE Primer

# Sikadur<sup>®</sup> WDE Primer

Moisture Intensive Epoxy Resin

Description	Sikadı	ur WDE Primer a two-compo		esin with excellent moi	sture-insensitive	
		cteristics and fast cure at low	viemperatures.			
Where to Use		ur WDE Primer is the primer so especially performing on	-			
Advantages	■ Ca ■ Ide	res down to 32°F (0°C). n be used in cold rooms. al for shutdown or fast turna od resistance to a wide vari		organic acids and alka	lis.	
How to Use						
Surface Preparation	bond i etc. sh be cle by she vacuu ensure be car rates o blast" streng	Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes and any other contaminants. All projections, rough etc. should be dressed off to achieve a level surface prior to the application. Concrete - Sh be cleaned and prepared to achieve a laitance and contaminant free, open textured s by shot blasting or equivalent mechnical means (CSP-3 as per ICRI guidelines). Sweep vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust wi ensure a tenacious bond between the primer and substrate. Whenever "shot-blasting" is ut be careful to leave concrete with a uniform texture. Over "blasting" will result in reduced cover rates of the primer and/or subsequent topcoats. It is also possible that the texture of the blast" pattern may show through the last coat. This is known as "tracking". The compressionation of the concrete substrate should be at least 3500 psi (24 MPa) at 28 days and a				
Mixing	250 psi (1.7 MPa) in tension at the time of application of Sikadur WDE Primer. Empty component B into component A container. Mix the combined components for at least a using a low-speed drill (300-450 rpm) to minimize entrapping air. Use an Exomixer type m <b>Typical Data (Material and curing conditions @ 74°F (22°C) and 40% R</b> RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPM TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.					
		a low-speed drill (300-450 r <b>Typical Data (Material</b> RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION MET	pm) to minimize entrapp and curing condition statistical variations depen- lobs, test methods, actual s	ing air. Use an Exom Is @ 74°F (22°C) ап NDING UPON MIXING МЕТНОД	ixer type mixing nd 40% R.H.) s and equipment,	
		a low-speed drill (300-450 r <b>Typical Data (Material</b> RESULTS MAY DIFFER BASED UPON	pm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla	ning air. Use an Exom <b>IS @ 74°F (22°C) an</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, s CONDITIONS.	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear	ning air. Use an Exom <b>Is @ 74°F (22°C) an</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short fille	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, c CONDITIONS. 2.5 gal. pails) ed 1 gal. cans)	
		a low-speed drill (300-450 r <b>Typical Data (Material</b> RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH <b>Packaging</b>	pm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- TODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product betweer	ing air. Use an Exom <b>IS @ 74°F (22°C) an</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° -	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, c CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C).	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors	pm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa	ing air. Use an Exom <b>IS @ 74°F (22°C) an</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° -	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, c CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C).	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product betweer A:B = 3:1 by volume	ing air. Use an Exom <b>IS @ 74°F (22°C) an</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° -	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, c CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C).	
		a low-speed drill (300-450 r <b>Typical Data (Material</b> RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPER- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product between A:B = 3:1 by volume ad 50% R.H. Resin A	hing air. Use an Exom <b>15 @ 74°F (22°C) a</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° - h 65° - 85°F (18° - 30°C) Hardener B	ixer type mixing nd 40% R.H.) S AND EQUIPMENT, CONDITIONS. 2.5 gal. pails) 2.5 gal. pails) 2.5 gal. cans) 90°F (5° -32°C). before using. Mixed A+B	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component Specific gravity, lb/gal. (kg/L)	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPER- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product between A:B = 3:1 by volume d 50% R.H. Resin A 9.34 (1.12)	hing air. Use an Exom <b>15 @ 74°F (22°C) a</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° - 1 1 65° - 85°F (18° - 30°C) <b>Hardener B</b> 8.73 (1.05)	ixer type mixing nd 40% R.H.) S AND EQUIPMENT, CONDITIONS. 2.5 gal. pails) 2.5 gal. pails) 2.5 gal. cans) 90°F (5° -32°C). before using. Mixed A+B 9.19 (1.1)	
		a low-speed drill (300-450 r <b>Typical Data (Material</b> RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPER- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product between A:B = 3:1 by volume ad 50% R.H. Resin A	hing air. Use an Exom <b>15 @ 74°F (22°C) a</b> NDING UPON MIXING METHOD ITE CONDITIONS AND CURING plastic pail (short filled 2 astic container (short filled aging. Store dry at 40° - h 65° - 85°F (18° - 30°C) Hardener B	ixer type mixing nd 40% R.H.) S AND EQUIPMENT, CONDITIONS. 2.5 gal. pails) 2.5 gal. pails) 2.5 gal. cans) 90°F (5° -32°C). before using. Mixed A+B	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component Specific gravity, lb/gal. (kg/L) Viscosity Solids by weight Pot Life, 7.05 oz (200 g)	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPER- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product between A:B = 3:1 by volume d 50% R.H. Resin A 9.34 (1.12) 600 cps -	And the second s	ixer type mixing nd 40% R.H.) S AND EQUIPMENT, CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C). before using. Mixed A+B 9.19 (1.1) 900 cps	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component Specific gravity, Ib/gal. (kg/L) Viscosity Solids by weight	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- HODS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product betweer A:B = 3:1 by volume ad 50% R.H. Resin A 9.34 (1.12) 600 cps - - 5, 70°F (21°C) Neat	A source of the second	ixer type mixing nd 40% R.H.) s AND EQUIPMENT, c CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C). before using. Mixed A+B 9.19 (1.1) 900 cps 100% 8 min Maximum 24 hrs.	
		a low-speed drill (300-450 r Typical Data (Material RESULTS MAY DIFFER BASED UPON TEMPERATURE, APPLICATION METH Packaging Colors Shelf Life Mixing Ratio Properties at 77°F (25°C) an Component Specific gravity, Ib/gal. (kg/L) Viscosity Solids by weight Pot Life, 7.05 oz (200 g) Waiting time between coats	rpm) to minimize entrapp and curing condition STATISTICAL VARIATIONS DEPEN- 10DS, TEST METHODS, ACTUAL S 2 gal (8 L) Component A: 2 x 1 gallon Component B: 2 x 1 pint pla Clear 2 years in unopened packa Condition product betweer A:B = 3:1 by volume ad 50% R.H. Resin A 9.34 (1.12) 600 cps - 5, 70°F (21°C) Neat Broadcast Primer	An an an an an an an an an an an an an an	ixer type mixing nd 40% R.H.) S AND EQUIPMENT, C CONDITIONS. 2.5 gal. pails) ed 1 gal. cans) 90°F (5° -32°C). before using. Mixed A+B 9.19 (1.1) 900 cps 100% 8 min Maximum	



	paddle (recommended model) suited to the volume of the mixing container. During the mixing operations, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing. Mix only that quantity that can be used within its pot life.
Application	<b>Primer</b> - The mixed resin should be applied at 160 ft <sup>2</sup> /gal. (4 m <sup>2</sup> /L) using a brush or roller when used as a primer for other Sika products. When it is used as a first coat of a build up system it is normal to broadcast Barnes # 51 or # 71 sand to saturation at a rate of 2-3 lb/10 ft <sup>2</sup> (1-1.5 kg/m <sup>2</sup> ) and allow to dry before proceeding to the next step.
imitations	<ul> <li>Do not thin with solvents.</li> <li>Not recommended for repairs applied underwater.</li> <li>Minimum/Maximum substrate temperature: 32°/85° (0°/30°).</li> <li>Maximum relative humidity: 85%.</li> <li>Substrate temperature must be at least 5° (3°) above measured dew point.</li> <li>Conduct quantitative anhydrous calcium chloride testing in accordance with ASTM-F1869. Maximum acceptable test result is 3 pounds per 1,000 ft2 per 24 hours. Determine the surface moisture content by using an impedance moisture meter designed for use on concrete as detailed in ASTM E-1907. Acceptable test results shall be 4% by mass or less. If over, use Sikafloor EpoCem 81/82.</li> <li>Freshly applied Sikadur WDE Primer should be protected from dampness, condensation and water for at least 24 hrs.</li> <li>Do not thin this product. Addition of thinners will slow the cure and reduce the ultimate properties of this product.</li> <li>This product is not designed for exterior use, immersion, or any use where moisture can reach the underside of the resurfacer.</li> <li>Will discolor over time when exposed to sunlight (UV) and under certain artificial lighting conditions. UV resistant, light stable topcoats are available where ultimate color/clarity retention is required.</li> </ul>
	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET. PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
	INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ
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	INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE. KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY. For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Produc Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions on the product's most current produc

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Product Data Sheet Edition 10.16.2014 Sikagard® 616

## Sikagard<sup>®</sup> 616

Versatile Epoxy for use as a Primer, High Build Protective Coating and for Decorative Quartz and Flake Application

Description		l <sup>®</sup> 616 is a 2 component, build coatings and decora			rd <sup>®</sup> 616 may be us	sed as a clear prime
Where to Us	quartz o	I <sup>®</sup> 616 is ideal as a broa r vinyl flake floor broadca when increased chemic	ast systems. Sikaga	rd <sup>®</sup> 616 car	n also be top coa	
		sed as a primer, Sikaga art by weight) is measure meter.				
Advantage	<ul> <li>Durable</li> <li>Attract</li> <li>Good</li> <li>100%</li> <li>Easily</li> <li>Good</li> </ul>	smooth, non-porous su e, impermeable and sea ive, high gloss, reflective chemical and mechanica solids as supplied. applied with brush, roller Abrasion Resistance. ent Impact Resistance.	amless. e coating al resistance.	n.		
Coverage	mm) wet	finish coating: Prime C film thickness (w.f.t.) W ) wet film thickness (w.f.	ear coat: 105 - 135			
Packaging		ent A: 3 US gal. (8.5 L); (Ready to mix unit).	Component B: 1.50	) US gal. (5	5.7 L); Compone	nts A+B: 4.5 US ga
	RESULTS MAY DIFFER BA TEMPERATURE, APPLICA	aterial and curing cond SED UPON STATISTICAL VARIA TION METHODS, TEST METHOD	TIONS DEPENDING UPON DS, ACTUAL SITE CONDITI	MIXING METH	ODS AND EQUIPMEN ING CONDITIONS.	,
	RESULTS MAY DIFFER BA	SED UPON STATISTICAL VARIA TION METHODS, TEST METHOD 2 years in original u	TIONS DEPENDING UPON S, ACTUAL SITE CONDITI nopened container i al for at least 24 hou Time ~ 50 n ~ 25 n	I MIXING METH ONS AND CUR Under prope	ODS AND EQUIPMEN ING CONDITIONS. er storage.	IT,
	RESULTS MAY DIFFER BA TEMPERATURE, APPLICA Shelf Life Storage Condition Color Pot life material	SED UPON STATISTICAL VARIA TION METHODS, TEST METHOD 2 years in original un s Precondition materia Clear Temperature +50°F (10°C) +68°F (20°C)	TIONS DEPENDING UPON DS, ACTUAL SITE CONDITI nopened container in al for at least 24 hou Time ~ 50 n ~ 25 n ~ 15 n econd coat of Sikaga	ninutes ninutes	ops and equipmen ing conditions. for storage. 65° to 75°F (18 ow: <b>m Maxin</b> s 3 days s 2 days	т, ° to 24°C). <b>num</b>
	RESULTS MAY DIFFER BA TEMPERATURE, APPLICA Shelf Life Storage Condition Color Pot life material Waiting / Recoat T	SED UPON STATISTICAL VARIA TION METHODS, TEST METHOD 2 years in original un s Precondition materia Clear Temperature +50°F (10°C) +68°F (20°C) imes Before applying se Ambient & substrate +50°F (10°C) +68°F (20°C)	ATIONS DEPENDING UPON DS, ACTUAL SITE CONDITI nopened container of al for at least 24 hou Time ~ 50 n ~ 25 n ~ 15 n econd coat of Sikage <b>Temperature</b>	ninutes ninutes ninutes ninutes ninutes ninutes ninutes ard <sup>®</sup> 616 alle <b>Minimu</b> 24 hours 6 hours	obs and equipmen ing conditions. er storage. 65° to 75°F (18° ow: <b>m Maxin</b> s 3 days s 2 days 1 day	r, ° to 24°C). <b>num</b>
	RESULTS MAY DIFFER BA TEMPERATURE, APPLICA Shelf Life Storage Condition Color Pot life material Waiting / Recoat T	SED UPON STATISTICAL VARIA TION METHODS, TEST METHOD 2 years in original un s Precondition materia Clear Temperature +50°F (10°C) +68°F (20°C) +86°F (30°C) imes Before applying se Ambient & substrate +50°F (10°C) +68°F (20°C) +68°F (20°C) +86°F (30°C) kafloor Epoxy or Polyu	ATIONS DEPENDING UPON DS, ACTUAL SITE CONDITI nopened container of al for at least 24 hou Time ~ 50 n ~ 25 n ~ 15 n econd coat of Sikage <b>Temperature</b>	ninutes ninutes ninutes ninutes ninutes ninutes ninutes ard <sup>®</sup> 616 alle <b>Minimu</b> 24 hours 6 hours	ops and Equipmen ing conditions. er storage. 65° to 75°F (18° ow: <b>m Maxin</b> s 3 days s 2 days 1 day <b>w</b>	r, ° to 24°C). <b>num</b>



Properties Tested at 73°f (23°c) and 50 % R.h:

Solid content ~ 100% (by volume) / ~ 100% (by weight)	
Compressive strength ASTM C579 Resin (filled 1:0,9 with F34)	7,250 psi (50 N/mm²) (28 days)
Flexural strength ASTM C580 Resin (filled 1:0,9 with F34)	2,900 psi (20 N/mm²) (28 days)
Pull-off strength ASTM D4541	> 400 psi (2.7 MPa) (100% concrete failure)
Viscosity (mixed) Components A + B:	292 (SP1/100)
Shore D hardness (7 days) ASTM D2240	78 - 82
VOC content ASTM D2369	≤ 50 g/L
Chemical Resistance:	Please consult Sika Technical Services.

How to Use

Mixing

Application

Surface Preparation Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, Preparation bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application.

**Concrete** - Should be cleaned and prepared to achieve a laitance-free and contaminant-free, open textured surface by shot blasting or equivalent mechanical means (CSP-3 to CSP-4 as per ICRI guidelines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. Whenever "shot-blasting" is utilized, be careful to leave concrete with a uniform texture. "Overblasting" will result in reduced coverage rates of the primer and/or subsequent topcoats. The "shotblast" pattern may show through the last coat, known as "tracking". The compressive strength of the concrete substrate should be at least 3,500 psi (24 MPa) at 28 days and at least 215 psi (1.5 MPa) in tension at the time of application. For other substrates, please contact Sika Technical Services.

Mixing Ratio - 1.5 : 1 by volume. Premix each component separately. Empty Component B (Hardener) in the correct mix ratio into Component A (Resin). Mix the combined components for at least 3 minutes using a low speed drill (300 - 450 rpm) and Exomixer or Jiffy type paddle suited to the volume of the mixing container to minimize entrapped air. Be careful not to introduce any air bubbles while mixing. Make sure the contents are completely mixed to avoid any weak or partially cured spots in the coating. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing.

Do not mix more material than can be applied within the working time limits (i.e. pot life) at the actual field temperature.

As primer: Apply Sikagard<sup>®</sup> 616 by squeegee at the rate of 160 - 200 ft<sup>2</sup>/US gal (3.9 – 4.9 m<sup>2</sup>/L) at 8 - 10 mils (0.20 – 0.25 mm) wet film thickness (w.f.t.) and back roll with pressure after 15 minutes. Coverage will vary depending on the porosity of the prepared floor. Product has a limited Pot Life, see Typical Data. Do not apply by dipping roller into mixing container. Pour a bead of product in the form of a ribbon on the surface to be coated, then spread with squeegee and back roll. Ensure that the coating is pore-free and pinhole-free and provides uniform and complete coverage over the entire concrete substrate. If necessary, apply an additional coat to ensure the coating is pore-free and provides uniform and complete coverage over the entire concrete substrate.

As sealer/intermediate: Sikagard<sup>®</sup> 616 is applied with a 40 mil (1 mm) notched squeegee over a smooth surface and a flat squeegee over a rough or decorative quartz surface. Back rolling is typically done with an 18 inch (455 mm) wide 3/8 inch (10 mm) short nap, solvent-resistant roller cover. Back roll the Sikagard<sup>®</sup> 616 only to level the squeegee applied material. Over-rolling and late back rolling may cause bubbling and leave roller marks.

Limitations Notes on Limitations: Prior to application, measure and confirm Substrate Moisture Content, Ambient Relative Humidity, Ambient and Surface Temperature and Dew Point. During installation, confirm and record above values at least once every 3 hours, or more frequently whenever conditions change (e.g. Ambient Temperature rise/fall, Relative Humidity increase/decrease, etc.).

> Substrate Moisture Content: Moisture content of concrete substrate must be ≤ 4% by mass (pbw – part by weight) as measured with a Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter on mechanically prepared surface according to this product data sheet (preparation to CSP-3 to CSP-4 as per ICRI guidelines). Do not apply to concrete substrate with moisture levels > 4% mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter.

> When relative humidity tests for concrete substrate are conducted perASTM F2170 for project specific requirements, values must be  $\leq 85\%$ . If values are > 85% according to ASTM F2170 use Sikalastic<sup>®</sup> MT Primer or Sikafloor<sup>®</sup> 81 EpoCem.

ASTM F2170 testing is not a substitute for measuring substrate moisture content with a Tramex<sup>®</sup> CME/ CMExpert type concrete moisture meter as described above.

Material Temperature: Precondition material for at least 24 hours between 65° to 75°F (18° to 24°C).

Ambient Temperature: Minimum/Maximum 50°/85°F (10°/30°C).

Substrate Temperature: Minimum/Maximum 50°/85°F (10°/30°C). Substrate temperature must be at least 5°F (3°C) above measured Dew Point.

Mixing and Application attempted at Material, Ambient and/or Substrate Temperature conditions less than 65°F (18°C) will result in a decrease in product workability and slower cure rates.

Relative Ambient Humidity: Maximum ambient humidity 85% (during application and curing).

#### Dew Point: Beware of condensation!

The substrate must be at least 5°F (3°C) above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or "blushing" on the floor finish. Be aware that the substrate temperature may be lower than the ambient temperature.

Mixing: Do not hand mix Sikagard® materials. Mechanically mix only. Do not thin this product. Addition of thinners (e.g. water, solvent, etc.) will slow cure and reduce ultimate properties of this product. Use of thinners will void any applicable Sika warranty.

Application: If used as a primer. Apply the primer/coating to the prepared substrate using a squeegee and back roll to provide uniform coverage. Ensure that the substrate is pore-free and pinhole-free and provides uniform and complete coverage over the entire concrete substrate. If necessary, apply an additional coat to ensure the substrate is pore-free and pinhole-free and provides uniform and complete coverage over the entire substrate.

- Do not apply while ambient and substrate temperatures are rising, as pinholes may occur. Ensure there is no vapor drive at the time of application. Refer to ASTM D4263, may be used for a visual indication of vapor drive.
- Freshly applied material should be protected from dampness, condensation and water for at least 72 hrs.
- Will discolor over time when exposed to sunlight (UV) and under certain artificial lighting conditions. Use of clear UV resistant top coat may not prevent discoloration of underlying coatings.
- Do not apply Sikagard<sup>®</sup> to concrete substrate containing aggregates susceptible to ASR (Alkali Silica Reaction) due to risk of natural alkali redistribution below the Sikagard® product after application. If concrete substrate has or is suspected to have ASR (Alkali Silica Reaction) present, do not proceed. Consult with design professional prior to use.
- Any aggregate used with Sikagard<sup>®</sup> systems must be non-reactive and oven-dried.
- This product is not designed for negative side waterproofing
- Use of unvented heaters and certain heat sources may result in defects (e.g. blushing, whitening, debonding, etc.).
- Beware of air flow and changes in air flow. Introduction of dust, debris, and particles, etc. may result in surface imperfections and other defects.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET. PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all Tisks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C P 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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# Sikagard<sup>®</sup> 664

Versatile Epoxy for High Performance Protective Coatings

Description	Sikagard <sup>®</sup> 664 is a pigmented, two part low viscosity, self-priming, epoxy coating/binder used for smooth and textured coatings and/or broadcast overlayments.
Where to Use	Roller coat and self-leveling slurry for concrete and cement screeds with normal up to medium heavy wear (e.g. storage, hallways, corridors and assembly halls, maintenance workshops, garages and loading ramps), or as a seal coat for broadcast systems. When used as a primer, Sikagard <sup>®</sup> 664 can be considered when $\leq 4\%$ moisture content by mass (pbw – part by weight) is measured on the concrete substrate with a Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter.
Advantages	<ul> <li>Good chemical and mechanical resistance.</li> <li>Easily applied with brush, roller or squeegee.</li> <li>Glossy aesthetic finish</li> <li>Slip resistant surface possible.</li> <li>Durable, impermeable and seamless.</li> <li>Solvent-free, neutral odor.</li> <li>Low mixed viscosity.</li> </ul>
Coverage	<b>Smooth Finish Coating:</b> Prime coat: 160 - 200 ft <sup>2</sup> /US gal $(3.9 - 4.9 \text{ m}^2/\text{L})$ at 8 - 10 mils $(0.20 - 0.25 \text{ mm})$ wet film thickness (w.f.t.). Wear coat: 105 - 135 ft <sup>2</sup> /US gal $(2.6 - 3.3 \text{ m}^2/\text{L})$ at 12 - 15 mils $(0.30 - 0.38 \text{ mm})$ wet film thickness ( .f.t.).
Packaging	Component A: 3.0 US gal. (11.4 L); Component B: 1.5 US gal. (5.7 L) Components A+B: 4.5 US gal. (17 L) (Ready to mix unit).
Cure Mechanism	See Typical Data.
Chemical Resistance	Please consult Sika Technical Service.

### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

•			en 40°-90°F (4°-32°C	·
-		st 24 hours betwe	en 65° to 75°F (18°	to 24°C).
Color Gray, Red &	Tan			
Pot life material Temperature		Time		
+50°F (10°C)		~ 50 minutes		
+68°F (20°C)		~ 25 minutes		
+86°F (30°C)		~ 15 minutes		
Waiting / Recoat Times Before ap	plying second co	at of Sikagard 66	4 on Sikagard 664	allow:
Ambient & Substrate	Temperature	Minimum	Maximum	
	+50°F (10°C)	24 hours	3 days	
	+68°F (20°C)	8 hours	2 days	
	+86°F (30°C)	6 hours	1 day	
Before applying Sikagard Epoxy	or Polyurethane o	on Sikagard 616 a	allow:	
Ambient & Substrate	Temperature	Minimum	Maximum	
	+50°F (10°C)	24 hours	3 days	
	+68°F (20°C)	8 hours	2 days	
	+86°F (30°C)	6 hours	1 day	
Cure Times Ambient & Substrate	Temperature	Foot traffic	Light traffic	Full cure
	+50°F (10°C)	~ 24 hours	~ 3 days	~ 10 days
	+68°F (20°C)	~ 12 hours	~ 2 days	~ 7 days
	+86°F (30°C)	~ 8 hours	~ 1 days	~ 5 days
Compressive Strength (ASTM C57	79) - 28 days	7,250	) psi (50 N/mm²)	
Flexural Strength (ASTM C580) - 2	8 davs	2 900	) psi (20 N/mm²)	
		_,000		

Pull-Off Strength (ASTM D4541)	>400 psi (2.7 N/mm <sup>2</sup> ) (100% concrete fail)
Shore D Hardness (ASTM D2240) - 7 days	76
VOC Content (ASTM D2369)	<30 g/l

Surface Preparation	Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application.
	<b>Concrete</b> - Should be cleaned and prepared to achieve a laitance-free and contaminant-free, open textured surface by shot blasting or equivalent mechanical means (CSP-3 to CSP-4 as per ICR guide-lines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. Whenever "shot blasting" is utilized, be careful to leave concrete with a uniform texture. "Over-blasting" will result in reduced coverage rates of the primer and/or subsequent topcoats. The "shotblast" pattern may show through the last coat, known as "tracking". The compressive strength of the concrete substrate should be at least 3,500 psi (24 MPa) at 28 days and at least 215 psi (1.5 MPa) in tension at the time of application. For other substrates, please contact. Sika Technical Services.
	<b>Primer or Smooth Finish Coating:</b> Priming the concrete substrate is required. Prime with Sikagard 616 or Sikalastic <sup>®</sup> MT Primer. Allow the primer to cure (varies with temperature and humidity) until tack free before applying subsequent coats. Ensure that the primer is pore-free, pinhole-free and provides uniform and complete coverage over the entire substrate. Sikagard <sup>®</sup> 664 may be used as primer or concrete substrates for Sikagard <sup>®</sup> coating systems subjected to light traffic use.
Mixing	Mixing Ratio - 2 : 1 by volume. Primer and Wear Coat: Premix each component separately. Empty Component B (Hardener) in the correct mix ratio into Component A (Resin). Mix the combined components for at least 3 minutes using a low speed drill (300 - 450 rpm) and Exomixer or Jiffy type paddle suited to the volume of the mixing container to minimize entrapped air. Be careful not to introduce any air bubbles while mixing. Make sure the contents are completely mixed to avoid any weak or partially cured spots in the coating. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing.
	<b>Self-leveling Slurry:</b> Premix each component separately. Empty Component B (Hardener) in the correct mix ratio into Component A (Resin). Mix the combined components for at least 1 minute using a low speed drill (300 - 450 rpm) and Exomixer or Jiffy type paddle suited to the volume of the mixing container to minimize entrapped air. Add Sikadur® 504 type filler and mix for additional 2 minutes. Be careful not to introduce any air bubbles while mixing. Make sure the contents are completely mixed to avoid any weak or partially cured spots in the slurry. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing.
	Do not mix more material than can be applied within the working time limits (i.e. pot life) at the actual field temperature.
Application	As Primer: Apply primer by squeegee at the rate of $160 - 200 \text{ ft}^2/\text{US}$ gal $(3.4 - 4.9 \text{ m}^2/\text{L})$ at $8 - 10 \text{ mil}$ $(0.20 - 0.25 \text{ mm})$ wet film thickness (w.f.t.) and back roll with pressure after 15 minutes. Coverage will vary depending on the porosity of the prepared floor. Product has a limited Pot Life, see Typica Data. Do not apply by dipping roller into mixing container. Pour a bead of product in the form of ribbon on the surface to be coated, then spread with squeegee and back roll. Ensure that the coating is pore-free and pinhole-free and provides uniform and complete coverage over the entire concrete substrate. If necessary, apply an additional coat to ensure the coating is pore-free and pinhole-free and complete coverage over the entire concrete substrate.
	As Wear and Sealer Coat: Sikagard <sup>®</sup> 664 is applied with a 40 mil (1 mm) notched squeegee over a smooth surface and a flat squeegee over a rough or broadcast quartz surface. Back rolling is typicall done with an 18 inch (455 mm) wide 3/8 inch (10 mm) short nap, solvent-resistant roller cover. Back rolling the Sikagard <sup>®</sup> 664 only to level the squeegee applied material. Over-rolling and late back rolling may cause bubbling and leave roller marks.
	Smooth Finish Self-Leveling Slurry: Pour a bead of product to the surface to be coated, then spread with a notched squeegee or pin rake to the desired thickness. Roll immediately (within max. 10 min utes of application) in two directions with a spiked roller to ensure even thickness and the removal of the spiked roller to ensure even thickness.

### Limitations

**Notes on Limitations:** Prior to application, measure and confirm Substrate Moisture Content, Ambient Relative Humidity, Ambient and Surface Temperature and Dew Point. During installation, confirm and record above values at least once every 3 hours, or more frequently whenever conditions change (e.g. Ambient Temperature rise/fall, Relative Humidity increase/decrease, etc.).

Substrate Moisture Content: Moisture content of concrete substrate must be  $\leq 4\%$  by mass (pbw – part by weight) as measured with a Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter on mechanically prepared surface according to this product data sheet (preparation to CSP-3 to CSP-4 as per ICRI guidelines). Do not apply to concrete substrate with moisture levels > 4% mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex<sup>®</sup> CME/CMExpert type concrete moisture meter.

When relative humidity tests for concrete substrate are conducted perASTM F2170 for project specific requirements, values must be  $\leq 85\%$ . If values are > 85% according to ASTM F2170 use Sikalastic<sup>®</sup> MT Primer or Sikafloor<sup>®</sup> 81 EpoCem.

ASTM F2170 testing is not a substitute for measuring substrate moisture content with a Tramex<sup>®</sup> CME/ CMExpert type concrete moisture meter as described above.

Material Temperature: Precondition material for at least 24 hours between 65° to 75°F (18° to 24°C).

Ambient Temperature: Minimum/Maximum 50°/85°F (10°/30°C).

**Substrate Temperature:** Minimum/Maximum  $50^{\circ}/85^{\circ}F$  ( $10^{\circ}/30^{\circ}C$ ). Substrate temperature must be at least  $5^{\circ}F$  ( $3^{\circ}C$ ) above measured Dew Point.

Mixing and Application attempted at Material, Ambient and/or Substrate Temperature conditions less than 65°F (18°C) will result in a decrease in product workability and slower cure rates.

Ambient Relative Humidity: Maximum ambient humidity 85% (during application and curing).

Dew Point: Beware of condensation!

The substrate must be at least  $5^{\circ}F(3^{\circ}C)$  above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or "blushing" on the floor finish. Be aware that the substrate temperature may be lower than the ambient temperature.

**Mixing:** Do not hand mix Sikagard<sup>®</sup> materials. Mechanically mix only. Do not thin this product. Addition of thinners (e.g. water, solvent, etc.) will slow cure and reduce ultimate properties of this product. Use of thinners will void any applicable Sika warranty. Improper mixing procedure or incorrect mixing ratio may result in moisture sensitivity, whitening, slow cure, soft spots, and other defects.

Application: If used as a primer apply material to the prepared substrate using a squeegee and back roll to provide uniform coverage. Ensure that the substrate is pore-free and pinhole free and provides uniform and complete coverage over the entire substrate. If necessary, apply an additional coat to ensure the substrate is pore-free and pinhole-free and provides uniform and complete coverage over the entire substrate. If necessary, apply an additional coat to ensure the substrate is pore-free and pinhole-free and provides uniform and complete coverage over the entire substrate. Do not apply while ambient and substrate temperatures are rising, as pinholes may occur. Ensure there is no vapor drive at the time of application. Refer to ASTM D4263, may be used for a visual indication of vapor drive.

- Freshly applied material should be protected from dampness, condensation and water for at least 72 hrs.
- Will discolor over time when exposed to sunlight (UV) and under certain artificial lighting conditions. Use of clear UV resistant top coat may not prevent discoloration of underlying coatings.
- Do not apply Sikagard<sup>®</sup> to concrete substrate containing aggregates susceptible to ASR (Alkali Silica Reaction) due to risk of natural alkali redistribution below the Sikagard<sup>®</sup> product after application. If concrete substrate has or is suspected to have ASR (Alkali Silica Reaction) present, do not proceed. Consult with design professional prior to use.
- Any aggregate used with Sikagard<sup>®</sup> systems must be non-reactive and oven-dried.
- This product is not designed for negative side waterproofing
- Typically not recommended for exterior slabs on grade where freeze/thaw conditions may exist.
- Use of unvented heaters and certain heat sources may result in defects (e.g. blushing, whitening, debonding, etc.).
- Beware of air flow and changes in air flow. Introduction of dust, debris, and particles, etc. may
  result in surface imperfections and other defects.



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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR WARKAN IES EARKESS OR IMPELED SHALL APPLT INCOUNTS ANY WARKAN'T OF WERKAN'T DE MEMORY AND ANAGES. SIKA SHALL NOT BE PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.



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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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ISO 9001 RC 14001

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C500

## Sikagard<sup>®</sup> 600 Chemical Resistant Protective Coating

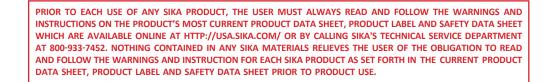
Description	A two component, high solids, novolac epoxy with exceptional chemical resistance. Sikagard <sup>®</sup> 600 can be installed as a stand-alone coating. Its versatility allows Sikagard <sup>®</sup> 600 to be applied as a topcoat or used as a binder in a slurry/broadcast system.
Where to Use	Designed for use as a medium to heavy coat epoxy resurfacer in areas subjected to chemical spillages. Ideal for use in chemical processing, chemical storage areas, and battery charge stations.
Advantages	<ul> <li>Low odor.</li> <li>Very good chemical resistance.</li> <li>Easy application.</li> </ul>
Coverage	Approximately 80 - 130 ft <sup>2</sup> /US gal (1.9 - 3.2 m <sup>2</sup> /L) at 12 to 20 mils (0.3 – 0.5 mm) wet film thickness (w.f.t) or 240 - 390 ft <sup>2</sup> /US gal (5.9 - 9.6 m <sup>2</sup> /L) per 3 gallon unit over primed, relatively smooth, dense concrete surfaces. (The above figures do not allow for surface profile or wastage).
Packaging	Component A: 2.0 US gal. (7.6 L); Component B: 1 US gal. (3.8 L); Component A+B: 3.0 US gal. (11.3 L) (Ready to mix unit).

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H. unless otherwise noted)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original unopened container under proper storage conditions. Store dry	
	between 40° - 90°F (4°- 32°C).	

	$\mathbf{D} = \mathbf{D} = $				
Color	Gray				
Pot life material	Temperature	Time			
	+50°F (10°C)	~ 50 minutes			
	+68°F (20°C)	~ 25 minutes			
	+86°F (30°C)	~ 15 minutes			
	ted pot life is exceeded. end of pot life is no				
Waiting / Recoat Tin	nes Before applying second coat o	0	ow:		
	Ambient & substrate Temperature		maximum		
	+50°F (10°C)	24 hours	3 days		
	+68°F (20°C) +86°F (30°C)	12 hours 6 hours	2 days 1 day		
Ourse Timese				full and	
Cure Times	Ambient & substrate Temperature +50°F (10°C)	~ 36 hours	light traffic ~ 6 days	full cur ~ 10 days	
	+68°F (20°C)	~ 24 hours	~ 4 days	~ 7 days	
	+86°F (30°C)	~ 18 hours	~ 2 days	~ 5 days	
	, , , , , , , , , , , , , , , , , , ,		, .		
•	t 73°f (23°c) and 50 % R.H:	(00 ) (00 )			
Compressive streng		400 psi (28 days)	·		
Pull-off strength AS		• •	IPa) (100% concre	ete failure)	
Elongation ASTM D		24%			
Shore D hardness A		85 - 88			
Impact Resistance	ASTM D2794:	160 in-lbs.			
Abrasion Resistanc	e ASTM D4060:	25 mg loss			
Flammability ASTM	D635 Film is Self Extinguishing				
VOC content ASTM	D2369:	≤ 50 g/L			
Tensile strength AS	TM D638:	4,340 psi (7 Days	5)		
Chemical Resistance	e:	Please consult S	ikaTechnical Servi	ces.	



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How to Use	
Surface Preparation	Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, Preparation bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application.
	<b>Concrete</b> - Should be cleaned and prepared to achieve a laitance-free and contaminant-free, open textured surface by shot blasting or equivalent mechanical means (CSP-3 to CSP-4 as per ICRI guide- lines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. Whenever "shot-blasting' is utilized, be careful to leave concrete with a uniform texture. "Over blasting" will result in reduced coverage rates of the primer and/or subsequent topcoats. The "shotblast" pattern may show through the last coat, known as "tracking". The compressive strength of the concrete substrate should be at least 3,500 psi (24 MPa) at 28 days and at least 215 psi (1.5 MPa) in tension at the time of application. For other substrates, please contact Sika Technical Services.
	<b>Priming</b> - Priming for concrete substrate is required. Prime with either Sikagard® 616 or Sikalastic® MT Primer. Allow the primer to cure (varies with temperature and humidity) until tack free before applying subsequent coats. Ensure that the primer is pore-free, pinhole-free and provides uniform and complete coverage over the entire substrate. Please refer to the individual most current and respective Product Data Sheet for specific and detailed information
Mixing	Mix Ratio - 2 : 1 by volume. Pre-mixed each component separately. Empty Component B (Hardener) in the correct mix ratio into Component A (Resin). Mix the combined components for at least 3 minutes using a low speed drill (300 - 450 rpm) and Exomixer or Jiffy type paddle suited to the volume of the mixing container to minimize entrapped air. Be careful not to introduce any air bubbles while mixing. Make sure the contents are completely mixed to avoid any weak or partially cured spots in the coating. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature
Application	Pour a thin approximately 6 – 12 in. wide bead of Sikagard <sup>®</sup> 600 in the form of a ribbon on the surface and spread the material at a rate of approximately 130 ft <sup>2</sup> /US gal (3.2 m <sup>2</sup> /L) with a notched squeegee, flat squeegee, or trowel. Apply as evenly as possible, working from left to right, and then back. Back rolling is typically done with an 18 inch (454 mm) wide short nap, 3/8" (10 mm), solvent-resistant roller cover. Back roll the Sikagard <sup>®</sup> 600 only to level the squeegee applied material. Over-rolling and late back rolling may cause bubbling and leave roller marks.
Limitations	<b>Notes on Limitations:</b> Prior to application, measure and confirm Substrate Moisture Content, Ambient Relative Humidity, Ambient and Surface Temperature and Dew Point. During installation, confirm and record above values at least once every 3 hours, or more frequently whenever conditions change (e.g. Ambient Temperature rise/fall, Relative Humidity increase/decrease, etc.).
	Substrate Moisture Content: Moisture content of concrete substrate must be ≤ 4% by mass (pbw – part by weight) as measured with a Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter on mechanically prepared surface according to this product data sheet (preparation to CSP-3 to CSP-4 as per ICRI guidelines). Do not apply to concrete substrate with moisture levels > 4% mass (pbw – part by weight) as measured with Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw part by weight) as measured with Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw part by weight) as measured with Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter.
	When relative humidity tests for concrete substrate are conducted perASTM F2170 for project specific requirements, values must be ≤ 85%. If values are > 85% according to ASTM F2170 use Sikalastic MT Primer or Sikafloor <sup>®</sup> 81 EpoCem.
	ASTM F2170 testing is not a substitute for measuring substrate moisture content with a Tramex <sup>®</sup> CME CMExpert type concrete moisture meter as described above.
	Material Temperature: Precondition material for at least 24 hours between 65° to 75°F (18° to 24°C).
	Ambient Temperature: Minimum/Maximum 50°/85°F (10°/30°C).
	Substrate Temperature: Minimum/Maximum 50°/85°F (10°/30°C). Substrate temperature must be at least 5°F (3°C) above measured Dew Point.
	Mixing and Application attempted at Material, Ambient and/or Substrate Temperature conditions less than 65°F (18°C) will result in a decrease in product workability and slower cure rates.
	Relative Ambient Humidity: Maximum ambient humidity 85% (during application and curing).
	<b>Dew Point:</b> Beware of condensation! The substrate must be at least 5°F (3°C) above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or "blushing" on the floor finish. Be aware that the substrate temperature may be lower than the ambient temperature.
	<b>Mixing:</b> Do not hand mix Sikagard <sup>®</sup> materials. Mechanically mix only. Do not thin this product. Addition of thinners (e.g. water, solvent, etc.) will slow cure and reduce ultimate properties of this product. Use of thinners will void any applicable Sika warranty.
ka®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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**Application:** Apply the coating to the prepared substrate which should be pore-free and pinhole free. If necessary, apply an additional coat of a suitable material to ensure the substrate is pore free and pinhole-free and provides uniform and complete coverage over the entire substrate.

- Do not apply while ambient and substrate temperatures are rising, as pinholes may occur. Ensure there is no vapor drive at the time of application. Refer to ASTM D4263, may be used for a visual indication of vapor drive.
- Freshly applied material should be protected from dampness, condensation and water for at least 72 hrs.
- Will discolor over time when exposed to sunlight (UV) and under certain artificial lighting conditions. Use of clear UV resistant top coat may not prevent discoloration of underlying coatings.
- Do not apply Sikagard to concrete substrate containing aggregates susceptible to ASR (Alkali Silica Reaction) due to risk of natural alkali redistribution below the Sikagard® product after application. If concrete substrate has or is suspected to have ASR (Alkali Silica Reaction) present, do not proceed. Consult with design professional prior to use.
- Any aggregate used with Sikagard<sup>®</sup> systems must be non-reactive and oven-dried.
- This product is not designed for negative side waterproofing
- Use of unvented heaters and certain heat sources may result in defects (e.g. blushing, whitening, debonding, etc.).
  - Beware of air flow and changes in air flow. Introduction of dust, debris, and particles, etc. may result in surface imperfections and other defects.

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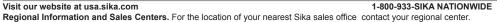


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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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# Sikadur<sup>®</sup> AnchorFix-1

High performance, two component adhesive anchoring system

Description	Sikadur <sup>®</sup> AnchorFix-1 adhesive anchoring system has been specially formulated as a high-performance two component adhesive anchor system for threaded and reinforcing bars in uncracked concrete.
Where to Use	<ul> <li>Uncracked concrete</li> <li>Hard natural stone</li> <li>Solid rock</li> <li>Solid masonry</li> </ul>
Advantages	<ul> <li>Fixing close to free edges.</li> <li>Versatile range of embedment depths.</li> <li>Anchoring without expansion forces.</li> <li>Component volume ratio of 10:1.</li> <li>Extended working time.</li> </ul>
Coverage	See below.
Packaging	10.1 fl.oz. (300 ml) or 28.7 fl.oz. (850 ml) cartridge
Approvals	European Technical Approval (ETA) according to ETAG001-5 for threaded bars only.

### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life When stored correctly, the shelf life will be from 12 months from the date of manufacture.

**Storage Conditions** 

Cartridges should be stored in their original packaging, the correct way up, in cool conditions (+41°F to +77°F) out of direct sunlight.

Working & Loading Times								
Cartridge Temperature*	T Work (minutes)	Base Material Temperature	T Load (minutes)					
+41°F to +50°F	+41°F to +50°F	145 minutes						
+50°F to +68°F 10 +50°F to +68°F 85 minutes								
+68°F to +77°F	6	+68°F to +77°F	50 minutes					
+77°F to + 86°F	5	+77°F to + 86°F	40 minutes					
+86°F 4 +86°F 35 minutes								
T Work is the typical time to gel at the highest temperature in the range T Load is the typical time to reach full capacity								

\*Cartridge temperature must be maintained at a minium of +41°F.



Installation Specifica	Installation Specification									
Property	Symbol	Unit								
Threaded Rod Diameter	d <sub>a</sub>	in	5/16	3/8	1/2	5/8	3/4	1		
Drill Bit Diameter	d <sub>o</sub>	in	3/8	1/2	9/16	11/16	13/16	1-1/16		
Cleaning Brush Size	d <sub>b</sub>	in	0.5	0.551 0.787				1.142		
Minimum Embedment Depth	h <sub>ef,min</sub>	in	2-1/2	3	4	5	6	8		
Maximum Embedment Depth	h <sub>ef,max</sub>	in	3-3/4	4-1/2	6	7-1/2	9	12		
Minimum Concrete Thickness	h <sub>min</sub>	in		h <sub>ef</sub> + 1-1/	/4 in ≥ 4 in		h <sub>ef</sub> +	2 d <sub>o</sub>		
Critical Anchor Spacing	S <sub>cr</sub>	in	4.0 h <sub>ef</sub> 3.0 h <sub>ef</sub>							
Critical Edge Distance	C <sub>ac</sub>	in	2.0 h <sub>et</sub> 1.5			1.5 h <sub>ef</sub>				
Maximum Tightening Torque	T <sub>inst</sub>	ft.lb	7.5	15	25	55	80	120		

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

Allowab	le Steel S	trength for Th	readed Rods						
		Carbon Steel ASTM F 1554 Grade 36 (A307 Gr.C)		Carbon Steel ASTM A 193 B7		Stainless Steel ASTM F 593 CW		Stainless Steel ASTM F 593 SH	
Anchor I (ir		Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>			Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>
3/8"	lb	2,110	1,080	4,550	2,345	3,360	1,870	4,190	2,160
3/0	kN	9.4	4.8	20.2	10.4	16.1	8.3	18.6	9.6
1/2"	lb	3,750	1,930	8,100	4,170	6,470	3,330	7,450	3,840
	kN	16.7	8.6	36.0	18.5	28.8	14.8	33.1	17.1
5/8"	lb	5,870	3,030	12,655	6,520	10,130	5,220	11,640	6,000
5/6	kN	26.1	13.5	56.3	29.0	45.1	23.2	51.8	26.7
3/4"	lb	8,460	4,360	18,220	9,390	12,400	6,390	15,300	7,880
5/4	kN	37.6	19.4	81.0	41.8	55.2	28.4	68.1	35.1
7/8"	lb	11,500	5,930	24,800	12,780	16,860	8,680	20,830	10,730
//0	kN	51.2	26.4	110.3	56.8	75.0	38.6	92.7	47.7
1"	lb	15,020	7,740	32,400	16,690	22,020	11,340	27,210	14,020
	kN	66.8	34.4	144.1	74.2	97.9	50.4	121.0	62.4
1 - 1/4"	lb	23,480	12,100	50,640	26,070	34,420	17,730	38,470	19,820
1 - 1/4	kN	104.4	53.8	225.1	116.0	153.1	78.9	171.1	88.2

Allowable Tension,  $N_{all} = 0.33 \times f_u \times nominal cross sectional area$  $Allowable Shear, <math>V_{all} = 0.17 \times f_u \times nominal cross section area$ \*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Allowable S	teel Streng	th for Rebar		Allowable Steel Strength for Rebar				
		Carbon Steel ASTM A	615 Grade 60		Carbon Steel CAN/CSA-G30.1			
Rebar Size		Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{all}$	Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{_{\mathrm{all}}}$	
#3	lb	3,280	1,690	10M	lb	4,016	2,069	
#3	kN	14.6	7.5	TON	kN	17.9	9.2	
	lb	5,831	3,004	4514	lb	8,052	4,148	
#4	kN	25.9	13.4	15M	kN	35.8	18.5	
#6	lb	9,111	4,693	20M	lb	11,960	6,161	
#5	kN	40.5	20.9		kN	53.2	27.4	
#0	lb	13,121	6,759	0514	lb	19,975	10,290	
#6	kN	58.4	30.1	25M	kN	88.9	45.8	
#7	lb	17,859	9,200	2014	lb	28,121	14,486	
#1	kN	79.4	40.9	30M	kN	125.1	64.4	
#8	lb	23,326	12,016	2514	lb	40,089	20,652	
#8	kN	103.8	53.4	35M	kN	178.3	91.9	
#4.0	lb	37,623	19,381			ross sectional area		
#10	kN	167.4	86.2	Shear = 0.17 x f *The design profe of the data provide	ssional on th	ess section area le job is ultimately responsil	ole for the interpreta	

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

1. Above values for reinforcing steel assume the design method is the same as a post-installed adhesive anchor, under the principles of anchor design (failure modes will be concrete breakout, pryout, steel failure, or adhesive bond) and not under the principles of reinforcing steel design (failure modes are typically splitting failure, inadequatebar development etc.). CONSULT AN ENGINEERING DESIGN PROFESSIONAL PRIOR TO USE.

Anchor	Embedment	Allowable Concrete Capacity / Bond Strength						
diameter	Depth	Tension (lb)			Shear (lb)			
		f' <sub>c</sub> = 2,500 psi	f' <sub>c</sub> = 4,000 psi	f' <sub>c</sub> = 8,000 psi	f' <sub>c</sub> = 2,500 psi	f' <sub>c</sub> = 4,000 psi	f' <sub>c</sub> = 8,000 psi	
	2-1/2"	1,517	1,590	1,704	2,022	2,120	2,272	
5/16"	3-1/8"	1,896	1,987	2,130	2,528	2,650	2,840	
	3-3/4"	2,275	2,385	2,556	3,033	3,179	3,408	
	3"	1,785	1,871	2,005	2,380	2,494	2,673	
3/8"	3-3/4"	2,231	2,338	2,506	2,975	3,118	3,342	
	4-1/2"	2,677	2,806	3,007	3,570	3,741	4,010	
	4"	3,276	3,434	3,680	4,368	4,578	4,907	
1/2"	5"	4,095	4,292	4,600	5,460	5,723	6,134	
	6"	4,914	5,151	5,520	6,552	6,867	7,360	
	5"	5,427	5,688	6,096	7,236	7,584	8,128	
5/8"	6-1/4"	6,784	7,110	7,620	9,045	9,480	10,160	
	7-1/2"	8,140	8,532	9,144	10,854	11,376	12,193	
	6"	6,801	7,128	7,640	9,068	9,505	10,187	
3/4"	7-1/2"	8,501	8,911	9,550	11,335	11,881	12,733	
	9"	10,202	10,693	11,460	13,602	14,257	15,280	
	8"	11,270	11,812	12,660	15,027	15,750	16,880	
1"	10"	14,088	14,766	15,825	18,783	19,687	21,100	
	12"	16,905	17,719	18,990	22,540	23,625	25,320	

1. The above values represent mean ultimate values and allowable working loads. The allowable working loads have been reduced using a safety factor of 4.0 for tension and 3.0 for shear , however, in some cases, such as life safety, safety factors of 10.0 or higher may be necessary. 2. Allowable loads must be checked against steel capacity. The lowest value controls.

3. Tabulated data is applicable to single anchors in normal weight concrete unaffected by edge or spacing reduction factors. V alues are valid for anchors installed into dry concrete in holes drilled with a hammer drill and ANSI carbide drill bit.

4. Service temperatures should remain approximately constant. The maximum long term temperature being 122°F and the maximum short term temperature being 176°F. Short term temperatures are those that occur over brief intervals, for example, diurnal cycling.

5. Linear interpolation is allowed.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



### Coverage

Anchor size:		(in.	)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Dia	ameter:	(in.	)	3/8	1/2	7/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in.	)	2 3/8	2 3/8	2 3/4	3 1/8	3 3/4	4	5
Estimated Number of Fixing *	Cartridge Volume	300	ml	83	47	53	15	9	5	2

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Dia	ameter:	(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in.)	3 1/8	3 3/4	5	6 1/4	7 1/2	10	12 1/2
Estimated Number of Fixing *	Cartridge Volume	300 ml	63	29	17	7	4	2	1

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Di	ameter:	(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in.)	3 3/4	4 1/2	6	7 1/2	9	12	15
Estimated Number of Fixing *	Cartridge Volume	300 ml	53	24	14	6	4	1	0

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

### Application

### Solid Substrate Installation Method

1. Drill the hole to the correct diameter and depth. This can be done with either a rotary percussion or rotary machine depending upon the substrate.

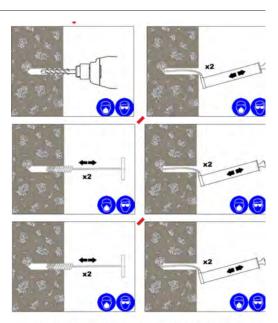
2. Thoroughly clean the hole in the following sequence using the 2K DF Brush with the required extensions and a source of clean compressed air. For holes of 15 3/4" (400mm) or less deep, a 2K Blow Pump may be used:

Blow Clean x2. Brush Clean x2. Blow Clean x2. Brush Clean x2. Blow Clean x2.

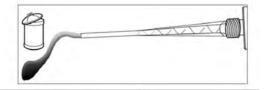
3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into a good quality applicator.

4. Extrude the first part of the cartridge to waste until an even color has been achieved without streaking in the resin.

5. If necessary, cut the extension tube to the depth of the hole and push onto the end of the mixer nozzle, and (for rebars 5/8" (16mm) dia. or more) fit the correct resin stopper to the other end. Attach extension tubing and resin stopper.



If the hole collects water after the initial cleaning, this water must be removed before injecting the resin.





6. Insert the mixer nozzle (resin stopper /extension tube if applicable) to the bottom of the hole. Begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately ½ to ¾ full and withdraw the nozzle completely.

7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time (see table on page 1).

8. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full.

This excess resin should be removed from around the mouth of the hole before it sets.

9. Leave the anchor to cure.

Do not disturb the anchor until the appropriate loading/curing time, on page 1, has elapsed depending on the substrate conditions and ambient temperature.

10. Attach the fixture and tighten the nut to the recommended torque.

Do not overtighten.

### Hollow Substrate Installation Method

1. Drill the hole to the correct diameter and depth. This should be done with a rotary percussion drilling machine to reduce spalling.

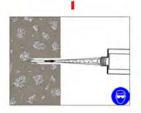
2. Thoroughly clean the hole in the following sequence using a brush with the required extensions and a source of clean compressed air. For holes of 15 3/4" (400mm) or less deep, a blow pump may be used:

Brush Clean x1. Blow Clean x1.

3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into a good quality applicator.

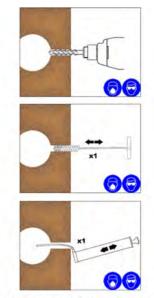
4. Extrude the first part of the cartridge to waste until an even color has been achieved without streaking in the resin.

5. Select the appropriate perforated sleeve and insert into the hole.









If the hole collects water after the initial cleaning, this water must be removed before injecting the resin.





6. Insert the mixer nozzle to the bottom of the perforated sleeve, withdraw 1/12" (2-3mm) then begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the perforated sleeve completely and remove the mixer nozzle and cartridge completely.

7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time (see table on page 1).

8. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full.

This excess resin should be removed from around the mouth of the hole before it sets.

9. Leave the anchor to cure.

Do not disturb the anchor until the appropriate loading/curing time, on page 1, has elapsed depending on the substrate conditions and ambient temperature.

10. Attach the fixture and tighten the nut to the recommended torque.

### Do not overtighten.

Limitations

### THE NTSB HAS STATED THAT THIS PRODUCT IS APPROVED FOR SHORT TERM LOADS ONLY AND SHOULD NOT BE USED IN SUSTAINED TENSILE LOAD ADHESIVE ANCHORING APPLICATIONS WHERE ADHESIVE FAILURE COULD RESULT IN A PUBLIC SAFETY RISK. CONSULT A DESIGN PROFESSIONAL PRIOR TO USE.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided on the product data sheet.

- Not for use in overhead applications.
- Not for use in cracked concrete.
- Minimum Application Temperature 14°F (-10°C)
- Maximum Application Temperature 86°F (30°C)

RIOR TO EACH USE OF ANY SIKA PRODUCT. THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED, KEEP OUT OF REACH OF CHILDREN, NOT FOR INTERNAL CONSUMPTION, FOR INDUSTRIAL USE ONLY, FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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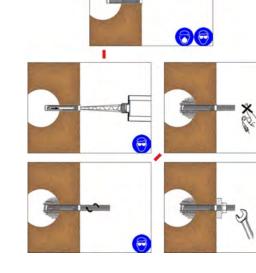
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C520

# Sikadur<sup>®</sup> AnchorFix-2

### High performance, two component adhesive anchoring system

Description	Sikadur <sup>®</sup> AnchorFix-2 adhesi two component adhesive an	5	, ,	0.						
Where to Use	<ul> <li>Uncracked concrete</li> <li>Hard natural stone</li> <li>Solid rock</li> <li>Solid masonry</li> </ul>	<ul> <li>Hard natural stone</li> <li>Solid rock</li> <li>Solid masonry</li> </ul>								
Advantages	<ul> <li>Versatile range of embedn</li> <li>Anchoring without expansion</li> </ul>	<ul> <li>Fixing close to free edges.</li> <li>Versatile range of embedment depths.</li> <li>Anchoring without expansion forces.</li> <li>Component volume ratio of 10:1.</li> <li>Extended working time.</li> </ul>								
Packaging	10.1 fl.oz. (300 ml) or 28.7 fl	.oz. (850 ml) cartridge								
Approvals	<ul> <li>EESR to AC308 by ICC-E</li> <li>ESR to AC308 by IAPMO-</li> <li>Certified to ANSI / NSF - 6</li> </ul>	UES Report #0327 for	threaded bars only.							
	MIXING METHODS AND	EQUIPMENT, TEMPERA AL SITE CONDITIONS AN	AL VARIATIONS DEPENDING FURE, APPLICATION METHO ID CURING CONDITIONS. tly, the shelf life will be 15 mon	DS,						
	Storage Conditions		e stored in their original packag 41°F to +77°F) out of direct su							
	Working & Loading Times	5								
	Working & Loading Times Cartridge Temperature	s T Work (minutes)	Base Material Temperature	T Load (hours)						
		1	Base Material Temperature +14°F to +32°F**	T Load (hours) 24 hours						
	Cartridge Temperature	T Work (minutes)	· · · · ·	. ,						

Solid rock Solid masonry										
Fixing close to free edges. Versatile range of embedm Anchoring without expansi Component volume ratio o Extended working time.	nent depths. on forces.									
0.1 fl.oz. (300 ml) or 28.7 fl.oz. (850 ml) cartridge										
EESR to AC308 by ICC-ES ESR to AC308 by IAPMO- Certified to ANSI / NSF - 6	UES Report #0327 for	threaded bars only.								
MIXING METHODS AND TEST METHODS, ACTUA	EQUIPMENT, TEMPERA	CAL VARIATIONS DEPENDING TURE, APPLICATION METHO ND CURING CONDITIONS.	DS,							
Shelf Life	manufacture.	ctly, the shelf life will be 15 mont	ns from the date of							
Storage Conditions	Cartridges should b	e stored in their original packag ⊧41°F to +77°F) out of direct sur								
Storage Conditions	Cartridges should to in cool conditions (									
	Cartridges should to in cool conditions (									
Working & Loading Times	Cartridges should b in cool conditions (	+41°F to +77°F) out of direct sur	nlight.							
Working & Loading Times Cartridge Temperature	Cartridges should to in cool conditions (- T Work (minutes)	+41°F to +77°F) out of direct sur	nlight. T Load (hours)							
Working & Loading Times Cartridge Temperature	Cartridges should to in cool conditions ( T Work (minutes) 12	Base Material Temperature +41°F to +32°F**	T Load (hours) 24 hours							
Working & Loading Times Cartridge Temperature Minimum +41°F	Cartridges should b in cool conditions ( T Work (minutes) 12 12	Base Material Temperature +41°F to +77°F) out of direct sur Base Material Temperature +14°F to +32°F** +32°F to +41°F	T Load (hours) 24 hours 180 minutes							
Working & Loading Times Cartridge Temperature Minimum +41°F +41°F to +50°F	Cartridges should b in cool conditions ( T Work (minutes) 12 12 8	Base Material Temperature +41°F to +77°F) out of direct sur Base Material Temperature +14°F to +32°F** +32°F to +41°F +41°F to +50°F	T Load (hours) 24 hours 180 minutes 100 minutes							
Working & Loading Times Cartridge Temperature Minimum +41°F +41°F to +50°F +50°F to +68°F	Cartridges should b in cool conditions ( T Work (minutes) 12 12 8 4	Base Material Temperature +14°F to +32°F** +32°F to +41°F +41°F to +50°F +50°F to +68°F	T Load (hours) 24 hours 180 minutes 100 minutes 70 minutes							

T Work is the typical time to gel at the highest temperature in the range T Load is the typical time to reach full capacity

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Installation Speci	fication										
Property	Sym- bol	Unit									
Threaded Rod Diameter	d <sub>a</sub>	in	5/16	3/8	1/2	5/8	3/4	1			
Drill Bit Diameter	d <sub>o</sub>	in	3/8	1/2	9/16	11/16	13/16	1-1/16			
Cleaning Brush Size	d <sub>b</sub>	in	0.5	551	0.7	787	1.1	142			
Minimum Embedment Depth	h <sub>ef,min</sub>	in	2-3/8	2-3/4	3-1/8	3-3/4	4	4			
Maximum Embedment Depth	h <sub>ef,max</sub>	in	6-1/4	7-1/2	10	12-1/2	15	20			
Minimum Con- crete Thickness	h <sub>min</sub>	in		-	1.	5 h <sub>ef</sub>					
Critical Anchor Spacing	S <sub>cr</sub>	in			2.0	) c <sub>ac</sub>					
Critical Edge Distance	C <sub>ac</sub>	in		$c_{ac} = h_{ef} * (t_{k, uncr} / 1160)^{0.4} * max[3.1 - 0.7(h / h_{ef}); 1.4]$							
Maximum Tightening Torque	T <sub>inst</sub>	ft.lb	7.5	15	25	55	80	120			

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

		1554 Grad	eel ASTM F e 36 (A307 .C)		eel ASTM A 3 B7	Stainless St 593	eel ASTM F CW	Stainless Steel ASTM F 593 SH		
	Diameter n)	Allowable Tension, Nall	Allowable Shear, Vall	Allowable Tension, Nall	Allowable Shear, Vall	Allowable Tension, Nai	Allowable Shear, Vall	Allowable Tension, Nail	Allowable Shear, Va⊫	
3/8"	lb	2,110	1,080	4,550	2,345	3,630	1,870	4,190	2,160	
3/0	kN	9.4	4.8	20.2	10.4	16.1	8.3	18.6	9.6	
1/2"	lb	3,750	1,930	8,100	4,170	6,470	3,330	7,450	3,840	
1/2	kN	16.7	8.6	36.0	18.5	28.8	14.8	33.1	17.1	
5/8"	lb	5,870	3,030	12,655	6,520	10,130	5,220	11640	6,000	
5/6	kN	26.1	13.5	56.3	29.0	45.1	23.2	51.8	26.7	
3/4"	lb	8,460	4,360	18,220	9,390	12,400	6,390	15,300	7,880	
3/4	kN	37.6	19.4	81.0	41.8	55.2	28.4	68.1	35.1	
7/8"	lb	11,500	5,930	24,800	12,780	16,860	8,680	20,830	10,730	
110	kN	51.2	26.4	110.3	56.8	75.0	38.6	92.7	47.7	
1"	lb	15,020	7,740	32,400	16,690	22,020	11,340	27,210	14,020	
I	kN	66.8	34.4	144.1	74.2	97.9	50.4	121.0	62.4	
1 1/4"	lb	23,480	12,100	50,610	26,070	34,420	17,730	38,470	19,820	
1 - 1/4"	kN	104.4	53.8	225.1	116.0	153.1	78.9	171.1	88.2	

Allowable Tension,  $N_{all} = 0.33 \times f_u \times nominal cross sectional area$  $Allowable Shear, <math>V_{all} = 0.17 \times f_u \times nominal cross section area$ \*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Allowable S	teel Streng	th for Rebar		Allowable St	eel Streng	th for Rebar	
		Carbon Steel ASTM A	615 Grade 60			Carbon Steel CAN/CS	SA-G30.18 Gr.400
Rebar	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{all}$	Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{all}$
#2	lb	3,280	1,690	4014	lb	4,016	2,069
#3	kN	14.6	7.5	10M	kN	17.9	9.2
	lb	5,831	3,004		lb	8,052	4,148
#4	kN	25.9	13.4	15M	kN	35.8	18.5
	lb	9,111	4,693	0014	lb	11,960	6,161
#5	kN	40.5	20.9	20M	kN	53.2	27.4
#0	lb	13,121	6,759	0514	lb	19,975	10,290
#6	kN	58.4	30.1	25M	kN	88.9	45.8
<i>4</i> 7	lb	17,859	9,200	0014	lb	28,121	14,486
#7	kN	79.4	40.9	30M	kN	125.1	64.4
#0	lb	23,326	12,016	0514	lb	40,089	20,652
#8	kN	103.8	53.4	35M	kN	178.3	91.9
#10	lb	37,623	19,381			cross sectional area	
#10	kN	167.4	86.2	Shear = 0.17 x f <sub>u</sub> *The design profe		oss section area le job is ultimately responsil	ble for the interpretati

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

1. Above values for reinforcing steel assume the design method is the same as a post-installed adhesive anchor, under the principles of anchor design (failure modes will be concrete breakout, pryout, steel failure, or adhesive bond) and not under the principles of reinforcing steel design (failure modes are typically splitting failure, inadequate bar development etc..). CONSULT AN ENGINEERING DESIGN PROFESSIONAL PRIOR TO USE.

of the data provided above.

Allowable Lo	ad Data in Tensie	on and Shear					
			Allow	able Concrete Ca	apacity / Bond Str	ength	
Anchor	Embedment		Tension (lb)			Shear (lb)	
Diameter	Depth	f' <sub>c</sub> = 2,500 psi	f' <sub>c</sub> = 4,000	f' <sub>c</sub> = 8,000	f' <sub>c</sub> = 2,500	f' <sub>c</sub> = 4,000	f' <sub>c</sub> = 8,000
	2-3/8"	1,390	1,457	1,562	1,854	1,943	2,082
5/16"	3-1/16"	1,793	1,879	2,014	2,390	2,505	2,685
	3-3/4"	2,195	2,301	2,466	2,927	3,068	3,288
	2-3/8"	1,507	1,579	1,693	2,009	2,106	2,257
3/8"	3-7/16"	2,181	2,286	2,450	2,908	3,048	3,266
	4-1/2"	2,855	2,992	3,207	3,806	3,990	4,276
	2-3/4"	2,397	2,513	2,693	3,197	3,350	3,591
1/2"	4-3/8"	3,814	3,998	4,285	5,085	5,330	5,713
	6"	5,231	5,482	5,876	6,974	7,310	7,835
	3-1/8"	3,065	3,212	3,443	4,087	4,283	4,591
5/8"	5-5/16"	5,210	5,461	5,853	6,947	7,281	7,804
	7-1/2"	7,356	7,710	8,263	9,808	10,280	11,017
	3-1/2"	3,495	3,663	3,926	4,659	4,884	5,234
3/4"	6-1/4"	6,240	6,541	7,010	8,320	8,721	9,347
	9"	8,986	9,418	10,094	11,981	12,558	13,459
	4"	5,378	5,637	6,042	7,171	7,516	8,056
1"	8"	10,757	11,274	12,084	14,342	15,033	16,112
	12"	16,135	16,912	18,125	21,514	22,549	24,167

1. The above values represent mean ultimate values and allowable working loads. The allowable working loads have been reduced using a safety factor of 4.0 for tension and 3.0 for shear, however, in some cases, such as life safety, safety factors of 10.0 or higher may be necessary. 2. Allowable loads must be checked against steel capacity. The lowest value controls.

3. Tabulated data is applicable to single anchors in normal weight concrete unaffected by edge or spacing reduction factors. Values are valid for anchors installed into dry concrete in holes drilled with a hammer drill and ANSI carbide drill bit. 4. Service temperatures should remain approximately constant. The maximum long term temperature being 122°F and the maximum short term temperature being 176°F. Short term

temperatures are those that occur over brief intervals, for example, diurnal cycling. 5. Linear interpolation is allowed.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



### Coverage

Anchor size:		(in.	)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Dia	ameter:	(in.	)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in.	)	2 3/8	2 3/8	2 3/4	3 1/8	3 3/4	4	5
Estimated	Cartridge	300	ml	83	47	32	15	9	5	2
Number of Fixing *	Volume	850	ml	254	143	97	48	29	16	8

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.	)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Dia	ameter:	(in.	)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in.	)	3 1/8	3 3/4	5	6 1/4	7 1/2	10	12 1/2
Estimated	Cartridge	300	ml	63	29	17	7	4	2	1
Number of Fixing *	Volume	850	ml	193	90	53	24	14	6	3

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)		5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Di	ameter:	(in	)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment	Depth:	(in	)	3 3/4	4 1/2	6	7 1/2	9	12	15
Estimated	Cartridge	300	ml	53	24	14	6	4	1	0
Number of Fixing *	Volume	850	ml	161	75	44	20	12	5	2

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

### Application

### Solid Substrate Installation Method

1. Drill the hole to the correct diameter and depth. This can be done with either a rotary percussion or rotary hammer drilling machine depending upon the substrate.

2. Thoroughly clean the hole in the following sequence using the 2K DF Brush with the required extensions and a source of clean compressed air. For holes of 15 3/4" (400mm) or less deep, a 2K Blow Pump may be used:

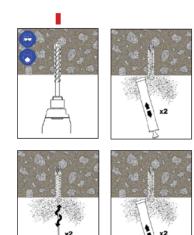
Blow Clean x2. Brush Clean x2. Blow Clean x2. Brush Clean x2. Blow Clean x2.

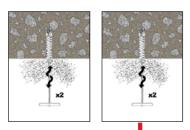
3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil pack and screw nozzle onto the mouth of the cartridge. Insert the cartridge into a good quality applicator.

4. Extrude the first part of the cartridge (at least dispense three full strokes) to waste until an even color has been achieved without streaking in the resin before injecting the resin into the drilled hole.

5. If necessary, cut the extension tube to the depth of the hole and push onto the end of the mixer nozzle, and (for rebars 8" (16mm) dia. or more) fit the correct resin stopper to the other end. Attach extension tubing and resin stopper.

6. Insert the mixer nozzle (resin stopper/extension tube if applicable) to the bottom of the hole. Begin





hole collects water after the initial cleaning, this r must be removed before injecting the resin.



to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately 1/2 to 3/4 full and withdraw the nozzle completely.

7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time (see table on page 1).

8. Any excess resin will be expelled from the hole evenly around the steel element showing that the hole is full. This excess resin should be removed from around the mouth of the hole before it sets.

9 Leave the anchor to cure

Do not disturb the anchor until the appropriate loading time, on page 1, has elapsed depending on the substrate conditions and ambient temperature.

10. Attach the fixture and tighten the nut to the recommended torque.

Do not overtighten as it could adversely affect product performance.

NOTE: Please refer to figure 5A & 5B of the IAPMO Report No. 0327 for detailed installation instructions.

Limitations

THE NTSB HAS STATED THAT THIS PRODUCT IS APPROVED FOR SHORT TERM LOADS ONLY AND SHOULD NOT BE USED IN SUSTAINED TENSILE LOAD ADHESIVE ANCHORING APPLICATIONS WHERE ADHESIVE FAILURE COULD RESULT IN A PUBLIC SAFETY RISK. CONSULT A DESIGN PROFESSIONAL PRIOR TO USE.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided on the product data sheet.

- Not for use in overhead applications.
- Not for use in cracked concrete.
- Please refer to section 5.0 for conditions of use in the IAPMO Evaluation Report #0327. This report is available on Sika and IAPMO's websites.
- Minimum Application Temperature 14°F (-10°C)
- Maximum Application Temperature 86°F (30°C)

RIOR TO EACH USE OF ANY SIKA PRODUCT. THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET. PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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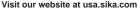
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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

C.P. 76920

Fax: 52 442 2250537



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Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

Note for decreased installation temperature: When

installing EASF at decreased installation temperature  $(+32^{\circ}F < T < 50^{\circ}F (0^{\circ}C < T < +10^{\circ}C))$  the cartridge must

The RM nozzle consists of two pieces: the component containing the mixer elements, and an extension piece. The extension piece must be snapped off the component contain-

ing the mixer elements before use. The two pieces are then

pushed together until a positive engagement is felt.

be conditioned to  $+68^{\circ}F(+20^{\circ}C)$ 

Note for use of RM nozzle:







## Sika<sup>®</sup> AnchorFix-2 Arctic

# High performance, two component, low temperature adhesive anchor system

Description	Sika® AnchorFix-2 Arctic adhesive anchor system has been specifically formulated as a high performance, two component, low temperature adhesive anchor system for threaded bars in uncracked concrete.
Where to Use	<ul> <li>Uncracked concrete</li> <li>Hard natural stone</li> <li>Solid rock</li> <li>Solid masonry</li> </ul>
Advantages	<ul> <li>Fixing close to free edges.</li> <li>Versatile range of embedment depths.</li> <li>Anchoring without expansion forces.</li> <li>Component volume ratio of 1:1.</li> <li>Extended working time.</li> </ul>
Packaging	28.7 fl.oz. (850 ml) cartridge
Approval	European Technical Approval (ETA) according to ETAG001-5.

### **Typical Data**

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	When stored correctly, the shelf life will be for a minimum of 12 months from the date of manufacture.
Storage Conditions	Cartridges should be stored in their original packaging, the correct way up, in cool conditions (+32°F to +77°F) out of direct sunlight.

Working & Loading Time	Working & Loading Times								
Cartridge Temperature	T Work (minutes)	Base Material Temperature	T Load						
Minimum +23°F	15	-14.8°F - +14°F*	36 hours						
	15	+14°F to +23°F	12 hours						
	15	+23°F to +32°F	100 minutes						
+23°F to +41°F	10	+32°F to +41°F	75 minutes						
+41°F to +50°F	5	+41°F to +50°F	50 minutes						
+50°F to +68°F	2.5	+50°F to +68°F	50 minutes						
+68°F	100 seconds	+68°F	20 minutes						
T Work is the typical time to g	el at the highest temperature i	n the range							

T Load is the typical time to reach full capacity

\*This application is not covered by the scope of the ETA or any other approval for this product. \*\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Installation Specifica	Installation Specification									
Property	Symbol	Unit								
Threaded Rod Diameter	d <sub>a</sub>	in	5/16	3/8	1/2	5/8	3/4	1	1-1/4	
Drill Bit Diameter	d。	in	3/8	1/2	9/16	11/16	13/16	1-1/16	1-1/2	
Cleaning Brush Size	d <sub>b</sub>	in	0.5	551	0.	787	1.1	142	1-2/3	
Minimum Embedment Depth	h <sub>ef,min</sub>	in	2-1/2	3	4	5	6	8	10	
Maximum Embedment Depth	h <sub>ef,max</sub>	in	6-1/4	7-1/2	10	12-1/2	15	20	25	
Minimum Concrete Thickness	h <sub>min</sub>	in		h <sub>ef</sub> + 1-1/	/4 in ≥ 4 in			h <sub>ef</sub> + 2 do		
Critical Anchor Spacing	S <sub>cr</sub>	in				3.0 h <sub>ef</sub>				
Critical Edge Distance	C <sub>ac</sub>	in	1.5 h <sub>et</sub>							
Maximum Tightening Torque	T <sub>inst</sub>	ft.lb	7.5	15	25	55	80	120	200	

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

Allowab	le Steel S	trength for Th	readed Rods						
		Carbon Steel ASTM F 1554 Grade 36 (A307 Gr.C)			Carbon Steel ASTM A 193 B7		ss Steel 593 CW	Stainless Steel ASTM F 593 SH	
Anchor Diameter (in)		Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>
3/8"	lb	2,110	1,080	4,550	2,345	3,360	1,870	4,190	2,160
3/6	kN	9.4	4.8	20.2	10.4	16.1	8.3	18.6	9.6
1/2"	lb	3,750	1,930	8,100	4,170	6,470	3,330	7,450	3,840
1/2	kN	16.7	8.6	36.0	18.5	28.8	14.8	33.1	17.1
5/8"	lb	5,870	3,030	12,655	6,520	10,130	5,220	11,640	6,000
5/6	kN	26.1	13.5	56.3	29.0	45.1	23.2	51.8	26.7
3/4"	lb	8,460	4,360	18,220	9,390	12,400	6,390	15,300	7,880
3/4	kN	37.6	19.4	81.0	41.8	55.2	28.4	68.1	35.1
7/0"	lb	11,500	5,930	24,800	12,780	16,860	8,680	20,830	10,730
7/8"	kN	51.2	26.4	110.3	56.8	75.0	38.6	92.7	47.7
1"	lb	15,020	7,740	32,400	16,690	22,020	11,340	27,210	14,020
1.	kN	66.8	34.4	144.1	74.2	97.9	50.4	121.0	62.4
1 1/4"	lb	23,480	12,100	50,640	26,070	34,420	17,730	38,470	19,820
1 - 1/4"	kN	104.4	53.8	225.1	116.0	153.1	78.9	171.1	88.2

Allowable Tension, N<sub>ail</sub> =  $0.33 \times f_u \times nominal cross sectional area.$  $Allowable Shear, V<sub>ail</sub> = <math>0.17 \times f_u \times nominal cross section area.$ \*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Allowable S	teel Streng	th for Rebar		Allowable St	eel Streng	th for Rebar		
		Carbon Steel ASTM A	615 Grade 60	Carbon Steel CAN			/CSA-G30.18 Gr.400	
Rebar	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{all}$	Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	
#3	lb	3,280	1,690	10M	lb	4,016	2,069	
#3	kN	14.6	7.5		kN	17.9	9.2	
#4	lb 5,831 3,004 15M	lb	8,052	4,148				
#4	kN	25.9	13.4	10101	kN	35.8	18.5	
#5	lb	9,111	4,693	0014	lb	11,960	6,161	
#5	kN	40.5	20.9	20M	kN	53.2	27.4	
#0	lb	13,121	6,759	0514	lb	19,975	10,290	
#6	kN	58.4	30.1	25M	kN	88.9	45.8	
47	lb	17,859	9,200	0014	lb	28,121	14,486	
#7	kN	79.4	40.9	30M	kN	125.1	64.4	
#8	lb	23,326	12,016	0514	lb	40,089	20,652	
#0	kN	103.8	53.4	35M	kN	178.3	91.9	
#10	lb	37,623	19,381	Tension = 0.33 x f	x nominal o	cross sectional area	•	
#10	kN	167.4	86.2	Shear = 0.17 x f x nominal cross section area *The design professional on the job is ultimately responsible for the interpre				

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

interpretation of the data provided above. 1. Above values for reinforcing steel assume the design method is the same as a post-installed adhesive anchor, under the principles of anchor design (failure modes will be concrete breakout, pryout, steel failure, or adhesive bond) and not under the principles of reinforcing steel design (failure modes are typically splitting failure, inadequatebar development etc..). CONSULT AN ENGINEERING DESIGN PROFESSIONAL PRIOR TO USE.

of the data provided above.

Anchor	Embedment	Allowable Concrete Capacity / Bond Strength							
diameter	Depth	Tension (Ib)			Shear (Ib)				
		f' <sub>c</sub> = 2,500 psi	f' <sub>c</sub> = 4,000 psi	f' <sub>c</sub> = 8,000 psi	f' <sub>c</sub> = 2,500 psi	f' <sub>c</sub> = 4,000 psi	f' <sub>c</sub> = 8,000 psi		
	2-1/2"	1,517	1,590	1,704	2,022	2,120	2,272		
5/16"	3-1/8"	1,896	1,987	2,130	2,528	2,650	2,840		
	3-3/4"	2,275	2,385	2,556	3,033	3,179	3,408		
	3"	1,785	1,871	2,005	2,380	2,494	2,673		
3/8"	3-3/4"	2,231	2,338	2,506	2,975	3,118	3,342		
	4-1/2"	2,677	2,806	3,007	3,570	3,741	4,010		
	4"	3,276	3,434	3,680	4,368	4,578	4,907		
1/2"	5"	4,095	4,292	4,600	5,460	5,723	6,134		
	6"	4,914	5,151	5,520	6,552	6,867	7,360		
	5"	5,427	5,688	6,096	7,236	7,584	8,128		
5/8"	6-1/4"	6,784	7,110	7,620	9,045	9,480	10,160		
	7-1/2"	8,140	8,532	9,144	10,854	11,376	12,193		
	6"	6,801	7,128	7,640	9,068	9,505	10,187		
3/4"	7-1/2"	8,501	8,911	9,550	11,335	11,881	12,733		
	9"	10,202	10,693	11,460	13,602	14,257	15,280		
	8"	11,270	11,812	12,660	15,027	15,750	16,880		
1"	10"	14,088	14,766	15,825	18,783	19,687	21,100		
	12"	16,905	17,719	18,990	22,540	23,625	25,320		

1. The above values represent mean ultimate values and allowable working loads. The allowable working loads have been reduced using a safety factor of 4.0 for tension and 3.0 for shear, however, in some cases, such as life safety, safety factors of 10.0 or higher may be necessary.

Allowable loads must be checked against steel capacity. The lowest value controls.

3. Tabulated data is applicable to single anchors in normal weight concrete unaffected by edge or spacing reduction factors. Values are valid for anchors installed into dry concrete in holes drilled with a hammer drill and ANSI carbide drill bit.

4. Service temperatures should remain approximately constant. The maximum long term temperature being 122°F and the maximum short term temperature being 176°F. Short term temperatures are those that occur over brief intervals, for example, diurnal cycling.

5. Linear interpolation is allowed.

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### Coverage

Anchor size:		(in.)	5/16	3/18	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	2 3/8	2 3/8	2 3/4	3 1/8	3 3/4	4	5
Estimated Number of Fixing *	Cartridge Volume	850 ml	254	143	97	48	29	16	8

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	3 1/8	3 3/4	5	6 1/4	7 1/2	10	12 1/2
Estimated Number of Fixing *	Cartridge Volume	850 ml	193	90	53	24	14	6	3

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	3 3/4	4 1/2	6	7 1/2	9	12	15
Estimated Number of Fixing *	Cartridge Volume	850 ml	161	75	44	20	12	5	2

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

#### Application

### Installation Method (Solid Substrates)

1. Drill the hole to the correct diameter and depth. This can be done with either a rotary percussion or rotary machine depending upon the substrate.

2. Thoroughly clean the hole in the following sequence using a brush with the required extensions and a source of clean compressed air. For holes of 15.8 in. (400mm) or less deep, a Blow Pump may be used:

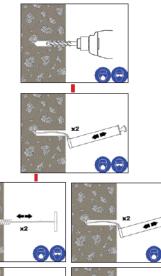
Blow Clean x2. Brush Clean x2. Blow Clean x2. Brush Clean x2. Blow Clean x2.

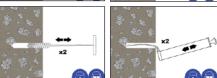
3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into a good quality applicator.

4. Extrude the first part of the cartridge (at least dispense three full strokes) to waste until an even color has been achieved without streaking in the resin before injecting the resin into the drilled hole.

5. If necessary, cut the extension tube to the depth of the hole and push onto the end of the mixer nozzle, and (for rebars .6 in. dia. or more) fit the correct resin stopper to the other end. Attach extension tubing and resin stopper.

6. Insert the mixer nozzle (resin stopper / extension tube if applicable) to the bottom of the hole. Begin to extrude the resin and slowly withdraw the mixer





If the hole collects water after the initial cleaning, this water must be removed before injecting the resin.



nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately  $\frac{1}{2}$  to  $\frac{3}{4}$  full and withdraw the nozzle completely.

7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time (see table on page 4).

8. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full.

This excess resin should be removed from around the mouth of the hole before it sets.

9. Leave the anchor to cure.

Do not disturb the anchor until the appropriate loading/ curing time, on page 4, has elapsed depending on the substrate conditions and ambient temperature.

10. Attach the fixture and tighten the nut to the recommended torque, **do not overtighten**.

### Hollow Substrate Installation Method

1. Drill the hole to the correct diameter and depth. This should be done with a rotary percussion drilling machine to reduce spalling.

2. Thoroughly clean the hole in the following sequence using the 2K DF Brush with the required extensions and a source of clean compressed air. For holes of 15.6 in. (400mm) or less deep, a Blow Pump may be used:

Brush Clean x1. Blow Clean x1.

3. Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into a good quality applicator.

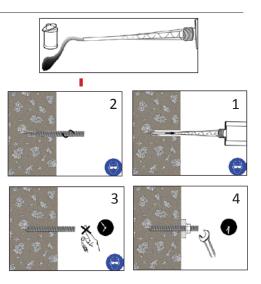
4. Extrude the first part of the cartridge (at least dispense three full strokes) to waste until an even color has been achieved without streaking in the resin before injecting the resin into the drilled hole.

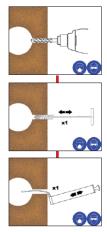
5. Select the appropriate perforated sleeve and insert into the hole.

6. Insert the mixer nozzle to the bottom of the perforated sleeve, withdraw 0.07 - 0.1 in. (2-3mm) then begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the perforated sleeve completely and remove the mixer nozzle and cartridge completely.

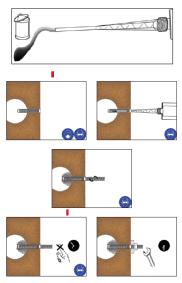
7. Insert the clean threaded bar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time (see table on page 1).

8. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full.





If the hole collects water after the initial cleaning, this water must be removed before injecting the resin.





	mouth of the hole before it sets.
	9. Leave the anchor to cure.
	Do not disturb the anchor until the appropriate loading/ curing time, on page 4, has elapsed depending on the substrate conditions and ambient temperature.
	10. Attach the fixture and tighten the nut to the recommended torque, <b>do not overtighten.</b>
Limitations	THE NTSB HAS STATED THAT THIS PRODUCT IS APPROVED FOR SHORT TERM LOADS ONLY AND SHOULD NOT BE USED IN SUSTAINED TENSILE LOAD ADHESIVE ANCHORING APPLICATIONS WHERE ADHESIVE FAILURE COULD RESULT IN A PUBLIC SAFETY RISK. CONSULT A DESIGN PROFESSIONAL PRIOR TO USE.
	*The design professional on the job is ultimately responsible for the interpretation of the data provided on the product data sheet.
	<ul> <li>Not for use in overhead applications.</li> <li>Not for use in cracked concrete.</li> <li>Minimum Application Temperature -14.8°F (-26°C)</li> <li>Maximum Application Temperature 68°F (20°C)</li> </ul>

This excess resin should be removed from around the

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

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RESPONSIBLE CARE

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Ŵ



Product Data Sheet Edition 1.21.2016 Identification no. C420 Sikadur® AnchorFix 500

# Construction

## Sika<sup>®</sup> AnchorFix 500 High Performance, two component adhesive anchor system

Description	Sika <sup>®</sup> AnchorFix 500 adhee component adhesive anch transport applications.						
Where to Use	<ul> <li>Adhesive anchoring an</li> <li>As a pick-proof sealant hospitals, and other inst</li> </ul>	around windows, do			cilities, schools,		
Advantages	<ul> <li>Fixing close to free edg</li> <li>Versatile range of embe</li> <li>Anchoring without expa</li> <li>Component volume rat</li> <li>Extended working time</li> </ul>	edment depths. ansion forces. io of 1:1.					
Packaging	20 & 55 fl. oz. cartridges.						
Testing	Sika AnchorFix-500 has bee Types I, II and IV, Grade 3, Typical Data RESULTS MAY DIFFER BASE TEMPERATURE, APPLICATIO	Class C.	RIATIONS DEPENDING U	PON MIXING METHODS A	ND EQUIPMENT,		
	Shelf Life	When stored corre manufacture.	ctly, the shelf life will b	e for 24 months from th	e date of		
	Storage Conditions	S Cartridges should be stored in their original packaging, the correct way up, in cool conditions (+50°F to +77°F) out of direct sunlight.					
	Working & I	Loading Times		·	]		
	Cartridge Ter	mperature	T Work (minutes)	T Load (hours)			

Cartridge Temperature	T Work (minutes)	T Load (hours)	
+50°F	75	24	
+68°F	30	8 4 4	
+86°F	15		
+104°F	7.5		
T Work is the typical time to gel at the high T Load is the typical time to reach full capa		ge	

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Typical Physical Properties		
Property	Result	Method
Consistency	Pass	ASTM C 881
Gel Time	30 minutes	ASTM C 881
Bond Strength (2 day cure)	2000 psi	ASTM C 882
Bond Strength (14 day cure)	2500 psi	ASTM C 882
Compressive Strength (7 day)	>10,000 psi	ASTM D 695
Compressive Modulus (7 days)	400000 psi	ASTM D 695
Water Absorption	0.08%	ASTM D 570
Heat Deflection Temperature	122°F	ASTM D 468
Linear Coefficient of Shrinkage	0.0003 in/in	ASTM D 2566
Shore D Hardness	80-85	ASTM D 2240

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

Installation Speci	fication								
Property	Sym- bol	Unit							
Threaded Rod Diameter	d <sub>a</sub>	in	3/8	1/2	5/8	3/4	7/8	1	1-1/4
Drill Bit Diameter	d <sub>o</sub>	in	1/2	9/16	3/4	7/8	1	1-1/8	1-3/8
Cleaning Brush Size	d <sub>b</sub>	-	S14H/F	S16H/F	S22H/F	S24H/F	S27H/F	S31H/F	S38H/F
Rebar Size	d <sub>a</sub>	in	#3	#4	#5	#6	#7	#8	#10
Drill Bit Diameter	d <sub>o</sub>	in	9/16	5/8	3/4	7/8	1	1-1/8	1-3/8
Cleaning Brush Size	d <sub>b</sub>	-	S16H/F	S18H/F	S22H/F	S27H/F	S31H/F	S35H/F	S43H/F
Minimum Embedment Depth	h <sub>ef,min</sub>	in	3	4	5	6	7	8	10
Maximum Embedment Depth	h <sub>ef,max</sub>	in	4 1/2	6	7 1/2	9	10 1/2	12	15
Minimum Con- crete Thickness	h <sub>min</sub>	in				2.0 h <sub>ef</sub>			
Critical Anchor Spacing	S <sub>cr</sub>	in				2.0 c <sub>ac</sub>			
Critical Edge Distance	C <sub>ac</sub>	in	$c_{ac} = h_{ef} * (t_{k,uncr} / 1160)^{0.4} * max[3.1 - 0.7(h / h_{ef}); 1.4]$						
Maximum Tightening Torque	T <sub>inst</sub>	ft.lb	15	30	60	100	125	150	200

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Allowable	Steel Strer	gth for Threa	ded Rods						
		Carbon Ste 1554 Grade Gr.	e 36 (A307		eel ASTM A B7	Stainless St 593		Stainless St 593	eel ASTM F SH
Anchor Dia	ameter (in)	Allowable Tension, Nall	Allowable Shear, Vall	Allowable Tension, Nall	Allowable Shear, Vall	Allowable Tension, Nall	Allowable Shear, Vall	Allowable Tension, Nall	Allowable Shear, Vall
3/8"	lb	2,110	1,080	4,550	2,345	3,630	1,870	4,190	2,160
3/0	kN	9.4	4.8	20.2	10.4	16.1	8.3	18.6	9.6
1/2"	lb	3,750	1,930	8,100	4,170	6,470	3,330	7,450	3,840
1/2"	kN	16.7	8,6	36.0	18.5	28.8	14.8	33.1	17.1
E /0"	lb	5,870	3.030	12,655	6,520	10,130	5,220	11,640	6,000
5/8"	kN	26.1	13,5	56.3	29.0	45.1	23.2	51.8	26.7
3/4"	lb	8,460	4.360	18,220	9,390	12,400	6,390	15,300	7,880
3/4	kN	37.6	19.4	81.0	41.8	55.2	28.4	68.1	35.1
7/0"	lb	11,500	5,930	24,800	12,780	16,860	8,680	20,830	10,730
7/8"	kN	51.2	26.4	110.3	56.8	75.0	38.6	92.7	47.7
4.11	lb	15,020	7,740	32,400	16,860	22,020	11,340	27,210	14,020
1"	kN	66.8	34.4	144.1	74.2	97.9	50.4	121.0	62.4
1 1/4"	lb	23,480	12,100	50,610	26,070	34,420	17,730	38,470	19,820
1 - 1/4"	kN	104.4	53.8	225.1	116.0	153.1	78.9	171.1	88.2

Allowable Tension,  $N_{all} = 0.33 \times f_u x$  nominal cross sectional area Allowable Shear,  $V_{all} = 0.17 \times f_u x$  nominal cross section area \*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

Allowable St	eel Strengt	h for Rebar		Allowable Ste	eel Strengt	h for Rebar				
		Carbon Steel ASTM A	615 Grade 60			Carbon Steel CAN/CS	A-G30.18 Gr.400			
Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>			
#3	lb	3,280	1,690		lb	4,016	2,069			
#5	kN	14.6	7.5	10M	kN	17.9	9.2			
#4	lb	5,831	3,004		lb	8,052	4,148			
#4	kN	25.9	13.4	15M	kN	35.8	18.5			
#5	lb	9,111	4,693		lb	11,960	6,161			
#5	kN	40.5	20.9	20M	kN	53.2	27.4			
#6	lb	13,121	6,759		lb	19,975	10,290			
#0	kN	58.4	30.1	25M	kN	88.9	45.8			
#7	lb	17,859	9,200		lb	28,121	14,486			
#7	kN	79.4	40.9	30M	kN	125.1	64.4			
#8	lb	23,326	12,016		lb	40,089	20,652			
#8	kN	103.8	53.4	35M	kN	178.3	91.9			
#10	lb	37,623	19,381	Tension = 0.33	xfxnom	inal cross sectional are	a			
#10	kN	167.4	86.2	Tension = $0.33 \text{ x} f_u \text{ x}$ nominal cross sectional area Shear = $0.17 \text{ x} f_u \text{ x}$ nominal cross section area						

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

The design professional on the job is ultimately responsible for the interpretation of the data provided above.

1. Above values for reinforcing steel assume the design method is the same as a post-installed adhesive anchor, under the principles of anchor design (failure modes will be concrete breakout, pryout, steel failure, or adhesive bond) and not under the principles of reinforcing steel design (failure modes are typically splitting failure, inadequate bar development etc.). CONSULT AN ENGINEERING DESIGN PROFESSIONAL PRIOR TO USE.



### Coverage

Anchor size	:	(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	2 3/8	2 3/8	2 3/4	3 1/8	3 3/4	4	5
Estimated	Cartridge	600 ml	176	99	67	33	20	11	6
Number of Fixing *	Volume	1500 ml	455	256	175	86	53	30	16

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	3 1/8	3 3/4	5	6 1/4	7 1/2	10	12 1/2
Estimated	Cartridge	600 ml	134	62	37	16	10	4	2
Number of Fixing *	Volume	1500 ml	346	162	96	43	26	12	6

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

### Application

### Installation Method (Solid Substrates)

1. Drill hole to required depth using a hammer drill with the drill bit that is appropriate to match the hole diameter as stated.

2. Insert the air lance to the bottom of the hole and depress the trigger for 2 seconds. The compressed air used should be at a minimum pressure of 6bar / 90psi and should be free from oil and / or water. Repeat the operation. If using the hand pump, give two blowing operations.

3. Select the correct size brush (see page 9, Installation Accessories). Ensure that the brush is in good condition and check that the diameter of the brush is correct for the size of the drilled hole. Insert the brush to the bottom of the hole and pull out using a back and forth twisting motion. Repeat the operation.

- 4. Repeat 2
- 5. Repeat 3
- 6. Repeat 2

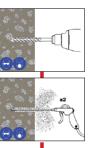
7. Select the appropriate static mixer nozzle for the installation and screw onto the mouth of the cartridge. Insert the cartridge into a good quality extrusion gun after checking that the extrusion gun is in good working order.

8. Extrude the first part of the cartridge to waste until an even colour has been achieved without streaking in the resin.

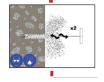
9. If necessary, attach extension tubing and resin stopper.

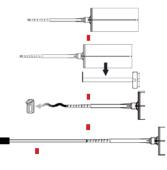
10. Insert the mixer nozzle to the bottom of the hole. Begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately  $\frac{1}{2}$  to  $\frac{3}{4}$  full and remove the mixer nozzle and cartridge completely.

11. Take the steel element of the anchor. This should be









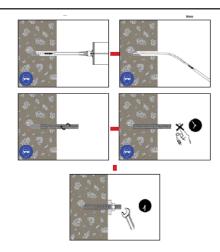


free from oil or other release agents. Insert the steel element to the bottom of the hole using a back and forth twisting motion. Any excess resin should be expelled from the hole evenly around the steel element.

12. Clean any excess resin from around the mouth of the hole.

13. Leave the anchor to cure. Do not disturb the anchor until the appropriate working time has elapsed depending on the substrate conditions and ambient temperature.

14. Attach the fixture as required.



### **Overhead Substrate Installation Method**

1. Using the SDS Hammer Drill with a carbide tipped drill bit of the appropriate size, drill the hole to suit the anchor.

2. a) Select the correct Air Lance, insert to the bottom of the hole and depress the trigger for 2 seconds. The compressed air must be clean – free from water and oil – and at a minimum pressure of 90psi (6bar). Perform the blowing operation twice.
b) If a Manual Pump is to be used, complete the blowing operation as above using the full stroke of the pump and blow the hole clean twice.

3. Select the correct size Hole Cleaning Brush. Ensure that the brush is in good condition and the correct diameter. Insert the brush to the bottom of the hole and withdraw with a twisting motion. There should be positive interaction between the steel bristles of the brush and the sides of the drilled hole. Perform the brushing operation twice.

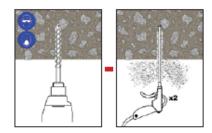
4. Repeat 2 (a) or (b)

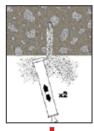
5. Repeat 3

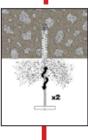
6. Repeat 2 (a) or (b)

7. Select the appropriate static mixer nozzle and attach to the cartridge. Check the Dispensing Tool is in good working order. Place the cartridge into the dispensing tool.

Note: The QH nozzle is in two sections. One section contains the mixing elements and the other section is an extension piece. Connect the extension piece







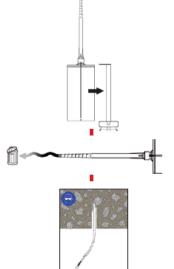


to the mixing section by pushing the two sections firmly together until a positive engagement is felt.

8. Extrude some resin to waste until an even-colored mixture is extruded. The cartridge is now ready for use.

9. As specified in the Installation Accessories Table, attach an extension tube with resin stopper (if required) to the end of the mixing nozzle with a push fit. (The extension tubes may be pushed into the resin stoppers and are held in place with a coarse internal thread).

10. Insert the mixing nozzle to the bottom of the hole. Extrude the resin and slowly withdraw the nozzle from the hole. Ensure no air voids are created as the nozzle is withdrawn. Inject resin until the hole is approximately 3/4 full and remove the nozzle from the hole.





Limitations

THE NTSB HAS STATED THAT THIS PRODUCT IS APPROVED FOR SHORT TERM LOADS ONLY AND SHOULD NOT BE USED IN SUSTAINED TENSILE LOAD ADHESIVE ANCHORING APPLICATIONS WHERE ADHESIVE FAILURE COULD RESULT IN A PUBLIC SAFETY RISK. CONSULT A DESIGN **PROFESSIONAL PRIOR TO USE.** 

Do not use in expansion (i.e. moving) joints.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided on the product data sheet

RIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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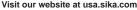
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation

201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 hone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

RESPONSIBLE CARE





## **Sika® AnchorFix-3001** High performance, 2 component adhesive anchor system use in cracked & uncracked concrete

<b>-</b>											
Description				ed as a high performance, tw n both cracked and uncracke							
Where to Use	<ul> <li>Cracked &amp; uncracked co</li> <li>Hard natural stone</li> </ul>	ncrete									
	<ul> <li>Flatd flatdrai stone</li> <li>Solid rock</li> </ul>										
	<ul> <li>Solid masonry</li> </ul>										
Advantages	Fixing close to free edge	S									
	Versatile range of embed										
Anchoring without expansion forces											
Packaging	20.2 fl. oz. (600 ml) or 50.7 f	fl. oz. (1500 ml) cartri	dges								
Approvals	ESR to AC308 by ICC-E	· /									
	Certified to ANSI /NSF -			pe I, IV, Class C, Grade 3							
	Typical Data										
	••	UPON STATISTICAL VARIA	ATIONS DEPENDING UPON MIX	ING METHODS AND EQUIP-							
	MENT, TEMPERATURE, APPLIC TIONS.	ATION METHODS, TEST N	IETHODS, ACTUAL SITE CONDI	TIONS AND CURING CONDI-							
	Shelf Life	When stored corre date of manufactu	ectly, the shelf life will be for	or 24 months from the							
	Storage Conditions	U U	be stored in their original nditions (+50°F to +77°F)								
				C C							
	Working & Loading Ti	mes									
	Cartridge Temperature	T Work (minutes)	Base Material Temperature	T Load (hours)							
		00	+40°F to +49°F	24							
	+50°F to +59°F	20	+50°F to +59°F	12							
	+59°F to +72°F	15	+59°F to +72°F	8							
	+72°F to +77°F	11	+72°F to +77°F	7							
	+77°F to +86°F	8	+77°F to +86°F	6							
	+86°F to +95°F	6	+86°F to +95°F	5							
	+95°F to +104°F	4	+95°F to +104°F	4							
	+104°F	3	+104°F	3							
	T Work is th	e typical time to gel a	at the highest temperature	in the range							

T Load is the typical time to reach full capacity

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Physical Properties			
Property	Result	Method	
Consistency	Pass	ASTM C 881	
Gel Time	10 minutes**	ASTM C 881	
Bond Strength (2 day cure)	2,500 psi	ASTM C 882	
Bond Strength (14 day cure)	2,700 psi	ASTM C 882	
Compressive Strength (7 day)	>13,000 psi	ASTM D 695	
Compressive Modulus (7 days)	420,000 psi	ASTM D 695	
Water Absorption	0.08%	ASTM D 570	
Heat Deflection Temperature	122°F	ASTM D 468	
Linear Coefficient of Shrinkage	0.0003 in/in	ASTM D 2566	

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above. \*\*Note: Per section 5.2 "The purchaser may specify a minimum gel time of 5 minutes for Types I and IV when automatic proportioning, mixing and dispensing equipment are used."

Installation Sp	ecificatio	n							
Property	Symbol	Unit							
Threaded Rod Diameter	d <sub>a</sub>	in	3/8	1/2	5/8	3/4	7/8	1	1-1/4
Drill Bit Diameter	d <sub>o</sub>	in	1/2	9/16	3/4	7/8	1	1-1/8	1-3/8
Cleaning Brush Size	d <sub>b</sub>	-	S14H/F	S16H/F	S22H/F	S24H/F	S27H/F	S31H/F	S38H/F
Nozzle Type	-	-	Q	Q	Q /QH	QH	QH	QH	QH
Extension Tube Required?	-	-	Y1 > 3.5" h <sub>ef</sub>	Y1 > 3.5" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>
Resin Stopper Required?	-	-	NO	NO	RS18 > 10" h <sub>ef</sub>	RS18 > 10" h <sub>ef</sub>	RS22 > 10" h <sub>ef</sub>	RS22 > 10" h <sub>ef</sub>	RS30 > 10" h <sub>ef</sub>
Rebar Size	d <sub>a</sub>	in	#3	#4	#5	#6	#7	#8	#10
Drill Bit Diameter	d <sub>。</sub>	in	9/16	5/8	3/4	7/8	1	1-1/8	1-3/8
Cleaning Brush Size	d <sub>b</sub>	-	S16H/F	S18H/F	S22H/F	S27H/F	S31H/F	S35H/F	S43H/F
Nozzle Type	-	-	Q	Q	Q /QH	QH	QH	QH	QH
Extension Tube Required?	-	-	Y1 > 3.5" h <sub>ef</sub>	Y1 > 3.5" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>	Y2 > 10" h <sub>ef</sub>
Resin Stopper Required?	-	-	NO	NO	RS18 > 10" h <sub>ef</sub>	RS18 > 10" h <sub>ef</sub>	RS22 > 10" h <sub>ef</sub>	RS22 > 10" h <sub>ef</sub>	RS30 > 10" h <sub>ef</sub>
Maximum Tight- ening Torque	T <sub>inst</sub>	ft.lb	15	30	60	100	125	150	200

Y1 - requires 3/8" diameter extension tube fitted to Q nozzle

Y2 requires 9/16" diameter extension tube fitted to QH nozzle

RS22 - use 22mm diameter resin stopper

RS30 - use 30mm diameter resin stopper

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.



Allowable	Steel Stre	ngth for Threade	ed Rods						
		ASTM F 1554	n Steel Grade 36 (A307 r.C)	Carbor ASTM A			ss Steel 593 CW	Stainles ASTM F	
Anchor D (in		Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>
3/8"	lb	2,110	1,080	4,550	2,345	3,360	1,870	4,190	2,160
3/6	kN	9.4	4.8	20.2	10.4	16.1	8.3	18.6	9.6
1/2"	lb	3,750	1,930	8,100	4,170	6,470	3,330	7,450	3,840
1/2	kN	16.7	8.6	36.0	18.5	28.8	14.8	33.1	17.1
5/8"	lb	5,870	3,030	12,655	6,520	10,130	5,220	11,640	6,000
5/6	kN	26.1	13.5	56.3	29.0	45.1	23.2	51.8	26.7
3/4"	lb	8,460	4,360	18,220	9,390	12,400	6,390	15,300	7,880
3/4	kN	37.6	19.4	81.0	41.8	55.2	28.4	68.1	35.1
7.01	lb	11,500	5,930	24,800	12,780	16,860	8,680	20,830	10,730
7/8"	kN	51.2	26.4	110.3	56.8	75.0	38.6	92.7	47.7
1"	lb	15,020	7,740	32,400	16,690	22,020	11,340	27,210	14,020
1	kN	66.8	34.4	144.1	74.2	97.9	50.4	121.0	62.4
4 4/43	lb	23,480	12,100	50,640	26,070	34,420	17,730	38,470	19,820
1 - 1/4"	kN	104.4	53.8	225.1	116.0	153.1	78.9	171.1	88.2

Allowable Tension,  $N_{_{all}}=0.33$  x  $f_{_{\rm U}}$  x nominal cross sectional area Allowable Shear,  $V_{_{all}}=0.17$  x  $f_{_{\rm U}}$  x nominal cross section area

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

Allowable S	teel Strength fo	or Rebar		Allowable Stee	I Strength for	or Rebar	
		Carbon Steel ASTM A 61	5 Grade 60			Carbon Steel CAN/CSA-	G30.18 Gr.400
Reba	ar Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, $V_{all}$	Rebar S	Size	Allowable Tension, N <sub>all</sub>	Allowable Shear, V <sub>all</sub>
"0	lb	3,280	1,690		lb	4,016	2,069
#3	kN	14.6	7.5	10M	kN	17.9	9.2
#4	lb	5,831	3,004		lb	8,052	4,148
#4	kN	25.9	13.4	15M	kN	35.8	18.5
#5	lb	9,111	4,693		lb	11,960	6,161
#5	kN	40.5	20.9	20M	kN	53.2	27.4
#6	lb	13,121	6,759		lb	19,975	10,290
#0	kN	58.4	30.1	25M	kN	88.9	45.8
#7	lb	17,859	9,200		lb	28,121	14,486
#7	kN	79.4	40.9	30M	kN	125.1	64.4
#8	lb	23,326	12,016		lb	40,089	20,652
#0	kN	103.8	53.4	35M	kN	178.3	91.9
#10	lb	37,623	19,381			cross sectional area	
#10	kN	167.4	86.2	Shear = 0.17 x f		oss section area	alo for the interpretat

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

1. Above values for reinforcing steel assume the design method is the same as a post-installed adhesive anchor, under the principles of anchor design (failure modes will be concrete breakout, pryout, steel failure, or adhesive bond) and not under the principles of reinforcing steel design (failure modes are typically splitting failure, inadequatebar development etc..). CONSULT AN ENGINEERING DESIGN PROFESSIONAL PRIOR TO USE.



				Allowable Concre	te Capacity /Bond		
Anchor Diameter	Embedment Depth		Tension (lb)			Shear (lb)	
		f² <sub>c</sub> =2,500psi	f² <sub>c</sub> =4,000psi	f <sup>2</sup> <sub>c</sub> =8,000psi	f <sup>2</sup> <sub>c</sub> =2,500psi	f²_c=4,000psi	f² <sub>c</sub> =8,000psi
	2-3/8"	1,939	2,032	2,178	2,585	2,710	2,904
3/8" or #3	4-15/16"	4,031	4,225	4,528	5,375	5,633	6,038
	7-1/2"	6,123	6,418	6,878	8,164	8,557	9,171
	2-3/4"	2,527	2,649	2,839	3,369	3,531	3,785
1/2" or #4	6-3/8"	5,858	6,140	6,581	7,811	8,187	8,774
	10"	9,186	9,631	10,323	12,252	12,842	13,764
	3-1/8"	3,889	4,076	4,368	5,185	5,434	5,824
5/8" or #5	7-13/16"	9,722	10,189	10,921	12,962	13,586	14,561
	12-1/2"	15,555	16,303	17,473	20,739	21,737	23,298
	3-3/4"	5,200	5,450	5,841	6,933	7,267	7,788
3/4" or #6	9-3/8"	13,000	13,625	14,603	17,333	18,167	19,471
	15"	20,799	21,800	23,365	27,732	29,067	31,153
	4"	8,407	8,811	9,444	11,209	11,749	12,592
1" or #8	12"	25,221	26,434	28,332	33,628	35,246	37,776
	20"	42,035	44,057	47,219	56,046	58,743	62,959
	5"	10,529	11,036	11,828	14,039	14,715	15,771
1-1/4" or #10	15"	31,588	33,108	35,484	42,117	44,144	47,312
	25"	52,646	55,180	59,140	70,195	73,573	78,853

 The above values represent mean ultimate values and allowable working loads. The allowable working loads have been reduced us ing a safety factor of 4. for tension and 3.0 for shear, however, in some cases, such as life safety, safety factors of 10.0 or higher may be necessary.

2. Allowable loads must be checked against steel capacity. The lowest value controls.

3. Tabulated data is applicable to single anchors in normal weight concrete unaffected by edge or spacing reduction factors. V alues are valid for anchors installed into dry concrete in holes drilled with a hammer drill and ANSI carbide drill bit.

4. Linear interpolation is allowed.
 \*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

In - Service Temperature	Reduction Factor*	
40°F	1.0	
68°F	1.0	
110°F	0.9	
130°F	0.7	***
150°F	0.5	*The the da
168°F	0.4	**For
176°F	0.3	extrap

\*The design professional on the job is ultimately responsible for the interpretation of the data provided above.

\*\*For intermediate temperatures, linear interpolation is allowed. Values must not be extrapolated.

### Coverage

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	2 3/8	2 3/8	2 3/4	3 1/8	3 3/4	4	5
Estimated Cartridge		600 ml	176	99	67	33	20	11	6
Number of Fixing *	Volume	1500 ml	455	256	175	86	53	30	16

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full

Anchor size:		(in.)	5/16	3/8	1/2	5/8	3/4	1	1 1/4
Drill Hole Diameter:		(in.)	3/8	1/2	9/16	3/4	7/8	1 1/8	1 3/8
Embedment Depth:		(in.)	3 1/8	3 3/4	5	6 1/4	7 1/2	10	12 1/2
Estimated Cartridge		600 ml	134	62	37	16	10	4	2
Number of Fixing *	Volume	1500 ml	346	162	96	43	26	12	6

\*Number of fixings assumes 30ml wastage in initial extrusion and holes filled to 3/4 full



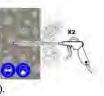
### Installation Method (Solid Substrates)

Always refer to MPII on ICC-ESR-3608

1. Using the SDS Hammer Drill in rotary hammer mode for drilling, with a carbide tipped drill bit conforming to ANSI B212.15-1994 of the appropriate size, drill the hole to the specified hole diameter and depth.



 Select the correct Air Lance, insert to the bottom of the hole and depress the trigger for 2 seconds. The compressed air must be clean – free from water and oil – and at a minimum pressure of 90 psi (6 bar).



### Perform the blowing operation twice.

3. Select the correct size Hole Cleaning Brush. Ensure that the brush is in good condition and the correct diameter. Insert the brush to the bottom of the hole, using a brush



extension if needed to reach the bottom of the hole and withdraw with a twisting motion. There should be positive interaction between the steel bristles of the brush and the sides of the drilled hole.

### Perform the brushing operation twice.

- 4. Repeat 2 (blowing operation) twice.
- 5. Repeat 3 (brushing operation) twice.
- 6. Repeat 2 (blowing operation) twice.
- Select the appropriate static mixer nozzle, checking that the mixing elements are present and correct (do not modify the mixer). Attach mixer nozzle to the cartridge. Check the Dispensing Tool is in good working order. Place the cartridge into the dispensing tool.

Note: The SAF-Q2 nozzle is in two sections. One section contains the mixing elements and the other section is an extension piece. Connect the extension piece to the mixing section by pushing the two sections firmly together until a positive engagement is felt.

**Note: AnchorFix®-3001** may only be installed between the temperatures of 40°F and 104°F. The product must be conditioned to a minimum of 50°F. For gel and cure time data, refer to Table 14.

 Extrude some resin to waste until an even-colored mixture is extruded, The cartridge is now ready for use.





PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

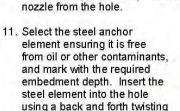
Constructio

As specified in Figure 2, Table 9. 11, and Table 12, attach an extension tube with resin stopper (if required) to the end of the mixing nozzle with a push fit.



(The extension tubes may be pushed into the resin stoppers and are held in place with a coarse internal thread).

10. Insert the mixing nozzle to the bottom of the hole. Extrude the resin and slowly withdraw the nozzle from the hole. Ensure no air voids are created as the nozzle is withdrawn. Inject resin until the hole is approximately 3/4 full and remove the



motion to ensure complete cover, until it reaches the bottom of the hole. Excess resin will be expelled from the hole evenly around the steel element and there shall be no gaps between the anchor element and the wall of the drilled hole.

- 12. Clean any excess resin from around the mouth of th hole.
- 13. Do not disturb the anchor until at least the minimum cure time has elapsed. Refer to the Table 14 Gel and Cure Times to determine the appropriate cure time.
- 14. Position the fixture and tighten the anchor to the appropriate installation torque.

Do not over-torque the anchor as this could adversely affect its performance.

**Overhead Substrate Installation Method** Always refer to MPII on ICC-ESR-3608

- 1. Using the SDS Hammer Drill in rotary hammer mode for drilling, with a carbide tipped drill bit conforming to ANSI B212.15-1994 of the appropriate size, drill the hole to the specified hole diameter and depth.
- 2. Select the correct Air Lance, insert to the bottom of the hole and depress the trigger for 2 seconds. The compressed air must be clean free from water and oil - and at a minimum pressure of 90 psi (6 bar).













3. Select the correct size Hole Cleaning Brush. Ensure that the brush is in good condition and the correct diameter. Insert the brush to the bottom of the hole, using a brush extension if needed to reach the bottom of the hole, and withdraw with a twisting motion. There should be positive interaction between the steel bristles of the brush and the sides of the drilled hole.



Perform the brushing operation twice.

- 4. Repeat 2 (blowing operation) twice.
- 5. Repeat 3 (brushing operation) twice.
- 6. Repeat 2 (blowing operation) twice.
- 7. Select the appropriate static mixer nozzle checking that the mixing elements are present and correct (do not modify the mixer). Attach mixer nozzle to the cartridge. Check the Dispensing Tool is in good working order. Place the cartridge into the dispensing tool.

Note: The SAF-Q2 nozzle is in two sections. One section contains the mixing elements and the other section is an extension piece. Connect the extension piece to the mixing section by pushing the two

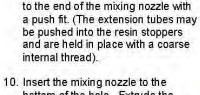


sections firmly together until a positive engagement is felt.

Note: AnchorFix®-3001 may only be installed between the Temperatures of 40°F and 104°F. The product must be Conditioned to a minimum of 50°F. For gel and cure time data, refer to Table 14.

- 8. Extrude some resin to waste until an even-colored mixture is extruded, The cartridge is now ready for use.
- CEREFFERT 9. As specified in Figure 2, Table 11, and Table 12, attach an extension



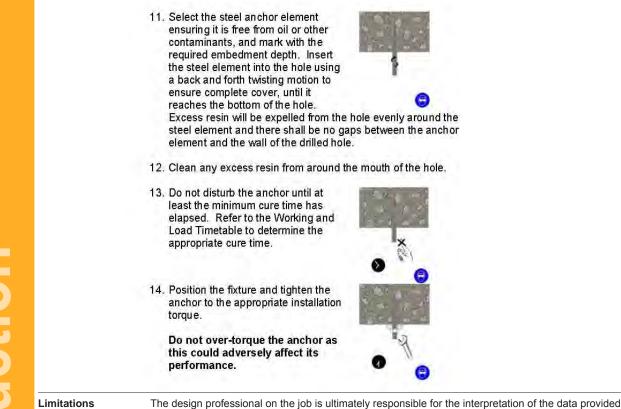


tube with resin stopper (if required)

bottom of the hole. Extrude the resin and slowly withdraw the nozzle from the hole. Ensure no air voids are created as the nozzle is withdrawn. Inject resin until the hole is approximately 3/4 full and remove the nozzle from the hole.







above Note: Sika AnchorFix-3001 has been qualified for resisting long-term leads through the ICC-ES AC308 creep

test for which an anchor is loaded and monitored for movement over time. According to AC308, anchors that pass the creep test are determined to be suitable for resisting long- term tensile loads.

- Installation of anchors in horizontal or upwardly inclined orientations to resist sustained tension loads shall be performed by personnel certified by an application certification program in accordance with ACI 318 D.9.2.2 or D.9.2.3
- Please refer to section 5.0 for conditions of use in the ICC Evaluation Report #3608. This report is available on Sika and ICC's websites.
- For a complete list of tools and accessories, refer to ICC ESR #3608
- Minimum application temperature: 40°F (4°C)
- Maximum application temperature: 104°F (40°C)

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# **D** - Grouting and Grout Aids

Sikadur 42 Grout-Pak	D10
Sikadur 42 Grout-Pak PT	D20
Sikadur 42 Grout-Pak LE	D30
SikaGrout 212	D40
SikaGrout 328	D50
SikaGrout 428 FS	D60
Intraplast-N	usa.sika.com
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**BUILDING TRUST** 

## Sikadur<sup>®</sup> 42, Grout-Pak Pre-proportioned, epoxy, baseplate grouting system

Description	Sikadur® 42, Grout-Pak is a 3-component, 100% solids, moisture-tolerant, epoxy baseplate grouting syste
Where to Use	<ul> <li>Precision seating of baseplates.</li> <li>Precision grouting of wind turbine tower bases requiring rapid strength gain.</li> <li>Grouting under equipment, including heavy impact and vibratory machinery, reciprocating engines, compressors, pumps, presses, etc.</li> <li>Grouting for "pour-back" anchorage on post tensioning projects (e.g. segmental bridge).</li> <li>Grouting under crane rails.</li> </ul>
Advantages	<ul> <li>Ready to mix, pre-proportioned kit.</li> <li>Moisture-tolerant.</li> <li>Corrosion and impact resistant.</li> <li>Stress and chemical resistant.</li> <li>Long working time.</li> <li>High vibration resistance.</li> <li>Fast strength gain.</li> <li>Low peak exothermic system for large pours.</li> <li>High effective bearing area.</li> <li>Excellent flowability.</li> <li>USDA certifiable for incidental food contact.</li> </ul>
Packaging	<ul> <li>0.5 ft<sup>3</sup> kit: Contains 0.9 gal. epoxy (Component A and Component B in a 5 gal. pail separated with a topline and 50 lbs. aggregate (Component C) in a multi-wall bag.</li> <li>1.5 ft<sup>3</sup> kit: Contains 2.7 gal. epoxy (Component A in a 5 gal. pail and Component B in a 2 gal. pail) and 1 lbs. aggregate (Component C) in three 50 lb. multi-wall bags.</li> </ul>
	<b>Typical Data</b> ( <i>Material and curing conditions</i> @ 73°F (23°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,
	TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.
	Shelf Life2 years in original, unopened containers.
	Storage ConditionsStore dry at 40°-95°F (4°-35°C). Condition material to 65°-85°F (18°-29°C) before using. Component C must be kept dry.
	Color Concrete gray
	Consistency Flowable
	Application Life Approximately 90 minutes
	Tensile Properties (ASTM C-307)       7 day       Tensile Strength       2,300 psi (15.8 MPa)
	Flexural Properties (ASTM C-580)         7 day       Flexural Strength (Modulus of Rupture)       4,000 psi (27.6 MPa)         Tangent Modulus of Elasticity       1.30 x 10 <sup>6</sup> psi (8,963 MPa)
	Water Absorption (ASTM C-413) 7 day (2-hour boil) 0.04%
	Bond Strength (ASTM C-882 modified)7 dayBond Strength to Concrete4,200 psi (29.0 MPa)Bond Strength to Steel3,800 psi (26.2 MPa)
	Coefficient of Thermal Expansion (ASTM C-531) 24.5 x 10 <sup>-6</sup> in./in./°F (13.7x10 <sup>-6</sup> mm/mm/°C)
	Thermal Compatibility (ASTM C-884) passes test
	Effective Bearing Area <sup>1</sup> >95%
	Compressive Properties (ASTM C-579B): Compressive Strength, psi (MPa)
	<b>40°F* (4°C) 73°F* (23°C) 90°F* (32°C)</b> <b>8 hour</b> 5,500 (37.9)
	<b>16 hour</b> - 9,600 (66.2) 9,800 (67.6)
	<b>1 day</b> - 12,200 (84.1) 11,500 (79.3)
	3 day4,800 (33.1)14,000 (96.6)14,000 (96.6)7 day13,700 (94.5)14,900 (102.8)14,800 (102.1)
	<b>14 day</b> 13,900 (95.9) <b>15,000 (102.1) 14,000 (102.1) 15,000 (103.4) 15,200 (104.8)</b>
	<b>28 day</b> 13,900 (95.9) 15,200 (104.8) 15,600 (107.6)
	* Material cured and tested at the temperatures indicated. 1 Percent final surface area of grout in contact with bearing plate



How to Use Surface Preparation	Substrate and baseplate contact area must be clean, sound, and free of standing water. Remove dust, laitance oils, grease, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e., sandblasting, bush hammering). Sandblast metal baseplates to a commercia white finish for maximum adhesion. Apply grout immediately to prevent re-oxidizing. Concrete substrate must have reached its desired strength (3,000 psi minimum) and must be dimensionally stable.
Mixing	<ul> <li>0.5 ft<sup>3</sup> kit: Pour the entire contents of Components 'A' &amp; 'B' into an appropriate mixing vessel (e.g. 5 gal. bucket and mix for 30 seconds with a 1/2 in. Jiffy mixing paddle (5 in. blade diameter) on a low-speed (400 - 600 rpm) 3/4 in. drive rotary drill, taking care not to entrain air during mixing. Do not over-mix. It is critical to the performance of the grout that there be no appreciable air bubbles in the resin. Slowly add the entire contents of Component 'C' and mix until uniformly blended (approx. 5 minutes).</li> <li>1.5 ft<sup>3</sup> kit: Pour the entire contents of Components 'A' &amp; 'B' into an appropriate mixing vessel (e.g. 5 gal bucket) and mix for 30 seconds with a 1/2 in. Jiffy mixing paddle (5 in. blade diameter) on a low-speed (400 - 600 rpm) 3/4 in. drive rotary drill, taking care not to entrain air during mixing. Do not over-mix. It is critical to the performance of the grout that there be no appreciable air bubbles in the resin. Transfer the mixed resin to an appropriate mixing vessel. Slowly add the entire 3 bags of Component 'C' and mix until uniformly blended (approx. 5 minutes).</li> </ul>
Application	Pour the mixed grout into the prepared forms from one side only to eliminate air entrapment. Baseplate should have vent holes around periphery to prevent air pockets from developing. Maintain the liquid head to ensure intimate contact with the base plate. Plungers may be used to ease placement. Place sufficient epoxy adhesive grout in the forms to rise slightly above the underside of the base plate. Grout depth of 1 in. (25 mm) minimum required.
Tooling & Finishing	<b>Forming:</b> The flowable consistency of the epoxy adhesive grout system requires the use of forms to contain the material around the baseplates. In order to prevent leakage or seepage, completely seal all forms. Apply polyethylene film or wax to all forms to prevent adhesion of the grout. Prepare form work to maintain a 2 in (50 mm) liquid head to facilitate placement. A grout box that can be attached to the form will enhance the grout flowability. Projected anchor bolts should be wrapped with neoprene foam rubber (or similar) to preven grout from adhering to the bolts. The use of expansion joints is recommended on large pours to minimize the potential for cracking in the epoxy grout (maximum 3-4 ft. spacing in each direction).
Limitations	<ul> <li>Minimum substrate and ambient temperature is 40°F (4°C).</li> <li>Do not thin. Addition of solvents will prevent proper cure.</li> <li>Material is a vapor barrier after cure.</li> <li>Minimum grout depth is 1 in. (25 mm).</li> <li>Baseplate should be shielded from direct sunlight and rain for a minimum of 24 hours before epoxy grouting, and 48 hours after grouting.</li> <li>Maximum grout depth is 4 in./lift (101 mm).</li> <li>Component C must be kept dry.</li> <li>Cold material may require chaining, rodding, and pushing during placement.</li> <li>For proper seating, allow grout to rise above the bottom of the base plate.</li> <li>Do not batch. Mix complete units.</li> <li>Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.</li> </ul>

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Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celava Km. 8.5

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# Sikadur<sup>®</sup> 42, Grout-Pak PT

Pre-proportioned, epoxy, anchorage protection system

Description	Sikadur® 42, Grout-Pak PT is a 3-component, 100% solids, moisture-tolerant, epoxy anchorage protection system.
Where to Use	<ul> <li>To protect the anchorages of post-tensioning tendons or bars (i.e. pour-back box) on segmental bridge projects.</li> </ul>
Advantages	<ul> <li>Ready to mix, pre-proportioned kit.</li> <li>Excellent adhesion.</li> <li>Impermeable and resistant to chemicals, corrosion, impact and stress.</li> <li>Moisture-tolerant.</li> <li>Low heat development/low peak exothermic system for large pours.</li> <li>High compressive strength.</li> <li>Long working time.</li> <li>High vibration resistance.</li> <li>Fast strength gain.</li> <li>Minimal shrinkage/expansion.</li> <li>High effective bearing area.</li> <li>Good flowability.</li> </ul>
Packaging	0.5 cu. ft. kit consists of epoxy resin (Component 'A' and 'B') and 50 lb. aggregate. (Component 'C') in a multi-wall bag.

### Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASI	ED UPON STATIST	ICAL VARIATIO	NS DEPENI	DING UPON MIXING METHODS AND	EQUIPMENT.
				E CONDITIONS AND CURING COND	
Shelf Life	2 years in orig	ginal, unoper	ned conta	iners.	
Storage Conditions		· · ·	,	ondition material to 75°-85°F	(24°-29°C) before
	using. Compo	onent 'C' mus	st be kept	dry.	
Color	Dark Gray				
	Flowable (whe			ly)	
Application (Pot) Life		/ 90 minutes			
Gel Time (ASTM D-24	71)		Approxi	nately 3.25 hrs.	
Tensile Strength (AST	M C-307)	7 day	2,200 ps	si (15.1 MPa)	
Flexural Properties (A					
				3,700 psi (25.5 MPa)	
0				1,400 ksi (9,655 MPa)	0.049/
• •	,	•	lotal vva	ater Absorption (2-hour boil)	0.04%
Bond Strength (ASTN 7 day Bond S			uro) 3.1	00 psi (21.3 MPa)	
				00 psi (24.8 MPa)	
Coefficient of Therma	0	```	'	oo po. (2 o a)	
				) x10 <sup>-6</sup> mm/mm/ЉС)	
0° - 160°F(-18°-7	(1°C) 12.6 x	к 10 <sup>-6</sup> in./in./Л	ЬF (6.8	x10 <sup>-6</sup> mm/mm/ЉС)	
Peak Exotherm (AST					
Specimen Size Tested:					
Thermal Compatibility			es test (5	cycles)	
Linear Shrinkage (AS	TM C-531) 7 d	ay	0.0	22%	
Effective Bearing Are	a (ASTM C-133	<b>39)</b> >95% f	final surfa	ce area of grout in contact wi	th bearing plate
Compressive Creep (			.7 MPa)	@ 140°F (60°C)	
<b>1 day</b> 0.0085					
7 day 0.0086 28 day 0.0093					
Heat Deflection Temp	· · · · · · · · · · · · · · · · · · ·	,	5°E (50°C	<b>`</b> \	
	ess loading = 2			<i>,</i> )	
, aug [iiber su	coo localing - 2	.04 poi (1.0 i	vii u)]		



	Compressive Properties (A Compressive Strength, psi 8 hour 16 hour 1 day 3 day 7 day 14 day 28 day Compressive Modulus (AST * Material cured and tested at the temp	(MPa) 40°F* (5°C) - - - - - - - - - - - - - - - - - - -	<b>73°F* (23°C)</b> - 10,000 (68.9) 11,000 (75.8) 14,200 (97.9) 15,000 (103.4) 16,000 (110.4) 17,000 (117.3) 2,600 ksi (17,940 MPa	<b>90°F* (32°C)</b> 8,200 (56.5) 13,000 (89.6) 14,000 (96.5) 15,000 (103.4) 15,000 (103.4) 16,500 (113.9) 17,500 (120.8)
How to Use Surface Preparation	Substrate and other contact an oils, grease, curing compounds by mechanical means (i.e. sand white finish for maximum adhes have reached its desired streng	s, waxes, impregnation Iblasting, bush hamme sion. Apply grout imme	s, foreign particles, coating ring). Sandblast metal cont diately to prevent re-oxidiz	s and disintegrated materials act surfaces to a commercia ing. Concrete substrate shal
Mixing	Pour the entire contents of Con for 30 seconds with a 1/2 in. Jif drive rotary drill, taking care no <b>that there be no appreciable</b> mix until uniformly blended (ap	fy mixing paddle (5 in. ot to entrain air during <b>air bubbles in the res</b> i	blade diameter) on a low-s mixing. It is critical to the	peed (400 - 600 rpm) 3/4 in. performance of the grout
Application	Pour the mixed epoxy grout into box should have vent holes are to ensure intimate contact with epoxy grout in the forms to rise minimum required.	ound periphery to preve the pour-back box. Plu	nt air pockets from develop ingers may be used to eas	bing. Maintain the liquid heac e placement. Place sufficien
Tooling & Finishing	<b>Forming:</b> The flowable consist rial. In order to prevent leakag stripped, apply polyethylene fill work to maintain a 2 in. (50 mr form will enhance the grout floo with neoprene foam rubber (or is recommended on large pou (0.9-1.2 m.) spacing in each dia	je or seepage, comple m or bond breaker to a n.) liquid head to facili wability. In base plate a similar) to prevent grou rs to minimize the pote	tely seal all forms. In appl Ill forms to prevent adhesic ate placement. A grout bo applications, projected anc t from adhering to the bolts	ications where forms will be on of the grout. Prepare form x that can be attached to the hor bolts should be wrapped b. The use of expansion joints
Limitations	<ul> <li>Minimum substrate and am</li> <li>Do not thin. Addition of solv</li> <li>Material is a vapor barrier a</li> <li>Minimum grout depth shoul</li> <li>Anchorage pour-back box s before epoxy grouting, and</li> <li>Component 'C' must be kep</li> <li>Cold material may require c</li> <li>For applications requiring gr (standard formulation - proce</li> <li>For proper seating in base p</li> <li>Do not batch. Mix comple</li> <li>Not an aesthetic product. C</li> </ul>	ents will prevent prope fter cure. d be 1 in. (25 mm.). Ma hould be shielded from after grouting until tack ot dry. shaining, rodding and p ood self-leveling and b Juct code 0335-30N). blate applications, allow te units.	r cure. aximum grout depth should a direct sunlight and rain for t free. ushing during placement. etter flow capabilities, use v grout to rise above the bo	r a minimum of 24 hours Sikadur® 42, Grout-Pak ottom of the base plate.
INS SH PAI TO	IOR TO EACH USE OF ANY SIKA I STRUCTIONS ON THE PRODUCT'S EET WHICH ARE AVAILABLE ONLI RTMENT AT 800.933.7452 NOTHING READ AND FOLLOW THE WARNIN NT PRODUCT DATA SHEET, PRODU	MOST CURRENT PROE NE AT HTTP://USA.SIKA CONTAINED IN ANY SIF IGS AND INSTRUCTIONS	DUCT DATA SHEET, PRODUC LCOM/ OR BY CALLING SIK (A MATERIALS RELIEVES TH S FOR EACH SIKA PRODUC)	CT LABEL AND SAFETY DATA A'S TECHNICAL SERVICE DE- IE USER OF THE OBLIGATION T AS SET FORTH IN THE CUR-
appli and a tions, recor recor and p All sa	KEEP CONTAINER TIGHTLY CLOSED • KEE formation provided by Sika Corporation ("Sik cation and use of Sika products, is given in go applied under normal conditions in accordance, a catual site conditions and other factors outs mmendations or instructions related to its pro- nmendations or instructions related to its pro- purpose before proceeding with the full appl ales of Sika product(s) are subject to its curr to each use of any Sika product, the user 1	a") concerning Sika products, i ood faith based on Sika's currer side of Sika's instructions. In pr side of Sika's control are such ducts, nor shall any legal relati oducts. The user of the Sika pr ication of the product(s). Sika ent terms and conditions of sa	ncluding but not limited to, any recor t experience and knowledge of its p actice, the differences in materials, s that Sika assumes no liability for the onship be created by or arise from th oduct(s) must test the product(s) for reserves the right to change the pr ale which are available at <u>www.sika</u>	nmendations and advice relating to the roducts when properly stored, handled ubstrates, storage and handling condi- provision of such information, advice, e provision of such information, advice, r suitability for the intended application operties of its products without notice. <u>usa.com</u> or by calling 800-933-7452.
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Ka Regi	201 Polito Avenue         601 Deln           Lyndhurst, NJ 07071         Pointe C           Phone: 800-933-7452         Quebec           Fax: 201-933-6225         Phone: 5	nada Inc.         Sika           nar Avenue         Car           laire         Frac           H9R 4A9         Cor           114-697-2610         C.P           -694-2792         Pho	est Sika sales office, contact you a Mexicana S.A. de C.V. retera Libre Celaya Km. 8.5 cc. Industrial Balvanera regidora, Queretaro 76920 ne: 52 442 2385800 .52 442 2385800 .52 442 2385800 .52 442 2385800 .52 442 2385800 .53 45 25 25 25 25 25 25 25 25 25 25 25 25 25	3-SIKA NATIONWIDE r regional center.

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## Sikadur<sup>®</sup> 42, Grout-Pak LE<sup>US</sup> Pre-Proportioned, Precision Epoxy Grouting System

Description	dusti			, three-component, low exotherm, low stem designed to seat and support high				
Where to Use	<ul> <li>Gro cor</li> </ul>	Precision seating of baseplates. Grouting under equipment, including heavy impact and vibratory machinery, reciprocating engines, compressors, pumps, presses, etc. Grouting under crane rails.						
Advantages       Meets API Standard 686         Low peak exotherm       Low dusting, ready-to-mix, pre-portioned kits         Moisture tolerant       Corrosion and impact resistant         Stress and chemical resistant       High compressive, tensile and shear strengths         High vibration resistance       High vibration resistance								
		Typical Data (Mate	erial and curing conditions @ 7	3°F (23°C) and 50% R.H.)				
				IDING UPON MIXING METHODS AND EQUIPMENT, TE CONDITIONS AND CURING CONDITIONS.				
		Shelf Life	2 years in original, unopened co					
		-	35°C) before using.	Condition material to 73°-95°F (23°-				
		Color	Dark Brown					
		Mix Ratio	A:B:C by weight	3:1:34				
		Density	solid/liquid by weight 144 lb/ft <sup>3</sup> (2300 kg/m <sup>3</sup> )	8:5:1				
		Pot Life	Mix 3:1 (A:B 300 g)	2 hrs. 20 min.				
		Tensile Strength (AS	· · · · · · · · · · · · · · · · · · ·	5,000 psi (34.5 MPa)				
		Tensile Strength (AS	-	2,000 psi (13.8 MPa)				
		Flexural Strength (A	-	6,400 psi (44.1 MPa)				
			Elasticity in Bending (ASTM C-	<b>-580)</b> 5.24 x 10 <sup>6</sup> psi (36 MPa)				
			al Expansion (ASTM C-531)					
			-22° to 86°F (-30°C to 30°C)	1.6 x 10 <sup>-5</sup> /°F (2.8 x 10 <sup>-5</sup> /°C)				
			75° to 212°F (24°C to 100°C)	2.1 x 10 <sup>-5</sup> /°F (3.8 x 10 <sup>-5</sup> /°C)				
		Bond Strength (AST						
			7 Days	> 2,500 psi (40 MPa) concrete failure				
		Creep Test (ASTM C		7.0 × 40.3				
			600 psi, 140°F (4.1 MPa, 60°C) 400 psi, 140°F (2.7 MPa, 60°C)	7.2 x 10 <sup>-3</sup> 5.3 x 10 <sup>-3</sup>				
		Linear Shrinkage (A		0.045%				
		Thermal Compatibili		No delamination/pass				
		Exotherm (ASTM D-2		94.3°F (34.6°C)				
		Effective Bearing Ar	ea (ÁSTM C-1339)	~90% (High)				
		Compressive Streng	th (ASTM C-579), psi (MPa) 73°F* (23°C)					
		24 hou	urs 5,000 psi (34.5 MPa)					
		2 days						
		3 days		0,000 psi (69.0 MPa)				
		7 days 28 day	s 11,000 psi (75.8 MPa) v <b>s</b> 13,300 psi (91.7 MPa)					
		* Material cured and tested at t						



	<ul> <li>Low coefficient of thermal expansion; compatible with concrete</li> <li>Material does not require heated transportation</li> </ul>
Packaging	2.0 cu. ft. Unit = Component A: 22.6 lbs. (10.28 kg) Component B: 7.5 lbs. (3.42 kg) Component C: 4 x 64 lbs. (29.03 kg)
Coverage	2 ft <sup>3</sup> (56,640 cm <sup>3</sup> ), 15 gallons (56.6 liters)
How to Use Surface Preparation	<b>Note:</b> For optimum results when grouting in critical items of equipment, it is recommended that the surface preparation requirements of the latest edition of Chapter 5, API Recommended Practice 686 be followed. This document is the "Recommended Practices for Machinery Installation and Installation Design" published by the American Petroleum Institute. Surface and base plate contact area must be clean and sound. For best results, the substrate should be dry. Remove dust, laitance, oils, grease, curing compounds, impregnations, waxes, foreign particles, coatings, and disintegrated materials by mechanical means( i. e. chipping with a chisel, sandblasting). All anchor pockets or sleeves must be void of water. Sandblast metal base plates to a commercial white finish (SP-10) for maximum adhesion. Apply grout immediately to prevent re-oxidizing.
Forming	The consistency of the epoxy grout system requires the use of forms to contain the material around the base plates. In order to prevent leakage or seepage, all forms must be sealed. Apply polyeth- ylene film or wax to all forms to prevent adhesion of the grout. Prepare form work to maintain more than 4 in. (100mm) liquid head to facilitate placement. A grout box equipped with an inclined trough attached to the form will enhance the grout's flowability and minimize air entrapment.
Mixing	Thoroughly pre-mix each Component A and Component B, distributing any settled solids and achieving an even consistency throughout each component. Mix the entire contents of components A and B in the component A pail for 30 seconds with a 1/2 in. Jiffy mixing paddle (5 in. blade diameter) on a low-speed (400 - 600 rpm) 3/4 in. drive rotary drill, taking care not to entrain air during mixing. During the mixing operation, scrape down the sides and bottom of the mixing pail with a flat or straight edge trowel at least once, to ensure complete mixing of A and B components. Avoid entrapment of air during mixing. Entrapped air can result in effecting the physical properties of the mixed grout. Empty entire contents of mixed A and B components into an appropriate mortar mixer ensuring that walls and bottom of mixing pail are scraped clean and all of mixed epoxy resin is added to mortar mixer. Slowly add the entire content of component C and mix until uniformly blended (approx. 5 minutes). Add all component C unless a reduction is directed by the Sika Representative. Mixed grout should be kept agitated prior to placement.
Application	Pour the mixed grout into the prepared forms from one or two adjacent sides only, to eliminate air entrapment. Maintain the liquid head to ensure intimate contact to the base plate. Place sufficient epoxy grout in the forms to rise slightly above the underside [1/8 in (3 mm)] of the base plate. The minimum void depth beneath the base-plate should be 1 in (25 mm), but 1.5 in (38 mm) is preferred. Where the void beneath the base plate is greater than 18 in (450 mm), place the epoxy grout in successive 18 in (450 mm) lifts or less, once the preceding lift has cooled and achieved and initial set.
Limitations	<ul> <li>If material is subject to cold or freezing temperatures during transportation to and from storage on a job site, care must be taken to properly precondition Components, A, B and C prior to beginning grouting operations.</li> <li>Cold ambient, substrate or material temperatures will inhibit the flow and curing characteristics of Sikadur 42 Grout-Pak LE<sup>US</sup>. For temperatures below 73.4°F (23°C), call Sika Technical Services.</li> <li>Grouting material must be stored in an area with ambient temperature between 73° and 86°F (23° and 30°C) for a minimum of 48 hours before use.</li> <li>Should ambient, substrate or material temperatures exceed 86F (30C), contact Sika Technical Services for guidance as excessive heat can influence the properties of epoxy polymer grouts.</li> <li>Material is a vapor barrier after cure.</li> <li>Do not thin with solvents. Solvents will prevent proper cure.</li> <li>Minimum grout thickness: 18 in. (450 mm) per lift. For grout thickness between 12-18 in. (300-450 mm), contact Sika Technical Services.</li> <li>Component C must be kept dry.</li> <li>For bolt grouting applications, contact Sika Technical Services.</li> </ul>



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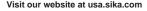
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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Product Data Sheet Edition 7.24.2014 SikaGrout® 212

### SikaGrout<sup>®</sup> 212

High performance, cementitious grout

sating mechanism. It is	non-metall	ic and contains no c	hloride.		
Grout <sup>®</sup> 212 compensati grout, SikaGrout <sup>®</sup> 212	tes for shrin provides th	kage in both the plane advantage of mu	astic and hardened	states. A structural	
	outing of col	umn base plates, m	achine base plates	, anchor rods,	
<ul> <li>Use on grade, above and below grade, indoors and out.</li> <li>Multiple fluidity allows ease of placement: ram in place as a dry pack, trowel-apply as a</li> </ul>					
<ul> <li>Multiple fluidity with c</li> <li>Non-metallic, will not</li> <li>Low heat build-up.</li> <li>Excellent for pumping hopper</li> <li>Superior freeze/thaw</li> <li>Resistant to oil and w</li> <li>Meets ASTM C-1107</li> <li>Shows positive expansion</li> </ul>	one materia s stain or rus g: Does not v resistance. vater. ' (Grade C). nsion when	st. segregate, even at tested in accordance			
	π./bag at n	ign flow.			
	летнорs, тезт One year Store dry	метнорs, астиац site ( in original, unopene at 40°-95°F (4°-35°(	conditions and curing d bags.	CONDITIONS.	
Oslan					
	Concrete	0,		Fluid <sup>2</sup>	
	& Flowable			Fluid	
		6 pt.+	6.5 pt.	8.5 pt.	
Set Time (ASTM C-266		3.5-4.5 hr.	4.0-5.0 hr.	4.5-6.5 hr.	
T			5.5-6.5 hr.	6.0-8.0 hr.	
Iensile Splitting Stren			575 (3.9 MPa)	500 (3.4 MPa)	
Flexural Strength, psi					
	28 day	2,000 (13.7 MPa)	1,900 (13.1 MPa)	1,900 (13.1 MPa)	
			+0.056%	+0.027%	
Compressive Strength	1 day 7 day	4,500 (31 MPa) 6,100 (42 MPa)	5,700 (39.3 MPa)	2,700 (18.6 MPa) 5,500 (37.9 MPa)	
	zo day	7,500 (51.7 MPa)	0,200 (42.7 IVIFA)	5,800 (40 MPa)	
	sating mechanism. It is With a special blend of Grout® 212 compensat grout, SikaGrout® 212 SikaGrout® 212 meets • Use for structural gro bearing plates, etc. • Use on grade, above • Multiple fluidity allows medium flow, pour or • Easy to use, just add • Multiple fluidity with of Non-metallic, will not • Low heat build-up. • Excellent for pumping hopper • Superior freeze/thaw • Resistant to oil and v • Meets ASTM C-1107 • Shows positive expai • SikaGrout® 212 is US Approximately 0.44 cu. 50-lb. multi-wall bags <b>Typical Data (Mater</b> <b>RESULTS MAY DIFFER BASED U</b> <b>TEMPERATURE, APPLICATION W</b> Shelf Life Storage Conditions (ASTM C-109, Plastic a Typical Water Require Set Time (ASTM C-266 <b>Tensile Splitting Strem</b> <b>Flexural Strength, psi (Astronometal Strength))</b>	sating mechanism. It is non-metall With a special blend of shrinkag Grout® 212 compensates for shrin grout, SikaGrout® 212 provides th SikaGrout® 212 meets ASTM C-11 Use for structural grouting of col bearing plates, etc. Use on grade, above and below Multiple fluidity allows ease of pl medium flow, pour or pump as h Easy to use, just add water. Multiple fluidity with one materia Non-metallic, will not stain or rus Low heat build-up. Excellent for pumping: Does not hopper Superior freeze/thaw resistance Resistant to oil and water. Meets ASTM C-1107 (Grade C). Shows positive expansion when SikaGrout® 212 is USDA-approv Approximately 0.44 cu. ft./bag at h 50-lb. multi-wall bags <b>Typical Data (Material and cur</b> RESULTS MAY DIFFER BASED UPON STATISTIC TEMPERATURE, APPLICATION METHODS, TEST Shelf Life One year Storage Conditions Store dry fore using Color Concrete Flow Conditions (ASTM C-109, Plastic & Flowable Typical Water Requirements: Set Time (ASTM C-266): Initial Tensile Splitting Strength, psi (A 28 day Bond Strength, psi (ASTM C-882 28 day Expansion % (CRD C-621) 28 day Compressive Strength, psi (CRD 1 day 7 day	sating mechanism. It is non-metallic and contains no c With a special blend of shrinkage-reducing and plas Grout® 212 compensates for shrinkage in both the pla grout, SikaGrout® 212 provides the advantage of mu SikaGrout® 212 meets ASTM C-1107 (Grade C). Use for structural grouting of column base plates, m bearing plates, etc. Use on grade, above and below grade, indoors and Multiple fluidity allows ease of placement: ram in pla medium flow, pour or pump as high flow. Easy to use, just add water. Multiple fluidity with one material. Non-metallic, will not stain or rust. Low heat build-up. Excellent for pumping: Does not segregate, even at hopper Superior freeze/thaw resistance. Resistant to oil and water. Meets ASTM C-1107 (Grade C). Shows positive expansion when tested in accordance SikaGrout® 212 is USDA-approved. Approximately 0.44 cu. ft./bag at high flow. 50-lb. multi-wall bags <b>Typical Data (Material and curing conditions @</b> RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE of fore using. Color Concrete gray Flow Conditions Plastic <sup>1</sup> (ASTM C-109, Plastic & Flowable; ASTM C-939, Fluit Typical Water Requirements: 6 pt.+ Set Time (ASTM C-266): Initial 3.5-4.5 hr. Final 4.5-5.5 hr. Tensile Splitting Strength, psi (ASTM C-293) 28 day 600 (4.1 MPa) Flexural Strength, psi (ASTM C-293) 28 day 1.400 (9.6 MPa) Bond Strength, psi (ASTM C-293) 28 day 1.400 (9.6 MPa) Bond Strength, psi (ASTM C-293) Expansion % (CRD C-621) 28 day +0.021% Compressive Strength, psi (CRD C-621) 1 day 4.500 (31 MPa) 7 day 6,100 (42 MPa)	<ul> <li>Use for structural grouting of column base plates, machine base plates, bearing plates, etc.</li> <li>Use on grade, above and below grade, indoors and out.</li> <li>Multiple fluidity allows ease of placement: ram in place as a dry pack, tr medium flow, pour or pump as high flow.</li> <li>Easy to use, just add water.</li> <li>Multiple fluidity with one material.</li> <li>Non-metallic, will not stain or rust.</li> <li>Low heat build-up.</li> <li>Excellent for pumping: Does not segregate, even at high flow. No build-hopper</li> <li>Superior freeze/thaw resistance.</li> <li>Resistant to oil and water.</li> <li>Meets ASTM C-1107 (Grade C).</li> <li>Shows positive expansion when tested in accordance with ASTM C-827</li> <li>SikaGrout® 212 is USDA-approved.</li> <li>Approximately 0.44 cu. ft./bag at high flow.</li> <li>50-lb. multi-wall bags</li> </ul> <b>Typical Data</b> (Material and curing conditions @ 73°F (23°C) and 50 REBULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS, TEST METHODS, ACTUAL STE CONDINOS AND CURNES Shelf Life One year in original, unopened bags. Storage Conditions Storage Conditions Storage Conditions Plastic' Flowable' (ASTM C-109, Plastic & Flowable; ASTM C-939, Fluid) Typical Water Requirements: <ul> <li>6 pt.+</li> <li>6.5 pt.</li> <li>6 pt.+</li> <li>6.5 pt.</li> <li>6 pt.+</li> <li>6.5 pt.</li> <li>7 Einal 4.5-5.5 hr.</li> <li>7.5-6.5 hr.</li> <li>7 Einal 4.5-5.5 hr.</li> <li>7 S.5-6.5 hr.</li> <li>7 Einal 4.5-5.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Einal 4.5-6.5 hr.</li> <li>7 Eina</li></ul>	

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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How to Use Surface Preparation	Remove all dirt, oil, grease, and other bond-inhibiting materials by mechanical means. Anchor bolts to be grouted must be de-greased with suitable solvent. Concrete must be sound an roughened to a CSP 4 or higher to promote mechanical adhesion. Prior to pouring, surfac should be brought to a saturated surface-dry condition. Steel should be cleaned and prepare thoroughly by blastcleaning to a white metal finish. Follow standard industry and Sika guideline for use as an anchoring epoxy.
	For pourable grout, construct forms to retain grout without leakage. Forms should be lined c coated with bond-breaker for easy removal. Forms should be sufficiently high to accommodat head of grout. Where grout-tight form is difficult to achieve, use SikaGrout <sup>®</sup> 212 in dry pac consistency.
Mixing	Mix manually or mechanically. Mechanically mix with low-speed drill (400-600 rpm) and Sik mixing paddle or in appropriately sized mortar mixer. Make sure all forming, mixing, placing, and clean-up materials are on hand. Add appropriat quantity of clean water to achieve desired flow. Add bag of powder to mixing vessel. Mix to uniform consistency, minimum of 2 minutes. Ambient and material temperature should be a close as possible to 70°F If higher, use cold water; if colder, use warm water.
	Product Extension: For deeper applications, SikaGrout <sup>®</sup> 212 (plastic and flowable consistencie only) may be extended with 25 lbs. of 3/8" pea gravel. The aggregate must be nonreactive, clear well-graded, saturated surface dry, have low absorption and high density, and comply with ASTN C33 size number 8 per Table 2. Add the pea gravel after the water and SikaGrout <sup>®</sup> 212.
Application	Within 15 minutes after mixing, place grout into forms in normal manner to avoid air entrapmen Vibrate, pump, or ram grout as necessary to achieve flow or compaction. SikaGrout <sup>®</sup> 212 must b confined in either the horizontal or vertical direction leaving minimum exposed surface. SikaGrout 212 is an excellent grout for pumping, even at high flow. For pump recommendations, contac Technical Service. Wet cure for a minimum of 3 days or apply a curing compound which complie with ASTM C-309 on exposed surfaces.
Fooling & Finishing	After grout has achieved final set, remove forms, trim or shape exposed grout shoulders to designed profile
-imitations	<ul> <li>Minimum ambient and substrate temperature 45°F and rising at time of application.</li> <li>Minimum application thickness: 1/2 in.</li> <li>Maximum application thickness (neat): 2 in. However, thicker applications can be achieved Contact Sika's Technical Services Department (800-933-7452) for further information.</li> <li>Do not use as a patching or overlay mortar or in unconfined areas.</li> <li>Material must be placed within 15 minutes of mixing.</li> <li>As with all cement based materials, avoid contact with aluminum to prevent adverse chemicar reaction and possible product failure. Insulate potential areas of contact by coating aluminur bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.</li> </ul>

PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5

Visit our website at usa.sika.com

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE



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Product Data Sheet Edition 4.9.2015 SikaGrout<sup>®</sup> 328

# SikaGrout<sup>®</sup> 328



High performance, precision, grout with extended working time

Description	at fluid consiste	s grout provid ncy.	les extended w	orking time and	d exceptional pl	hysical performant
		of 40°-95°F. S	SikaGrout® 328			dry pack over a ter de B & C) and Cor
Where to Use	beams, colum Applications w to transfer opt For underwate vice for dosage	equiring a pu outing of ma ins and curta vhere a non- timum load. er application ge informatio d to confirm	Impable grout. chinery and eq ain walls. shrink grout is n in conjunction n. Independent performance ur	uipment, base needed for ma with Sikament test data is av nder actual field	plates sole plat ximum effective 100SC. Cons ailable howeve	tes, precast panels
Advantages	<ul> <li>Multiple fluidit</li> <li>Reaches 10,0</li> <li>Outstanding p</li> <li>Extended wor</li> <li>Excellent fluid</li> <li>Contains prer</li> <li>Hardens free</li> <li>Non-metallic,</li> <li>Meets CRD C</li> </ul>	00 psi in dry performance king time. lity - sufficier nium quality of segregatio will not stain 2-621 & ASTI	pack consister in fluid state. nt time for place quartz aggrega on. or rust. M C-1107 (Grad	ement. ate.		
	Shows positive SikeCrout® 33					
Covorago	SikaGrout <sup>®</sup> 32	28 is USDA-a	approved.			
Coverage Packaging	<ul> <li>SikaGrout<sup>®</sup> 32</li> <li>Approximately 0</li> <li>Multi-wall bags;</li> </ul>	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b	approved. ag at high flow. bag.	and 50% P H )		
	<ul> <li>SikaGrout<sup>®</sup> 32</li> <li>Approximately 0</li> </ul>	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST N 9 months in o Store dry at 4	approved. ag at high flow. oag. ons @ 73°F (23°C) L VARIATIONS DEPE INTHODS, ACTUAL S riginal, unopened b	NDING UPON MIXING SITE CONDITIONS AN Dags.		ONS.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA 9 months in o Store dry at 4 before using.	approved. ag at high flow. bag. <b>ons @ 73°F (23°C)</b> L VARIATIONS DEPE METHODS, ACTUAL S riginal, unopened f 0°-95°F (4°-35°C).	NDING UPON MIXING SITE CONDITIONS AN Dags.	ID CURING CONDITIO	ONS.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED 0     TEMPERATURE, APPLICATION M     Shelf Life	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST N 9 months in o Store dry at 4 before using. Concrete gray	approved. ag at high flow. bag. bag. <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins	NDING UPON MIXING SITE CONDITIONS AN Dags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr.	ID CURING CONDITION Iditioning material t Flowable <sup>1</sup> (124-145%) 7.0 -7.5 pts. > 3 hr.	to 65°-75°F <b>Fluid</b> <sup>2</sup> (20-60 sec) 8.0 -8.5 pts. > 4 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA PON STATISTICA PON STATISTICA 9 months in o Store dry at 4 before using. Concrete gray s: Initial Final	approved. ag at high flow. bag. bag. cons @ 73°F (23°C) L VARIATIONS DEPE METHODS, ACTUAL S riginal, unopened to 0°-95°F (4°-35°C). Corry Pack (10-25%) 5.5 -6.0 pts.	NDING UPON MIXING SITE CONDITIONS AN Dags. Recommend con Plastic (100-125%) 6.5 -7.0 pts.	ID CURING CONDITION ditioning material t Flowable <sup>1</sup> (124-145%) 7.0 -7.5 pts.	bns. to 65°-75°F Fluid <sup>2</sup> (20-60 sec) 8.0 -8.5 pts.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA PON STATISTICA PON STATISTICA 9 months in o Store dry at 4 before using. Concrete gray s: Initial Final	approved. ag at high flow. bag. bag. <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins	NDING UPON MIXING SITE CONDITIONS AN Dags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr.	ID CURING CONDITION Iditioning material t Flowable <sup>1</sup> (124-145%) 7.0 -7.5 pts. > 3 hr.	to 65°-75°F <b>Fluid</b> <sup>2</sup> (20-60 sec) 8.0 -8.5 pts. > 4 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):      Compressive Strength, psi         1 day         3 day         14 day         28 day      Splitting Tensile, psi (ASTM         3 day	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST M 9 months in o Store dry at 4 before using. Concrete gray S: Initial Final ASTM-C-109	approved. ag at high flow. bag. bag. <b>Drs @ 73°F (23°C)</b> L VARIATIONS DEPE IETHODS, ACTUAL S riginal, unopened R 0°-95°F (4°-35°C). <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins < 2 hrs 5,000 8,000 9,200	NDING UPON MIXING SITE CONDITIONS AN bags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr. < 6 hr. 4,500 6,500 7,000	ID CURING CONDITION ditioning material t (124-145%) 7.0 -7.5 pts. > 3 hr. < 7 hr. 4,000 6,000 6,700	Fluid <sup>2</sup> (20-60 sec)         8.0 -8.5 pts.         > 4 hr.         < 8 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):      Compressive Strength, psi         1 day         3 day         14 day         28 day      Splitting Tensile, psi (ASTM         3 day         7 day	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST M 9 months in o Store dry at 4 before using. Concrete gray S: Initial Final ASTM-C-109	approved. ag at high flow. bag. bag. <b>Drs @ 73°F (23°C)</b> L VARIATIONS DEPE IETHODS, ACTUAL S riginal, unopened R 0°-95°F (4°-35°C). <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins < 2 hrs 5,000 8,000 9,200	NDING UPON MIXING SITE CONDITIONS AN bags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr. < 6 hr. 4,500 6,500 7,000	ID CURING CONDITION ditioning material t (124-145%) 7.0 -7.5 pts. > 3 hr. < 7 hr. 4,000 6,000 6,700	Fluid ²         (20-60 sec)         8.0 -8.5 pts.         > 4 hr.         < 8 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):      Compressive Strength, psi         1 day         3 day         14 day         28 day      Splitting Tensile, psi (ASTM         3 day         7 day         28 day	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST M 9 months in o Store dry at 4 before using. Concrete gray S: Initial Final ASTM-C-109 I C-496)	approved. ag at high flow. bag. bag. <b>Drs @ 73°F (23°C)</b> L VARIATIONS DEPE IETHODS, ACTUAL S riginal, unopened R 0°-95°F (4°-35°C). <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins < 2 hrs 5,000 8,000 9,200	NDING UPON MIXING SITE CONDITIONS AN bags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr. < 6 hr. 4,500 6,500 7,000	ID CURING CONDITION ditioning material t (124-145%) 7.0 -7.5 pts. > 3 hr. < 7 hr. 4,000 6,000 6,700	Fluid <sup>2</sup> (20-60 sec)         8.0 -8.5 pts.         > 4 hr.         < 8 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):      Compressive Strength, psi         1 day         3 day         14 day         28 day      Splitting Tensile, psi (ASTM         3 day         7 day	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST M 9 months in o Store dry at 4 before using. Concrete gray S: Initial Final ASTM-C-109 I C-496)	approved. ag at high flow. bag. bag. <b>Drs @ 73°F (23°C)</b> L VARIATIONS DEPE IETHODS, ACTUAL S riginal, unopened R 0°-95°F (4°-35°C). <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins < 2 hrs 5,000 8,000 9,200	NDING UPON MIXING SITE CONDITIONS AN bags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr. < 6 hr. 4,500 6,500 7,000	ID CURING CONDITION ditioning material t (124-145%) 7.0 -7.5 pts. > 3 hr. < 7 hr. 4,000 6,000 6,700	Fluid ²         (20-60 sec)         8.0 -8.5 pts.         > 4 hr.         < 8 hr.
	SikaGrout® 32     Approximately 0     Multi-wall bags;      Typical Data (Material and o     RESULTS MAY DIFFER BASED U     TEMPERATURE, APPLICATION M     Shelf Life     Storage Conditions      Color     Flow Conditions      Typical Water Requirements     Set Time (ASTM C-191):      Compressive Strength, psi         1 day         3 day         14 day         28 day      Splitting Tensile, psi (ASTM         3 day         7 day         28 day      Flexural Strength, psi (AST	28 is USDA-a 0.44 cu. ft./ba 50 lbs. per b curing condition PON STATISTICA IETHODS, TEST M 9 months in o Store dry at 4 before using. Concrete gray S: Initial Final ASTM-C-109 I C-496)	approved. ag at high flow. bag. bag. <b>Drs @ 73°F (23°C)</b> L VARIATIONS DEPE IETHODS, ACTUAL S riginal, unopened R 0°-95°F (4°-35°C). <b>Dry Pack</b> (10-25%) 5.5 -6.0 pts. <15mins < 2 hrs 5,000 8,000 9,200	NDING UPON MIXING SITE CONDITIONS AN bags. Recommend con Plastic (100-125%) 6.5 -7.0 pts. > 2 hr. < 6 hr. 4,500 6,500 7,000	ID CURING CONDITION ditioning material t (124-145%) 7.0 -7.5 pts. > 3 hr. < 7 hr. 4,000 6,000 6,700	Fluid ²         (20-60 sec)         8.0 -8.5 pts.         > 4 hr.         < 8 hr.

		Bond Strength, psi (ASTM	I C-882 modified):		
		Hardened concrete to pla	astic grout		
		3 day			950
		7 day			1750
		28 day	(10711 0 000)		2000
		Freeze Thaw Cycles Pro	cedures - (ASTM - C-666)		
		300 Cycles RDF 99% <sup>1</sup> CRD C-227: 100-124% (plastic <sup>2</sup> CRD C-611: 10-30 sec efflux tir			
	How to Use				
	Surface Prepara	grouted must b	e de-greased with suitable	I-inhibiting materials by mechani solvent. Concrete must be sour ace should be brought to a SSD	nd and roughened to promote
		coated with bo	nd-breaker for easy remova	rms to retain grout without leaka I. Forms should be sufficiently h achieve, use SikaGrout® 328 in c	high to accommodate head of
	Mixing	a jiffy paddle. S		0-600 rpm) for at least 5 minutes in an appropriately sized mortar	
		may be extend C1260, C227 a	ed with 25 lbs. of 3/8" pea g nd C289), clean, well-grade	ons, SikaGrout <sup>®</sup> 328 (plastic and pravel. The aggregate must be n d, saturated surface dry, have low per Table 2. Add the pea gravel	on-reactive (Reference ASTM w absorption and high density,
		appropriate qua a uniform cons possible to 70°f	antity of clean water to achi istency, minimum of 5 minu	g, mixing, placing, and clean-up eve desired flow. Add bag of po tes. Ambient and material tempo colder, use warm water. Use only DVER WATER!	wder to mixing vessel. Mix to erature should be as close as
	Application	pump, or ram g minimum expos shoulders to de pump recomme	rout as necessary to achieve sed surface. After grout has esigned profile. SikaGrout®	into forms in normal manner to e flow or compaction. SikaGrout <sup>®</sup> achieved final set, remove forms 328 is an excellent grout for pu I Service. Wet cure for a minimu 09 on exposed surfaces.	328 must be confined leaving , trim or shape exposed grout mping, even at high flow. For
	Limitations	<ul> <li>Minimum application</li> <li>For application</li> <li>Do not use an As with all control</li> </ul>	blication thickness: 1/2 in. on thicknesses of 6 inches of s a patching or overlay mor ement based materials, avoi	d contact with aluminum to preve	al Service Department.
			product failure. Insulate po ppropriate epoxy such as S	tential areas of contact by coatir ikadur 32 Hi-Mod.	ng aluminum bars, rails, posts
		INSTRUCTIONS ON THE SHEET WHICH ARE AVAIL PARTMENT AT 800.933.74 TO READ AND FOLLOW T	PRODUCT'S MOST CURREN LABLE ONLINE AT HTTP://US 52 NOTHING CONTAINED IN / THE WARNINGS AND INSTRU	JSER MUST ALWAYS READ AND I PRODUCT DATA SHEET, PRODU A.SIKA.COM/ OR BY CALLING SII ANY SIKA MATERIALS RELIEVES 1 CTIONS FOR EACH SIKA PRODUC SAFETY DATA SHEET PRIOR TO F	ICT LABEL AND SAFETY DATA KA'S TECHNICAL SERVICE DE- 'HE USER OF THE OBLIGATION CT AS SET FORTH IN THE CUR-
		KEEP CONTAINER TIGHTLY CLOSED.	KEEP OUT OF REACH OF CHILDREN. NOT	FOR INTERNAL CONSUMPTION. FOR INDUSTRIA	LUSE ONLY. FOR PROFESSIONAL USE ONLY.
		For further information and advactual Safety Data Sheets conta	vice regarding transportation, han ining physical, ecological, toxicolo	dling, storage and disposal of chemica gical and other safety related data. Reac at 1-800-424-9300, International 703-527	l products, users should refer to the I the current actual Safety Data Sheet
		Data Sheet, product label and S ment at 800-933-7452. Nothing of	afety Data Sheet which are availab contained in any Sika materials reli	nd follow the warnings and instructions of le online at http://usa.sika.com/ or by ca eves the user of the obligation to read an eet, product label and Safety Data Sheet	Iling Sika's Technical Service Depart- d follow the warnings and instruction
r		the current Product Data Sheet Buyer's sole remedy shall be lin EXPRESS OR IMPLIED SHALL J SHALL NOT BE LIABLE UNDER THE USE OF THIS PRODUCT IN A SALE OF SIKA PRODUCTS A CALLING 201-933-8800.	if used as directed within shelf life. hited to the purchase price or replac APPLY INCLUDING ANY WARRANI ANY LEGAL THEORY FOR SPECIA MANNER TO INFRINGE ON ANY P. RE SUBJECT SIKA'S TERMS AN	o be free from manufacturing defects an User determines suitability of product fo ement of product exclusive of labor or or Y OF MERCHANTABILITY OR FITNESS L OR CONSEQUENTIAL DAMAGES. SIK/ ATENT OR ANY OTHER INTELLECTUAL P ID CONDITIONS OF SALE AVAILABLE	r intended use and assumes all risks. bat of labor. NO OTHER WARRANTIES OR A PARTICULAR PURPOSE. SIKA A SHALL NOT BE RESPONSIBLE FOR ROPERTY RIGHTS HELD BY OTHERS. AT HTTP://USA.SIKA.COM/ OR BY
H	R	Visit our website at usa.sika. Regional Information and Sa		<b>1-800-9</b> Dur nearest Sika sales office, contact yo	33-SIKA NATIONWIDE
	ka	Regional information and Sa Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225	Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610	Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro	



Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Fracc. Industrial Balvane Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537

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**Product Data Sheet** Edition 7.24.2014 SikaGrout 428 FS

Description



### SikaGrout<sup>®</sup> 428 FS

High performance, fast setting, non-shrink, cement grout

SikaGrout 428 FS is a non-shrink, non-metallic, cementitious precision grout powered by ViscoCrete tech-

Where Advant Covera Packag

	a fluid consiste	out 428 FS is designed to achieve hig ncy. A structural, precision grout, Sika range of 40°-90°F and meets ASTM-	aGrout 428 F	S can be place	•
e to Use	<ul> <li>For quick tur</li> <li>Grouting of f</li> <li>Non-shrink g columns and</li> <li>Applications</li> <li>To transfer of</li> </ul>	naround applications, when rate of s oundations, windmills, compressors, prouting of machinery and equipment I curtain walls. where a non-shrink grout is needed	trength gain etc. , base plates	is a significant s, sole plates, p	recast panels, beams,
ntages	<ul> <li>Outstanding</li> <li>Excellent flu</li> <li>Nonmetallic,</li> <li>ASTM C-110</li> <li>Shows posit</li> </ul>	ity with one material performance in fluid state idity, sufficient time for placement will not stain or rust. 17 (Grade C). ive expansion as per ASTM C-827.			
age	Approximately	0.50 cu. ft./bag			
ging	65 lb. bag				
		D UPON STATISTICAL VARIATIONS DEPENDI N METHODS, TEST METHODS, ACTUAL SITE One year in original, unopened bag Store dry at 35°-95°F (4°-35°C). R before using.	S.	AND CURING COND	DITIONS.
	Color	Concrete gray			
	5 hours 6 hours 1 day 3 day 7 day 28 day <b>Compressive Strength -</b> 5 hours	ASTM C-109 Plastic @ 6.5 pts./bag ASTM C-109 Flowable @ 7.0 pts./bag	40°F 750 1,000 4,000 5,500 7,500 11,000 500	73°F 2,500 3,500 7,000 9,500 12,000 13,000 2,000	90°F 6,000 7,000 9,000 11,000 12,000 13,000 5,000
	6 hours 1 day 3 day 7 day 28 day Compressive Strength -	ASTM C-109 Fluid @ 1 gal./bag	750 3,500 5,000 7,000 10,500	3,000 7,000 9,000 11,000 12,500	5,500 7,000 9,500 11,000 12,500
	5 hours 6 hours 1 day 3 day 7 day 28 day		< 200 < 500 3,250 6,000 7,500 10,000	1,000 3,000 7,500 8,500 10,000 12,000	4,000 6,000 8,000 8,500 10,000 12,000
	Bond Strength - ASTM C 1 Day 7 Days 28 Days	-882		1,800 2,200 2,500	

	1 Day	200	<u>73°F</u> >400	>450
	7 Day 28 Day	400 450	>500 >550	>500 >550
	Flow	<45 sec	>30 sec	>30 sec
	Effective Bearing Area	>95%	>95%	>95%
	Initial Set		30 minutes	
	Final Set		45-60 minutes	
	Expansion			
	1 Day	Positive	Positive	Positive
	7 Day	Positive	Positive	Positive
	28 Day	Positive	Positive	Positive
	Permeability			
	ASTM C-1202, 28 days at 60 volts		<1,000	
How to Use				
Surface Preparatio	grouted must be de-greased wi	th suitable solvent.	Concrete must be	chanical means. Anchor bolts to be sound and roughened to promote SSD (saturated surface-dry) condi-
		asy removal. Forms	s should be sufficier	eakage. Forms should be lined or ntly high to accommodate head of FS in dry pack consistenc.
Mixing	or a jiffy paddle. SikaGrout 428 continue until a homogenous m time should be approximately 3 <b>Product Extension:</b> For deepe may be extended with 30 lbs. o	FS can be mixed i ixture is achieved. I minutes. r applications, Sika f 3/8" pea gravel. Th	in an appropriately Do not over mix. On Grout 428 FS (plast ne aggregate must	inutes using a Sika mixing paddle sized mortar mixer. Mixing should ce all the powder is added the mix ic and flowable consistencies only) be non-reactive (Reference ASTM re low absorption and high density,
	and comply with ASTM C33 size 428 FS.	e number 8 per Tabl	e 2. Add the pea gr	avel after the water and SikaGrout
Application	and comply with ASTM C33 size 428 FS. <b>Mixing Procedure:</b> Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confi remove forms, trim or shape ex	a number 8 per Table a all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. after mixing, place result in faster than er mixing. Vibrate, r ned leaving minimu sposed grout should	e 2. Add the pea gr g, placing, and clea ve desired flow. Add nutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting the am grout as necess im exposed surface lers to designed pro-	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For e warm water. Use only amount of /ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that sary to achieve flow or compaction. . After grout has achieved final set, ofile. Wet cure for a minimum of 3
	and comply with ASTM C33 size 428 FS. <b>Mixing Procedure:</b> Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confi remove forms, trim or shape ex days or apply a water based cu	a number 8 per Table a all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. a after mixing, place result in faster than er mixing. Vibrate, r ined leaving minimu posed grout should ring compound whit	e 2. Add the pea gr g, placing, and clea ve desired flow. Add nutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting til am grout as necess im exposed surface ders to designed pri- ch complies with AS	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For a warm water. Use only amount of (ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that eary to achieve flow or compaction. . After grout has achieved final set, ofile. Wet cure for a minimum of 3 6TM C-309 on exposed surfaces.
Application Limitations	and comply with ASTM C33 size 428 FS. <b>Mixing Procedure:</b> Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confi remove forms, trim or shape ex days or apply a water based cu Minimum ambient and substr Minimum application thickness Typical max. application for n	a number 8 per Table a all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. a after mixing, place result in faster than er mixing. Vibrate, r ined leaving minimu sposed grout should ring compound whice ate temperature 40° ss: 1/2 in. eat grout is 2 in. Fo ended applications,	e 2. Add the pea gr g, placing, and clea ve desired flow. Add nutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting the am grout as necess in exposed surface ders to designed pro- ch complies with AS °F and rising at time r deeper pours, ext min. application th	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For a warm water. Use only amount of (ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that eary to achieve flow or compaction. . After grout has achieved final set, ofile. Wet cure for a minimum of 3 6TM C-309 on exposed surfaces.
	<ul> <li>and comply with ASTM C33 size 428 FS.</li> <li>Mixing Procedure: Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confirremove forms, trim or shape ex days or apply a water based cu</li> <li>Minimum ambient and substr</li> <li>Minimum application thicknes</li> <li>Typical max. application for n aggregate is advised. For ext would be 6 in.</li> </ul>	a number 8 per Table a all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. a after mixing, place result in faster than er mixing. Vibrate, r ined leaving minimu sposed grout should ring compound whice ate temperature 40° ss: 1/2 in. eat grout is 2 in. Fo ended applications, overlay mortar or in	e 2. Add the pea gr g, placing, and clea ve desired flow. Add nutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting tii am grout as necess im exposed surface lers to designed pro- ch complies with AS °F and rising at time r deeper pours, ext min. application th unconfined areas.	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For e warm water. Use only amount of (ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that eary to achieve flow or compaction. . After grout has achieved final set, offile. Wet cure for a minimum of 3 GTM C-309 on exposed surfaces. e of application. ending grout with recommended
	<ul> <li>and comply with ASTM C33 size 428 FS.</li> <li>Mixing Procedure: Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confirremove forms, trim or shape ex days or apply a water based cu</li> <li>Minimum ambient and substr</li> <li>Minimum application thicknes</li> <li>Typical max. application for n aggregate is advised. For ext would be 6 in.</li> <li>Do not use as a patching or constrained in the grout.</li> <li>As with all cement based material must be placed material mat</li></ul>	a number 8 per Table a all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. a after mixing, place result in faster than er mixing. Vibrate, r ined leaving minimu goosed grout should ring compound whice ate temperature 40° ss: 1/2 in. eat grout is 2 in. Fo ended applications, overlay mortar or in n 10 minutes of mix temperatures will r	le 2. Add the pea gr g, placing, and clea ve desired flow. Add nutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting the am grout as necess im exposed surface ders to designed pro- ch complies with AS °F and rising at time r deeper pours, ext min. application th unconfined areas. cing. esult in reduced wo	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For a warm water. Use only amount of (ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that sary to achieve flow or compaction. . After grout has achieved final set, ofile. Wet cure for a minimum of 3 STM C-309 on exposed surfaces. e of application. ending grout with recommended ickness will be 1 in. and the max.
	<ul> <li>and comply with ASTM C33 size 428 FS.</li> <li>Mixing Procedure: Make sure ap-proximately one gallon of cl Mix to a uniform consistency, warmer temperatures use cold water necessary to achieve hom Within no more than 10 minutes ment. Mixed grout in mass will the grout can be placed right aft SikaGrout 428 FS must be confirremove forms, trim or shape ex days or apply a water based cu</li> <li>Minimum ambient and substr</li> <li>Minimum application thicknes</li> <li>Typical max. application for n aggregate is advised. For ext would be 6 in.</li> <li>Do not use as a patching or constrained in the grout.</li> <li>As with all cement based material must be placed material mat</li></ul>	a number 8 per Table all forming, mixing ean water to achiev maximum of 3 mir water and for colde nogeneous mixture. after mixing, place result in faster than er mixing. Vibrate, r ined leaving minimu crosed grout should ring compound whice at temperature 40° ss: 1/2 in. eat grout is 2 in. Fo ended applications, overlay mortar or in n 10 minutes of mix temperatures will r terials, avoid contact ure. Insulate potenti e epoxy such as Sik	le 2. Add the pea gr g, placing, and clea ve desired flow. Add hutes. Condition pr er temperatures use DO NOT OVER W grout into forms in expected setting the am grout as necess mexposed surface bers to designed pr ch complies with AS °F and rising at time r deeper pours, ext min. application th unconfined areas. dr sult in reduced wo ct with aluminum to al areas of contact adur 32 Hi-Mod.	avel after the water and SikaGrout an-up materials are on hand. Add d bag of powder to mixing vessel. oduct to room temperatures. For a warm water. Use only amount of ATER! normal manner to avoid air entrap- mes. Plan jobs accordingly so that sary to achieve flow or compaction. . After grout has achieved final set, ofile. Wet cure for a minimum of 3 STM C-309 on exposed surfaces. e of application. ending grout with recommended ickness will be 1 in. and the max.

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PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

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# **E** - Total Corrosion Management

Sika FerroGard 650, 670, 675 Sika FerroGard 903 Sika FerroGard 908 Sika Ebonex E10 A400 A410 usa.sika.com



**BUILDING TRUST** 



**Product Data Sheet** Edition 1.8.2016

Sika° FerroGard°

### Sika° FerroGard° 650, 670, 675

Embedded Galvanic Anode

Description		Anodes are engineered zinc anod ed in a proprietary mortar designe	es used for the protection of reinforcing steel in concret d to optimize performance.
Where to Use	Patch repairs within conc		d existing concrete. Effective in chloride contaminated an
Advantages	zinc anode and corros	1 1 1 37 1	vides excellent transport of reactants to the surface of th e of the zinc, using a chelation process. The encasing
	Proven technology –	supported by 10+ years of developr	nent and testing.
	<ul> <li>Cost Effective – lower</li> </ul>	s Life Cycle Cost of repairs.	
	<ul> <li>Auto-Corrosion – enc</li> </ul>	asing mortar maintains performan	ce but does not auto- or self-corrode the zinc anode.
	Ease of Installation -	uses standard attachment metho	ds known to industry.
	<ul> <li>Self-Powered / Self R</li> </ul>	egulating – creates own protective	e current that adjusts to demand.
	<ul> <li>Maintenance Free – re</li> </ul>	equires no monitoring or maintena	nce.
	<ul> <li>Safe to Use – protects to handle without PPE</li> </ul>		ost-tension reinforcing steel; moderate pH safe
		d steel tie wires (annealed) are pre les a better electrical contact and e	-twisted to form a cradle that accepts extends "throwing power".
	Service Life - canable	of 10+ years of protection dependi	ng on design and conditions.
	Typical Data RESULTS MAY DIFFER B		DEPENDING UPON MIXING METHODS AND EQUIPMENT, FUAL SITE CONDITIONS AND CURING CONDITIONS.
	Typical Data RESULTS MAY DIFFER B	ATION METHODS, TEST METHODS, AC	
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC	ATION METHODS, TEST METHODS, AC	rual SITE CONDITIONS AND CURING CONDITIONS.
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes.	rual SITE CONDITIONS AND CURING CONDITIONS.
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu	rUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance:
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650:	rual site conditions and curing conditions. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup>
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 675:	rual site conditions and curing conditions. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup>
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC. Zinc Anode:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she	rual site conditions and curing conditions. <b>II, Standard Specification for Cast and Wrought Gal-</b> <b>m performance:</b> 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup>
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC. Zinc Anode: Shelf Life	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> If life of 5 years.
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLIC, Zinc Anode: Shelf Life Storage Conditions Electro-Potential:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> If life of 5 years. tratures >100°F
	Typical Data         RESULTS MAY DIFFER B         TEMPERATURE, APPLICA         Zinc Anode:         Shelf Life         Storage Conditions	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 675: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150 738 A-hr/kg	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> 1f life of 5 years. ratures >100°F 0 mV, CSE (water saturated)
	Typical Data RESULTS MAY DIFFER B TEMPERATURE, APPLICA Zinc Anode: Zinc Anode: Shelf Life Storage Conditions Electro-Potential: Capacity:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> 1f life of 5 years. ratures >100°F 0 mV, CSE (water saturated)
	Typical Data         RESULTS MAY DIFFER B         TEMPERATURE, APPLIC.         Zinc Anode:         Zinc Anode:         Shelf Life         Storage Conditions         Electro-Potential:         Capacity:         Auto-Corrosion:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150 738 A-hr/kg <0.1 mm / yu	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> 1f life of 5 years. Iratures >100°F 0 mV, CSE (water saturated) Par
	Typical Data         RESULTS MAY DIFFER B         TEMPERATURE, APPLIC.         Zinc Anode:         Zinc Anode:         Shelf Life         Storage Conditions         Electro-Potential:         Capacity:         Auto-Corrosion:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150 738 A-hr/kg <0.1 mm / yu ~11.5 Anode	TUAL SITE CONDITIONS AND CURING CONDITIONS. II, Standard Specification for Cast and Wrought Gal- m performance: 21 in <sup>2</sup> 40 in <sup>2</sup> 42 in <sup>2</sup> Uf life of 5 years. ratures >100°F 0 mV, CSE (water saturated) Par Mass
	Typical Data         RESULTS MAY DIFFER B         TEMPERATURE, APPLIC.         Zinc Anode:         Zinc Anode:         Shelf Life         Storage Conditions         Electro-Potential:         Capacity:         Auto-Corrosion:	ATION METHODS, TEST METHODS, AC Conforms to ASTM B418 Type vanic Zinc Anodes. High Surface Area for optimu Sika° FerroGard° 650: Sika° FerroGard° 670: Sika° FerroGard° 675: Nominal she Avoid tempe -850 to -1150 738 A-hr/kg <0.1 mm / yu ~11.5	TUAL SITE CONDITIONS AND CURING CONDITIONS.

FerroGard<sup>®</sup> 675





PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

160 g

How to Use Spacing	Multiple factors must be considered to determine the spacing of the FerroGard® anode, including the structure's temperature moisture content, chloride content, the steel surface area and placement. In most applications, the spacing should not excee 30 inches. A design engineer should always be consulted to confirm final requirements. Consult FerroGard® Anode Calculatio sheet for engineered designs or refer to the Maximum Anode Spacing Chart below.
Installation	<b>Surface Preparation:</b> All loose and spalled concrete should be removed in accordance with ICRI Guideline No. 310.1R-200 Guideline for Surface Preparation for the Repair of Deteriorated Concrete Resulting from Reinforcing Steel Corrosion. The Sik FerroGard <sup>®</sup> anode positioning should be considered when removing the existing concrete.
	<b>Positioning:</b> In most applications, the FerroGard <sup>®</sup> anode should be positioned at the perimeter of the repair and on plan with the reinforcing steel to provide a proper level of cover. Anodes must be positioned so that the entire anode and the wir connections to the reinforcing steel are totally covered by the encasement material once the repair is complete. Note: Do not modify the shape of the anode to fit a hole.
	<b>Preparation:</b> For correct electrical connection and anode function, the surface of the reinforcing steel should be untreate and cleaned to a near white surface condition in areas designated for the connection of the FerroGard <sup>®</sup> anode. Refer to SSP SP-10. Note, pre-soaking the SIKA FerroGard <sup>®</sup> anodes in clean water for several minutes prior to installation is recommende to minimize dehydration of the repair mortar.
	<b>Continuity:</b> The reinforcing steel within the patch area should be tested for continuity: DC resistance between bars should $t \le 1 \Omega$ . Make continuity corrections, if needed, by welding steel bonding wire between bars to achieve a DC resistance $\le 1 \Omega$ .
	Attaching: Tighten the two pairs of pre-twisted wires around the reinforcing steel in a double wrap pattern to achieve a sour electrical bond. The pre-twisted wire connectors provide a sound base, good electrical contact and proper spacing from th reinforcing steel to which the anode is attached. No additional form of attachment or electrical connection is necessary. Not Use only the connector wires attached to the anode; do not use supplementary connection methods between the connector loops and the rebar nor use a twisting tool to tighten the wires.
	<b>Verification:</b> Verify sound electrical connection of the FerroGard <sup>®</sup> system to the reinforcing steel by checking for a DC resistance $\leq 1 \Omega$ .
	<b>Note:</b> Conventional, commercially available repair mortars should be used to repair the concrete and encase the FerroGarc anodes. The mix should have a resistivity of $\leq 20,000 \ \Omega$ -cm. High polymer content and silica fume should not be used in th mix. If the repair design requires a mix with resistivity >20,000 $\Omega$ -cm, encase the anode and bridge the area between th anode and the existing concrete with SikaRepair <sup>®</sup> 222 (with water) or SikaRepair <sup>®</sup> 223 (with water). Place encasement materia in accordance with conventional techniques to assure good consolidation.
	Do not use any form of battery or impressed current in association with the FerroGard <sup>®</sup> anode or apply an electrical current to the reinforcing steel prior to or after the repair. Do not install a preformed high resistivity or non-conductive barrier between the FerroGard <sup>®</sup> anode and the reinforcing steel. Do not apply corrosion inhibitors directly on the FerroGard <sup>®</sup> anode body connecting wires, especially on or near the wire connection point with the reinforcing steel.



l content <1% by weight of cement, or Steel Potential more positive than -350 mV, CSE					
	FerroGard® 650	FerroGard® 670	FerroGard® 675		
Steel Density Ratio	inches	inches	inches		
<0.2	28	30	31		
0.21-0.46	25	27	28		
0.47-0.70	22	25	27		
0.71-0.93	20	23	25		
0.94-1.15	18	22	24		
1.16-1.36	16	20	22		
1.37-1.56	15	19	21		
1.57-1.75	14	19	21		
1.75-1.93	13	18	20		
1.94-2.1	12	17	19		

#### Maximum Anode Spacing for High Corrosion Risk Environment

Cl content >1% by weight of cement, or Steel Potential more negative than -350 mV, CSE						
	FerroGard® 650	FerroGard® 670	FerroGard® 675			
Steel Density Ratio	inches	inches	inches			
<0.2	25	27	28			
0.21-0.46	22	24	25			
0.47-0.70	19	22	24			
0.71-0.93	17	20	22			
0.94-1.15	15	19	21			
1.16-1.36	13	17	19			
1.37-1.56	12	16	18			
1.57-1.75	11	16	18			
1.75-1.93	10	15	17			
1.94-2.1	9	14	16			

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KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY ON FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO

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CALLING 201-933-8800. 1-800-933-SIKA NATIONWIDE Visit our website at usa.sika.com

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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construction

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# F - Liquid Applied Roofing & Waterproofing

Sikalastic Protective Waterproofing Sikalastic 320	F10
Sikalastic DeckPro Traffic Systems	
1 Component	
Sikalastic 710/715/735 AL Traffic System	F20
Sikalastic 710 Lo-VOC/715 Lo-VOC/736 AL	F30
Lo-VOC Traffic System	
Sikalastic 710 NP Base	F40
Sikalastic 715 Lo-VOC/715 Lo-VOC Traffic System	F50
2 Component	
Sikalastic 720/745 AL Traffic System	F60
Sikalastic 720 SG Base	F70
Sikalastic 390/391/395 Traffic System	F80
Decorative	
Sikalastic 735 AL/736 AL Lo-VOC/748 PA	F90
Hybrid	
Sikalastic 22 Lo-Mod Hybrid Traffic System	F100
Primers	
Sikalastic FTP Primer	F110
Sikalastic FTP Lo-VOC Primer	F120
Sikalastic PF Lo-VOC Primer	F130
Sikalastic MT Primer	F140
Sikalastic Recoat Primer	F150

#### Sikalastic RoofPro Resins

Resins	
Sikalastic 601BC/621 TC	F160
Sikalastic 624 WP	F170
Sikalastic 641	F180
Sikalastic 641 Lo-Voc	F190
Sikalastic 600 Accelerator	F200
Sikalastic Clearglaze	F210
Reinforcements	
Sika Reemat Standard and Premium	F220
Sika Fleece 120, 140, 170	F230
Sika Flexitape Heavy	F240
Sika Joint Tape SA	F250
Primers	
Sika Joint Tape SA Primer	F260
Sika Concrete Primer	F270
Sikalastic DTE Primer	F280
Sikalastic EP Primer	F290
Sika Reactivation Primer	F300
Sika Bonding Primer	A430
Insulations and Cover Boards	
Sarnatherm ISO Insulation (20 psi)	usa.sika.com
Sarnatherm ISO Insulation (25 psi)	usa.sika.com
Sarnatherm Tapered ISO Insulation (20 psi)	usa.sika.com
Sarnatherm Tapered ISO Insulation (25 psi)	
Sarnatherm XPS Insulation	usa.sika.com
Securock Gypsum Fiber Roof Board	usa.sika.com
Securock Cement Roof Board	usa.sika.com
Dens Deck Roof Board	usa.sika.com
Adhesives and Fasteners	
Sarnacol OM Board Adhesive	usa.sika.com
Sarnafastener #12	usa.sika.com
Sarnafastener #14	usa.sika.com
Sarnafastener CD10	usa.sika.com
Sarnaplate	usa.sika.com
Vapor Barriers and Primers	
Sarnavap Self-Adhered Vapor/Air Barrier	usa.sika.com
Sarnavap Self-Adhered Primer	usa.sika.com
Sarnavap Self-Adhered Primer WB	usa.sika.com
Sarnavap Self-Adhered Primer VC	usa.sika.com
Accessories	
Sarnapaver	usa.sika.com
Sika Drainage Mats	usa.sika.com
Edge Grip Fascia	usa.sika.com
Edge Grip Extruded Fascia	usa.sika.com
Wall Grip Coping	usa.sika.com
Wall Grip Coping Plus	usa.sika.com
2	



**BUILDING TRUST** 

**Product Data Sheet** Edition 7.26.2016 Identification no. Sikalastic® 320

### Sikalastic<sup>®</sup> 320 NS/SL

Single Component, Bitumen Modified Waterproofing Membrane

Description	Sikalastic® 320 is a single component, liquid applied, bitumen modified, coal tar free, moisture cured polyurethane waterproofing membrane available in self-leveling and non-sag consistencies.
Where to Use	<ul> <li>Planters</li> <li>Green and Inverted Roofs</li> <li>Between Slabs</li> <li>Plazas and Pavers</li> <li>Foundation Walls</li> <li>Bridges and Tunnels</li> </ul>
Advantages	<ul> <li>Easy Application</li> <li>Applies on green and damp concrete</li> <li>Alkali Resistant</li> <li>Quick Re-coat time</li> <li>Ability to catalyze with water <ul> <li>Faster cure rate</li> <li>Reduce chance of pinholes from concrete out-gassing</li> <li>Apply at any thickness horizontally</li> </ul> </li> </ul>
Packaging	5 gallon (18.9 liter) pail. 55 gallon drum, net fill 50 gallons (189 liters)

Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	One year from date containers	of manufacture in original, factory-sealed		
Storage Conditions	Store indoors at terr	nperatures between 60-95°F (15-35°C).		
Colors	Black			
Coverage	50 ft²/gal results in	30 ± mils DFT		
	25 ft²/gal results in	60 ± mils DFT (standard)		
	18 ft²/gal results in 1	90 ± mils DFT		
	13 ft²/gal results in 1	120 ± mils DFT		
Total Volume Solids (AS	TM D-2697)	96 ± 2%		
Total Weight Solids (AS	TM D-236)	95 ± 2%		
VOCs (ASTM D-2369-81)		48 g/L		
Tensile Strength (ASTM	D-412)	500 psi ± 50 psi   2.1 ± 0.3 Mpa		
Elongation at Break (AS	TM D-412)	350% ± 50%		
Tear Resistance (Die C, A	ASTM D-624)	50 ± 10 psi		
Hardness (ASTM D-2240	))	92 Shore A		
Specific Gravity		1.2 ± 0.2		
Viscosity at 80°F (27°C)		25-45 cps (SL) 150-250 cps (NS)		
Service Temperature		-25°F to 200°F (-31.7°C to 93.3°C)		
Application on Green Co	ncrete			
Horizontal		48 hours or walkable conditions		
Vertical		24 hours after forms removed		



How To Use Surface Preparation	Surfaces may be dry or damp, but must be sound and free of standing water, dust, laitance, greas curing compounds, impregnations, waxes and any other contaminants. Some warranties require or coat of Sikalastic PF Lo-VOC Primer on horizontal surfaces before application of Sikalastic 320.
Mixing	Before application, Sikalastic® 320 should be thoroughly mixed using a mechanical mixer and jiffy sty paddle at slow speed for 1.5 minutes minimum to ensure a homogeneous material. Take care not t allow entrapment of air into the material. Do not mix in an up and down motion.
	Using Optional Water Catalyst: Before application, mix Sikalastic <sup>®</sup> 320 using a mechanical mixer an jiffy style mixing paddle at a slow speed. At a ratio 1 part of water to no less than 40 parts Sikalastic 320. For a 5 gal pail, add 1 pint (16 oz) of water (less water may be used to extend working time). Us care not to allow the entrapment of air into the mixture. Do not mix in an up and down motion. One water is mixed with Sikalastic <sup>®</sup> 320 apply within 20 minutes.
Application	Sikalastic® 320 may be applied with a brush, squeegee, trowel, or roller up to 90 mils vertically an 120 mils horizontally per coat. Mix Sikalastic® 320 with water to greatly reduce the chance of pinho formation from concrete out-gassing and improve cure rate. Cured membrane must be pinhole fre after application to validate warranty.
	Flood Test: After Sikalastic <sup>®</sup> 320 has cured, plug drains and provide proper means to contain flood wate Flood deck with a 2" head of water and allow to stand for 24 hours. Check for leaks and immediate make repairs if required. Retest after any repairs have been made. If a flood test cannot be complete in within 3 days of application, cover Sikalastic <sup>®</sup> 320 with a protection course to prevent damage from other trade work until a successful flood test is completed.
	<b>Membrane Protection:</b> As soon as possible after completion of a successful water test, visual inspectic and/or repairs, cover all horizontal membranes with an approved drainage mat and optional protectic board. Sikalastic <sup>®</sup> 320 should not be exposed to sunlight or UV radiation for more than 14 days. For a vertical membranes, cover immediately after cure with a protection course.
	Joints, Cracks and Flashing: For all cracks up to 1/16" in width apply a 4" wide, 30 mil stripe coat of Sikalastic® 320 centered over the crack. All cracks over 1/16" in width must be routed to at least ¼" to ¼" sealed with the appropriate Sikaflex® sealant and coated with a 4" wide, 30 mil stripe coat centered on the sealant. When sealing green concrete, use Sikaflex® 1a+. Reinforcing fabric may be required for metal flashing transitions, plywood seams, and expansion joints by embedding reinforcing in 15 mi of membrane then coating with another 15 mils of membrane. Metal surfaces should be primed wit Sikalastic® EP Primer the day before application of Sikalastic® 320 detail coats.
	<b>Curing and Recoating:</b> At 75°F (24°C) and 50% relative humidity, allow each coat of Sikalastic <sup>®</sup> 320 t cure 16-24 hours* minimum. When using water as a catalyst: allow Sikalastic <sup>®</sup> 320 to cure a minimu of 2-4 hours* before proceeding to subsequent coats. If more than 48 hours pass between coats th surface must be solvent wiped and primed with Sikalastic EP Primer.
Removal/ Equipment Cleanup	Equipment should be immediately cleaned with an environmentally safe solvent, as permitted unde local regulations.
Limitations	<ul> <li>*Higher temperatures and/or high humidity will accelerate the cure time. In cold weather conditions, use pail warmers or preconditioning to assist in workability.</li> <li>Sikalastic<sup>®</sup> 320 should not be submerged or subject to ponding for more than 72 hours.</li> <li>Containers that have been opened must be used as soon as possible.</li> <li>Not recommended for Oriented Strand Board (OSB) or asphalt surfaces.</li> <li>Membrane should not be applied under thin set tile. Mortar beds applied above Sikalastic<sup>®</sup> 320 should be at least 2" thick.</li> <li>Do not apply to porous or damp surfaces where moisture vapor transmission will occur during application and cure. Exposure to direct sunlight can exacerbate vapor transmission during cure. Apply Sikalastic<sup>®</sup> 320 in shaded areas and/or during falling temperatures or contact Sika for use of a suitable primer in this situation</li> </ul>
INST SHE PAR' TION CUR	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGA I TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
For furt actual S	NTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONI ther information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to th Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data She using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.
Prior to Data Sh ment at	each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Produ neet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depa 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction of Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to
the curr Buyer's EXPRE' SHALL THE US SALE ( CALLIN Visit of U	arrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties of rent Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risk is sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIE SS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIK NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FC E OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHER DF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR E IG 201-933-8800. ur website at usa.sika.com 1-800-933-SIKA NATIONWIDE
Region Sil 20 Ly Ph	In Website at Usacistical Control       Silva Canada Inc.       Silva Mexicana S.A. de C.V.       Carretera Libre Celaya Km. 8.5       Silva Canada Inc.       Silva Canada Inc.

Construction

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610







Single component, elastomeric, crack-bridging, waterproofing traffic system

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Description	The Sikalastic 710/715/735 Traffic System is a single component, aromatic, moisture cured, elastomeric poly- urethane coating system designed for use as a waterproofing membrane for pedestrian and vehicular traffic bearing surfaces. Optional aliphatic top coat provides enhanced UV resistance and color stability. System components are:					
	Sikalastic FTP primer (see separate data s	sheet)				
	Sikalastic MT primer (moisture-tolerant pri	mer - see separate				
	Sikalastic 710 Base one-component arom					
	Sikalastic 715 Top one-component aromat Sikalastic 735 AL Top, one-component alig	to polyurethane top	LIV-resistant top coa	v exposure) at		
	Sikalastic 700 ACL optional accelerator					
Where to Use	Sikalastic 710/715/735 AL Traffic System plywood surfaces exposed to vehicular or Multi-story parking garages Parking decks and ramps		on structurally sound	d concrete, cementitious		
	<ul> <li>Foot bridges and walkways</li> </ul>					
	Mechanical rooms					
	<ul> <li>Stadiums and arenas</li> </ul>					
	<ul><li>Plaza and rooftop decks</li><li>Balconies</li></ul>					
dvantages	Excellent crack-bridging properties and	flexibility, even at lo	w temperatures			
	Outstanding resistance to abrasion and labeled and the second delation and the second delation of the second de	wear				
	<ul> <li>Impervious to water and deicing salts</li> <li>Range of standard colors</li> </ul>					
Coverage	Coverage rates provided are intended to a	chieve required wet	film thickness unde	er optimal conditions. Ac		
<b>..</b>	tional material may be required depending					
	tional material may be required depending.			ia rata		
	temperatures, and other site-dependent fa	ctors. This will resul	t in a lower coverag	je rale.		
	temperatures, and other site-dependent fa					
Cure Mechanism Packaging	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure Sikalastic 710 Base and 715 Top: 5 gal. p	ails, 50 gal. (net) dru	ecorative quartz/flal			
	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure	ails, 50 gal. (net) dru I. pails - tint base)	ecorative quartz/flal			
	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure Sikalastic 710 Base and 715 Top: 5 gal. p Sikalastic 735 AL Top: 5 gal. pails (4.65 ga Sikalastic 700 ACL: 1 quart cans (6 cans	ats data sheet for d ails, 50 gal. (net) dru I. pails - tint base) per carton)	ecorative quartz/flal	ke systems.		
	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure Sikalastic 710 Base and 715 Top: 5 gal. p Sikalastic 735 AL Top: 5 gal. pails (4.65 ga	ats data sheet for d ails, 50 gal. (net) dru I. pails - tint base) per carton)	ecorative quartz/flal	ke systems.		
	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure Sikalastic 710 Base and 715 Top: 5 gal. p Sikalastic 735 AL Top: 5 gal. pails (4.65 ga Sikalastic 700 ACL: 1 quart cans (6 cans	ats data sheet for d ails, 50 gal. (net) dru I. pails - tint base) per carton) conditions @ 75°F	ecorative quartz/flal ums <i>(24°C) and 50% R</i> DING UPON MIXING ME <sup>*</sup>	Ke systems.		
	temperatures, and other site-dependent fa See Sikalastic Aliphatic Decorative Top Co Moisture Cure Sikalastic 710 Base and 715 Top: 5 gal. p Sikalastic 735 AL Top: 5 gal. pails (4.65 ga Sikalastic 700 ACL: 1 quart cans (6 cans <b>Typical Data</b> ( <i>Material and curing</i> RESULTS MAY DIFFER BASED UPON STATISTIC	aits data sheet for d ails, 50 gal. (net) dru I. pails - tint base) per carton) conditions @ 75°F	ecorative quartz/flal ums <i>(24°C) and 50% R</i> DING UPON MIXING ME <sup>*</sup>	Ke systems. H) THODS AND EQUIPMENT, JRING CONDITIONS.		
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How to Use Surface Preparation	Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compounds bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to application.
	<b>Concrete-</b> Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).
	<ul> <li>Route out all cracks and joints as part of surface preparation.</li> <li>Plywood- Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported according to APA guidelines. Joints should be sealed and detailed following deck priming, and may need embedded fabric reinforcement.</li> <li>Metal- Should be thoroughly cleaned by grinding or blast cleaning.</li> </ul>
Application	Priming           Primer Selection - Determine maximum moisture content of concrete substrate by weight with a Tramex CME or CMExpert type concrete moisture meter.
	Sikalastic FTP Primer – For concrete decks with a maximum moisture content of 4% by weight, and for plywood decks, apply Sikalastic FTP Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided Sikalastic FTP Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.
	Sikalastic FTP Lo-VOC Primer - For exterior exposed concrete decks with a maximum moisture content of 4% by weight, interior protected concrete decks with a maximum moisture content of 5% by weight, and plywood decks, apply Sikalastic FTP Lo-VOC Primer with a flat squeegee or phenolic resin core roller a approximately 300 sf/gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. For exterior exposed concrete decks with a maximum moisture content of 5% by weight two applications of Sikalastic FTP Lo-VOC Primer are required. Sikalastic FTP Lo-VOC Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.
	<b>Sikalastic PF Lo-VOC Primer -</b> For concrete and plywood decks with a porous or rough surface, and for meta flanges and penetrations, use Sikalastic PF Lo-VOC Primer. For exterior exposed concrete decks with a maxi mum moisture content of 4% by weight, interior protected concrete decks with a maximum moisture content o 5% by weight, and plywood decks, apply Sikalastic PF Lo-VOC Primer with a flat squeegee or phenolic resin core roller at approximately 200 sf/gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. For exterior exposed concrete decks with a maximum moisture content o 5% by weight, two applications of Sikalastic PF Lo-VOC Primer are required. Refer to separate primer data sheet for additional information.
	<b>Sikalastic MT Primer -</b> For concrete with a maximum moisture content of 5% by weight, and for metal flanges and penetrations, apply Sikalastic MT Primer with a flat squeegee or roller at approximately 175 sf/gal. Fo concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic M <sup>T</sup> Primer with a flat squeegee or phenolic resin roller at approximately 175 sf/gal per application. Work prime well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Refer to separate primer data sheet for additional information.
	<b>Sikalastic Recoat Primer</b> – For existing polyurethane coatings, incidental exposed concrete deck areas, and as an interlaminate primer, apply Sikalastic Recoat Primer with a flat squeegee or phenolic resin core rolle at approximately 300 sf/gal. and work will into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Sikalastic Recoat Primer is not suitable for metal substrates. Refer to separate prime data sheet for additional information.
	Primer Mixing
	Sikalastic FTP Primer – Premix Part A and Part B components separately using a low speed (400-600 rpm mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Sikalastic FTP Part B is dark olive green in color and may appear black in the container. Sikalastic FTP Part A is light amber in color. Add the 1 gallon of Sikalastic FTP Part A to the 1.25 gallons of Part B in the short filled Part B pail. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). This mixture will appear as a light olive green color. Slowly add 1.25 gallons of potable water to the mixture under agitation. Mix for ar additional 2 minutes until the mixture is fully dispersed. Fully dispersed material will appear as light yellow to white in color.
	<b>Sikalastic FTP Lo-VOC Primer -</b> Premix Part A (blue liquid) and Part B (yellow liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform colo (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For the 3 gal lon kit, pour Part B into Part A slowly and while mixing scrape the side of the container, For the 15 gallon kit pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 2 parts A to 1 part B Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 30 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.
Kal	R TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND RUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- MENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION EAD AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

**Sikalastic PF Lo-VOC Primer -** Premix Part A (black liquid) and Part B (white liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 gallon kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic MT Primer** - Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

Sikalastic Recoat Primer – Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part A into a separate container. Pour Part B into Part A slowly and while mixing scrape the side of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). In the event that a faster cure is required, Sikalastic Recoat Primer can be applied with Sikalastic 700 ACL as an accelerator. Add two quarts Sikalastic 700 ACL into 10 gallons of mixed primer. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

#### <u>Detailing</u>

Non-structural cracks up to 1/16 inch - Apply a detail coat of Sikalastic<sup>®</sup> 710 Base at 32 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.

**Cracks and joints over 1/16 up to 1 inch -** Rout and seal with Sikaflex<sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic<sup>®</sup> 710 Base at 32 mils, 4" wide, centered over the crack. Allow to become tack free before over coating.

Joints over 1 inch - Should be treated as expansion joints and brought up through the Sikalastic<sup>®</sup> 710 Base waterproofing membrane and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant.

**Fabric Reinforcement** – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.

Panelized Joints - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.

NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.

#### Base Coat

Thoroughly mix Sikalastic 710 Base using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 1/4" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and control joints. Allow coating to cure a minimum of 16 hours at 70 degrees F and 50% RH or until tack free before top coating.

#### **Top Coats**

Thoroughly mix Sikalastic 715 Top and Sikalastic 735 AL using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, or phenolic resin core roller, and backroll. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating and backroll if required (see System Guide). Allow coating to cure a minimum of 16 hours at 70 degrees F and 50% RH or until tack free between coats, and a minimum of 72 hours before opening to vehicular traffic.

#### Aggregate

Use clean, rounded, oven dried quartz sand with a minimum gradation of 16-30 or 12-20 mesh for vehicular traffic and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means and even, light broadcast short of to refusal. Any loose aggregate must be removed prior to recoating. Backroll aggregate only where indicated.



#### Accelerator

Sikalastic 700 ACL may be added to Sikalastic 710 Base or 715 Top in order to speed cure time particularly in cold weather conditions. The use of Sikalastic 700 ACL is required for all Sikalastic 715 and 735 AL applications exceeding 19 wet mils. Mix thoroughly prior to application. Add a maximum of 1 quart to 5 gallons (or 1:20 ratio) and only to material that will be applied the same day.

System Guide	Pedestrian Traffic	Heavy Pedestrian /Light Vehicular	Heavy Vehicular Traffic - Seed and Lock	Heavy Vehicular Traffic - Seed and Backroll			
Primer Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high moisture content substr							
710 Detail Coat	32 mils wet over properly treated cracks and joints.						
710 Base Coat		32 mils wet (23 m	nils dry) - 50 sf/gal.				
715 / 735 AL Top Coat I	14 mils wet (10 mils dry) - 115 sf/gal	11 mils wet (8 mils dry) - 145 sf/gal	11 mils wet (8 mils dry) - 145 sf/gal	22* mils wet (16 mils dry) - 73 sf/gal (See NOTE)			
Aggregate	5-10 lbs/100 sf -seeded/ backrolled	10-15 lbs/100 sf -seeded/ backrolled	10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/ backrolled			
715 / 735 AL Top Coat II		16 mils wet (12 mils dry) - 100 sf/gal	16 mils wet (12 mils dry) - 100 sf/gal	22* mils wet (16 mils dry) - 73 sf/gal (See NOTE)			
Aggregate			10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/ backrolled			
715/735 AL Top Coat III			16 mils wet (12 mils dry) - 100 sf/gal				
Total Thickness	33 mils dry (excluding aggregate)	43 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)			
See separate Sikalastic <sup>®</sup> Aliphatic Top Coats data sheet for DecoQuartz <sup>®</sup> and DecoFlake <sup>®</sup> systems.							
NOTE: *Requires use of 7	00 ACL Accelerator with 715	Top Coat, and 735 AL Top C	Coat				
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface rough- ness and porosity, aggregate selection and embedment, and application technique.							

#### Recoat Windows

In the event of an unforeseen rain event or delays beyond the stated recoat window referenced in each product's current PDS, observe the following.

Product	Recoat Window	Required Surface Preparation After Recoat Window is Exceeded
Sikalastic FTP	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic FTP Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic PF Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic MT	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic Recoat	Tack-free to 12 hours	Heavily abrade and reprime
Sikalastic Recoat with 700 ACL Accelerator	Tack-free to 6 hours	Heavily abrade and reprime
Sikalastic 710	Tack-free to 48 hours	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 710 with 700 ACL Accelerator	Tack-free to 24 hours	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 715	Tack-free to 48 hours	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 715 with 700 ACL Accelerator	Tack-free to 24 hours	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 735 AL	Tack-free to 48 hours	Abrade, clean and solvent wipe <u>or</u> Abrade, clean and Sikalastic Recoat Primer
Sikalastic 735 AL with 700 ACL Accelerator	Tack-free to 24 hours	Abrade, clean and solvent wipe <b>or</b> Abrade, clean and Sikalastic Recoat Primer

Notes:

- 1. Heavy abrasion of epoxy-based materials is intended to achieve an open, porous surface and to remove any amine blush that may interfere with bonding.
- 2. Abrasion of polyurethane-based materials is intended to achieve an open, porous surface.



	3. Cleaning is intended to remove dirt, debris, contaminants, and residue from mechanical surface
	<ul><li>preparation methods.</li><li>4. Recommended solvents include high quality xylene and acetone. Handling and use of all solvents must</li></ul>
	be done in accordance with the manufacturer's warnings and instructions for use.
<u>Removal</u>	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means
Maintenance/Repair	Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow remova equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades withou protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coatin back to well adhered material and reinstall patch according to procedures described above. Do not use aspha or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surfac restoration.
<u>-imitations</u>	<ul> <li>To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for Sikalastic FTP Primer; 4% for exterior exposed decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior exposed decks with two applications of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for interior protected decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic MT Primer; 6% for exterior and interior decks with one application of Sikalastic MT Primer; (see separate Primer; 6% for exterior addinterior decks with one application and curing of material is 40°F (4°C); maximum is 95°F (35C). Frequent monitoring of ambient and substrate temperatures sould always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Coating materials will become more viscous at lower application temperatures and be more difficult to</li> </ul>
	<ul> <li>spread, which may affect yield.</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not thin with solvents.</li> </ul>
	<ul> <li>Use properly graded, oven dried aggregates only.</li> <li>Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> </ul>
	Precautions should be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.
	<ul> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not pro-</li> </ul>
	ceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.
	<ul> <li>When applying over existing coatings compatibility and adhesion testing is recommended.</li> <li>Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.</li> </ul>
	<ul> <li>Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.</li> <li>On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.</li> <li>Unvented metal pan decks or decks containing a between-slab membrane require further technical evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.</li> <li>Do not subject to continuous immersion. Ponding water up to 72 hours duration is not considered to be continuous immersion.</li> </ul>
	<ul> <li>Sikalastic 710 Base coat is not UV stable and must be top coated.</li> <li>Sikalastic 715 Top coat is UV resistant, but will chalk, fade or discolor over time when exposed to UV and under certain artificial lighting conditions. Sikalastic 735 AL aliphatic top coat provides superior color and gloss retention.</li> </ul>
	<ul> <li>Base and intermediate coats must be kept clean and re-coated within 48 hours, or within 24 hours if Accelerator is used. If this recoat window is exceeded, contact Sika for recommendations.</li> <li>Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.</li> </ul>

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





### Sikalastic<sup>®</sup> 710 Lo-VOC/715 Lo-VOC/736 AL Lo-VOC Traffic System

Single component, low VOC, elastomeric, crack-bridging, waterproofing traffic system

isture cured, elastomeric polyun trian and vehicular traffic bearin mponent products. Optional ali omponents are: FTP Primer (see separate data FTP Lo-VOC primer (see separ MT primer (moisture-tolerant p 710 Base Lo-VOC one-compon posure) 736 AL Lo-VOC, optional one- 700 ACL optional accelerator 710 Lo-VOC/715 Lo-VOC/736 cementitious or plywood surfac story parking garages ng decks and ramps oridges and walkways anical rooms ums and arenas and rooftop decks nies uurnaround with optional Booste lent crack-bridging properties a anding resistance to abrasion a vious to water and deicing salt e of standard colors	arate data sheet) rate data sheet) primer - see separate data sheet) ponent aromatic polyurethane base coat with optional Booster ent aromatic polyurethane top coat with optional Booster (suitable ecomponent aliphatic polyurethane UV-resistant top coat B AL Lo-VOC Traffic System is suitable for use on structurally sound ces exposed to vehicular or pedestrian traffic.				
cementitious or plywood surface story parking garages ing decks and ramps pridges and walkways anical rooms ums and arenas and rooftop decks nies urnaround with optional Booster lent crack-bridging properties a anding resistance to abrasion a vious to water and deicing salt e of standard colors	ces exposed to vehicular or pedestrian traffic. er and flexibility, even at low temperatures and wear s				
lent crack-bridging properties a anding resistance to abrasion a vious to water and deicing salt e of standard colors rates provided are intended to	and flexibility, even at low temperatures and wear s				
•	a a biava required wat film thickness under antimal conditions. Addi				
ures, and other site-dependent	g on substrate surface roughness and porosity, material and substrate factors. This will result in a lower coverage rate.				
See Sikalastic Aliphatic Decorative Top Coats data sheet for decorative quartz/flake systems. Moisture Cure					
710 Base Lo-VOC and 715 To					
I Data (Material and curing co May differ based upon statistical var , test methods, actual site conditions	ONDITIONS @ 75°F (24°C) and 50% RH) IATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION S AND CURING CONDITIONS.				
ife:	1 year in original, unopened containers				
e Conditions:	Store dry at 40°-95°F (4°-35°C).				
t Conditioning:	Condition material to 65°-85°F (18°-30°C) before using.				
Sikalastic 710 Base Lo-VOC: tic 715 Top Lo-VOC: tic 736 AL Lo-VOC: istance and Recovery ongation (ASTM C-957)	Gray Gray, Charcoal and Tan Gray, Charcoal and Tan. Custom colors available PASS				
	, TEST METHODS, ACTUAL SITE CONDITION: fe: c Conditions: t Conditioning: Sikalastic 710 Base Lo-VOC: tic 715 Top Lo-VOC: tic 736 AL Lo-VOC: istance and Recovery				



	710 Base Lo-VOC w/o Booster	710 Base Lo-VOC w/ Booster	715 Top Lo-VOC w/o Booster	715 Top Lo-VOC w/ Booster	736 AL Lo-VOC
Viscosity	6500 ± 3000 cps	6500 ± 3000 cps	4000 ± 2000 cps	4000 ± 2000 cps	3500 ± 700 cps
Total Volume Solids (ASTM D-2697):	89%	89%	89%	88%	83%
VOC Content (ASTM D-2369-81):	93 g/L	100 g/L	96 g/L	100 g/L	99 g/L
Fensile Strength (ASTM D-412):	1200 ± 300 psi	1350 ± 300 psi	3400 ± 300 psi	3400 ± 300 psi	4000 ± 300 psi
Elongation at Break (ASTM D-412):	450 ± 50%	500 ± 50%	450 ± 50%	450 ± 50%	250 ± 50%
Tear Resistance (Die C, ASTM D-624):	195 ± 25 pli	195 ± 25 pli	350 ± 50 pli	350 ± 50 pli	400 ± 50 pli
Hardness (ASTM D-2240):	75 ± 5 Shore A	60 ± 5 Shore A	85 ± 5 Shore A	80 ± 5 Shore A	90 ± 5 Shore A
		1		1	

#### How to Use

Surface Preparation Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to application.

> Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).

Route out all cracks and joints as part of surface preparation

Plywood - Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported according to APA guidelines. Seams should be sealed with Sikaflex 2c or 1a and detailed and may need embedded fabric reinforcement.

Metal - Should be thoroughly cleaned by grinding or blast cleaning to near white metal (SSPC SPS-10).

#### Application

Priming

Primer Selection - Determine maximum moisture content of concrete substrate by weight with a Tramex CME or CMExpert type concrete moisture meter.

Sikalastic FTP Primer - For concrete decks with a maximum moisture content of 4% by weight, and for plywood decks, apply Sikalastic FTP Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf/ gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Sikalastic FTP Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information

Sikalastic FTP Lo-VOC Primer - For exterior exposed concrete decks with a maximum moisture content of 4% by weight, interior protected concrete decks with a maximum moisture content of 5% by weight, and plywood decks, apply Sikalastic FTP Lo-VOC Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf/gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. For exterior exposed concrete decks with a maximum moisture content of 5% by weight, two applications of Sikalastic FTP Lo-VOC Primer are required. Sikalastic FTP Lo-VOC Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.

Sikalastic PF Lo-VOC Primer - For concrete and plywood decks with a porous or rough surface, and for metal flanges and penetrations, use Sikalastic PF Lo-VOC Primer. For exterior exposed concrete decks with a maximum moisture content of 4% by weight, interior protected concrete decks with a maximum moisture content of 5% by weight, and plywood decks, apply Sikalastic PF Lo-VOC Primer with a flat squeegee or phenolic resin core roller at approximately 200 sf/gal, and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. For exterior exposed concrete decks with a maximum moisture content of 5% by weight, two applications of Sikalastic PF Lo-VOC Primer are required. Refer to separate primer data sheet for additional information.

Sikalastic MT Primer - For concrete with a maximum moisture content of 5% by weight, and for metal flanges and penetrations, apply Sikalastic MT Primer with a flat squeegee or roller at approximately 175 sf/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic MT Primer with a flat squeegee or phenolic resin roller at approximately 175 sf/gal per application. Work primer well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Refer to separate primer data sheet for additional information.

Sikalastic Recoat Primer - For existing polyurethane coatings, incidental exposed concrete deck areas, and as an interlaminate primer, apply Sikalastic Recoat Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf/gal. and work will into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Sikalastic Recoat Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.



#### Primer Mixing

**Sikalastic FTP Primer** – Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Sikalastic FTP Part B is dark olive green in color and may appear black in the container. Sikalastic FTP Part A is light amber in color. Add the 1 gallon of Sikalastic FTP Part A to the 1.25 gallons of Part B in the short filled Part B pail. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). This mixture will appear as a light olive green color. Slowly add 1.25 gallons of potable water to the mixture under agitation. Mix for an additional 2 minutes until the mixture is fully dispersed. Fully dispersed material will appear as light yellow to white in color.

**Sikalastic FTP Lo-VOC Primer -** Premix Part A (blue liquid) and Part B (yellow liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For the 3 gallon kit, pour Part B into Part A slowly and while mixing scrape the side of the container, For the 15 gallon kit, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 2 parts A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic PF Lo-VOC Primer -** Premix Part A (black liquid) and Part B (white liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 gallon kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic MT Primer** - Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

Sikalastic Recoat Primer – Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part A into a separate container. Pour Part B into Part A slowly and while mixing scrape the side of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). In the event that a faster cure is required, Sikalastic Recoat Primer can be applied with Sikalastic 700 ACL as an accelerator. Add two quarts Sikalastic 700 ACL into 10 gallons of mixed primer. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

#### **Detailing**

**Non-structural cracks up to 1/16 inch -** Apply a detail coat of Sikalastic<sup>®</sup> 710 Lo-VOC Base (with Booster if required) at 26 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.

**Cracks and joints over 1/16 up to 1 inch -** Rout and seal with Sikaflex<sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic<sup>®</sup> 710 Lo-VOC Base at 26 mils, 4" wide, centered over the crack. Allow to become tack free before over coating.

Joints over 1 inch - Should be treated as expansion joints and brought up through the Sikalastic<sup>®</sup> 710 Lo-VOC Base waterproofing membrane and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant.

**Fabric Reinforcement** – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.

**Panelized Joints** - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.

NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.

#### Base Coat

Thoroughly mix Sikalastic 710 Base Lo-VOC using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 710 Base Lo-VOC Booster (if required) into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 1/4" notched squeegee or trowel and backroll using a phenolic resin core



roller. Extend base coat over entire area including previously detailed cracks and control joints. Allow coating to cure a minimum of 16 hours (6 hours with Booster) at 70°F and 50% RH or until tack free before top coating.

#### Top Coats

Thoroughly mix Sikalastic 715 Top Lo-VOC using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 715 Top Lo-VOC Booster (if required) into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Add a maximum of 1 quart to 4.75 gallons (or 1:19 ratio) and only to material that will be applied in the next hour. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, or phenolic resin core roller, and backroll. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating and backroll if required (see System Guide). Allow coating to cure a minimum of 16 hours (6 hours with Booster) 70 degrees F and 50% RH or until tack free between coats, and a minimum of 72 hours (36 hours with Booster) before opening to vehicular traffic.

Thoroughly mix Sikalastic 736 AL Lo-VOC using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 700 ACL accelerator in order to speed cure time particularly in cold weather conditions (if required) into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Add a maximum of 1 quart to 5 gallons (or 1:20 ratio) and only to material that will be applied the same day. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, or phenolic resin core roller, and backroll. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating and backroll if required (see System Guide). Allow coating to cure a minimum of 16 hours (6 hours with Accelerator at) 70 degrees F and 50% RH or until tack free between coats, and a minimum of 72 hours (36 hours with Accelerator) before opening to vehicular traffic.

#### Aggregate

Use clean, rounded, oven dried quartz sand with a minimum gradation of 16-30 or 12-20 mesh for vehicular traffic and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means and even, light broadcast short of to refusal. Any loose aggregate must be removed prior to recoating. Backroll aggregate only where indicated.

#### **Boosters**

Sikalastic 710 Lo-VOC Booster may be added to Sikalastic 710 Lo-VOC Base in order to speed cure time. Sikalastic 715 Lo-VOC Booster may be added to Sikalastic 715 Lo-VOC Top in order to speed cure time. **The use of Sikalastic 715 Lo-VOC Booster is required for all Sikalastic 715 Lo-VOC applications exceeding 19 wet mils.** Boosters are product specific – use Sikalastic 710 Lo-VOC Booster with Sikalastic 710 Lo-VOC Base, and use Sikalastic 715 Lo-VOC Booster with Sikalastic 715 Lo-VOC Top. Mix thoroughly prior to application. Add a maximum of 1 quart to 4.75 gallons (or 1:19 ratio) and only to material that will be applied within 45 minutes typical.

#### **Accelerator**

Sikalastic 700 ACL may be added to Sikalastic 736 AL Lo-VOC in order to speed cure time particularly in cold weather conditions. The use of Sikalastic 710 ACL is required for all Sikalastic 736 AL Lo-VOC applications exceeding 19 wet mils. Mix thoroughly prior to application. Add a maximum of 1 quart to 5 gallons (or 1:20 ratio) and only to material that will be applied the same day.



System Guide	Pedestrian Traffic	Heavy Pedestrian / Light Vehicular - Seed and Lock	Heavy Pedestrian / Light Vehicular Seed and Backroll**	Heavy Vehicular Traffic - Seed and Lock	Heavy Vehicular Traffic - Seed and Backroll			
Primer	rimer Sikafloor FTP - 300 sf/gal. Consult Sika for other primer options for recover and high moisture content sub-							
710 Base Lo-VOC Detail Coat		26 mils wet over properly treated cracks and joints.						
710 Base Lo-VOC Base Coat		26 m	nils wet (23 mils dry) - 61	sf/gal.				
715 Top Lo-VOC /736 AL Lo-VOC Top Coat I*	11/12 mils wet (10 mils dry) - 145/133 sf/gal	9/10 mils wet (8 mils dry) - 178/160 sf/gal	23**/24** mils wet (20 mils dry) - 69/67 sf/gal (see NOTE)	9/10 mils wet (8 mils dry) - 178/160 sf/gal	18/19 mils wet (16 mils dry) - 89/84 sf/gal			
Aggregate	5-10 lbs/100 sf -seeded/backrolled	10-15 lbs/100 sf -seeded	15-20 lbs/100 sf - seeded/backrolled	10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/backrolled			
715 Top Lo-VOC /736 AL Lo-VOC Top Coat II*		13/14 mils wet (12 mils dry) - 123/114 sf/gal		13/14 mils wet (12 mils dry) - 123/114 sf/gal	18/19 mils wet (16 mils dry) - 89/84 sf/gal			
Aggregate				10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/backrolled			
715 Top Lo-VOC /736 AL Lo-VOC Top Coat III*				13/14 mils wet (12 mils dry) - 123/114 sf/gal				
Total Thickness	33 mils dry (excluding aggregate)	43 mils dry (excluding aggregate)	43 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)			
NOTE: *Wet mil and co	overage information provid	led separately for both 7	15 Top Lo-VOC/736 AL Lo	o-VOC Top Coats	<u>~</u>			
NOTE: **Requires use	of 715 Top Lo-VOC Boos	ter with 715 Top Lo-VOC	Top Coat, and 700 ACL	Accelerator with 736 AL L	o-VOC Top Coat			
	provided are optimal and ection and embedment, a			ending on temperature, s	surface roughness and			

**Recoat Windows** 

In the event of an unforeseen rain event or delays beyond the stated recoat window referenced in each product's current PDS, observe the following.

Product	Recoat Window	Required Surface Preparation After Recoat Window is Exceeded
Sikalastic FTP	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic FTP Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic PF Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic MT	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic Recoat	Tack-free to 12 hours	Heavily abrade and reprime
Sikalastic Recoat with 700 ACL Accelerator	Tack-free to 6 hours	Heavily abrade and reprime
Sikalastic 710 Lo-VOC	Tack-free to 48 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer
Sikalastic 710 Lo-VOC with 710 Lo-VOC Booster	6-24 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer
Sikalastic 715 Lo-VOC	Tack-free to 48 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer
Sikalastic 715 Lo-VOC with 715 Lo-VOC Booster	6-24 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer
Sikalastic 736 AL Lo-VOC	48 hours	Abrade, clean and solvent wipe or Abrade, clean and Sikalastic Recoat Primer
Sikalastic 736 AL Lo-VOC with 700 ACL Accelerator	24 hours	Abrade, clean and solvent wipe or Abrade, clean and Sikalastic Recoat Primer

Notes:

1. Heavy abrasion of epoxy-based materials is intended to achieve an open, porous surface and to re move any amine blush that may interfere with bonding.

- 2. Abrasion of polyurethane-based materials is intended to achieve an open, porous surface.
- Cleaning is intended to remove dirt, debris, contaminants, and residue from mechanical surface preparation methods.
- 4. Recommended solvents include high quality xylene and acetone. Handling and use of all solvents must be done in accordance with the manufacturer's warnings and instructions for use.



laintenance/Repair	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.
	Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow removal equip- ment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to wel adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.
<u>imitations</u>	<ul> <li>To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for Sikalastic FTP Primer; 4% for exterior exposed decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior exposed decks with two applications of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior exterior and interior decks with one application of Sikalastic FTP Lo-VOC Primer; 5% for exterior and interior decks with one application of Sikalastic MT Primer; 6% for exterior and interior decks with one application of Sikalastic MT Primer; 6% for exterior and interior decks with one application and curing of material is 40°F (4°C); maximum is 95°F (35°C). Frequent monitoring of ambient and substrate temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Coating materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield.</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and</li> </ul>
	<ul> <li>moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not thin with solvents.</li> <li>Use properly graded, oven dried aggregates only.</li> <li>Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> </ul>
	Precautions should be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.
	Do not apply to a porous or damp surface where moisture vapor transmission will occur during applica- tion and cure.
	<ul> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> <li>When applying over existing coatings compatibility and adhesion testing is recommended.</li> <li>Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent pre-</li> </ul>
	<ul> <li>mature failure.</li> <li>Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.</li> <li>On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.</li> <li>Unvented metal pan decks or decks containing a between-slab membrane require further technical evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.</li> <li>Do not subject to continuous immersion.</li> <li>Base coat is not UV stable and must be top coated.</li> </ul>
	<ul> <li>Base coal is not ov stable and must be top coaled.</li> <li>Sikalastic 715 Top Lo-VOC is UV resistant, but will chalk, fade or discolor over time when exposed to UV and under certain artificial lighting conditions. Sikalastic 736ALLo-VOC aliphatic top coat provides superior color and gloss retention.</li> </ul>
	<ul> <li>Base and intermediate coats must be kept clean and re-coated within 48 hours, or 24 hours if Accelerator or Boosters are used.</li> <li>Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.</li> </ul>

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on SIAA warrants this product for one year from date of instantion to be free from manufacturing defects and to meet the technical properties of the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Corregidora, Queretaro C.P. 76920

Phone: 52 442 2385800 Fax: 52 442 2250537

Visit our website at usa.sika.com

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Ś



### Sikalastic<sup>®</sup> 710 NP Base

Single component, elastomeric, crack-bridging, primerless, waterproofing base coat

Description	Sikalastic® 710 NP is a single component, aromatic, moisture cured, elastomeric polyurethane coating in tended for use as the waterproofing base coat under polyurethane or epoxy wearing surfaces for pedestrial and vehicular traffic bearing applications, and as the waterproofing base coat under a separate wearing course such as concrete, and tile in a setting bed. Sikalastic 710 NP is a direct replacement for Sikalastic 710 in a applications.			
Where to Use	<ul> <li>Multi-story parking garages</li> <li>Parking decks and ramps</li> <li>Foot bridges and walkways</li> <li>Mechanical rooms</li> <li>Stadiums and arenas</li> <li>Plaza and rooftop decks</li> <li>Balconies</li> </ul>			
Advantages	<ul> <li>Excellent crack-bridging properties and</li> <li>Primer not required for typical applicati</li> <li>Resistant to water and deicing salts</li> <li>Alkaline resistant</li> </ul>			
Coverage	50 ft <sup>2</sup> /gal. @ 32 wet mils (23 dry mils). NOTE: Coverage rates provided are optimal and are not guaranteed. Coverage rates will vary depending or temperature, surface roughness and porosity, aggregate selection and embedment, and application technique			
	<b>o</b> 1 1	<b>o o i i o</b>		
Cure Mechanism	<b>o</b> 1 1	<b>o o i i o</b>		
Cure Mechanism	temperature, surface roughness and porosi			
Cure Mechanism	temperature, surface roughness and porosi Moisture Cure	<b>o o i i o</b>		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data ( <i>Material and curing con</i>	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data ( <i>Material and curing con</i> RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. <b>Typical Data (Material and curing con</b> RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS.		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life:	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS. 1 year in original, unopened containers		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions:	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C).		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning:	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION to CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°- 85°F (18°- 30°C) before using.		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning: Colors:	ditions @ 75°F (24°C) and 50% RH) loss bepending upon MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°- 85°F (18°- 30°C) before using. Medium Gray		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning: Colors: Viscosity	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) NONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION to CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°- 85°F (18°- 30°C) before using. Medium Gray 6500 ± 3000 cps		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning: Colors: Viscosity Total Volume Solids (ASTM D-2697):	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) IONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°- 85°F (18°- 30°C) before using. Medium Gray 6500 ± 3000 cps 71%		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. <b>Typical Data (Material and curing con</b> RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning: Colors: Viscosity Total Volume Solids (ASTM D-2697): VOC Content (ASTM D-2369-81):	ditions @ 75°F (24°C) and 50% RH)         Ions DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION ND CURING CONDITIONS.         1 year in original, unopened containers         Store dry at 40°- 95°F (4°- 35°C).         Condition material to 65°- 85°F (18°- 30°C) before using.         Medium Gray         6500 ± 3000 cps         71%         240 g/L		
Cure Mechanism Chemical Resistance	temperature, surface roughness and porosi Moisture Cure Resistant to de-icing salts. 5 gal. pails, 50 gal. (net) drums. Typical Data (Material and curing com RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATI METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AN Shelf Life: Storage Conditions: Product Conditioning: Colors: Viscosity Total Volume Solids (ASTM D-2697): VOC Content (ASTM D-2369-81): Tensile Strength (ASTM D-412):	ty, aggregate selection and embedment, and application technique ditions @ 75°F (24°C) and 50% RH) loss DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION UD CURING CONDITIONS. 1 year in original, unopened containers Store dry at 40°- 95°F (4°- 35°C). Condition material to 65°- 85°F (18°- 30°C) before using. Medium Gray 6500 ± 3000 cps 71% 240 g/L 650 ± 100 psi 375 ± 50%		



How to Use Surface Preparation	Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compound bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc., should be dressed off to achieve a level surface prior to the application.
	<b>Concrete</b> - Should be cleaned and prepared to achieve a laitance and contaminant free, open texture surface by shot blasting. The use of a primerless-type base coat requires that the concrete surface be sufficiently rough and open pored so that the base coat is able to penetrate the substrate surface and achie an adequate bond. The desired surface texture (CSP 4-5 per ICRI Guidelines) is somewhat rougher than it primer is being used. In addition, the substrate surface must be thoroughly cleaned by blowing/vacuuming remove all particulates that may interfere with base coat bonding. The base coat will not mix and consolidat dust and particulates as will some primers, so thorough cleaning is mandatory.
	<b>Plywood</b> – Should be clean and smooth, APA and exterior grade, not less than ½" thick, and spaced as supported according to APA guidelines. Joints should be sealed with Sikaflex 2c or 1a and detailed, and m need embedded fabric reinforcement.
	Metal - Should be thoroughly cleaned by blast cleaning.
Detailing	<b>Non-structural cracks up to 1/16 inch</b> – Apply a detail coat of Sikalastic 710 NP Base at 32 mils wet, 4" with centered over the crack. Allow to become tack free before overcoating.
	Cracks and joints over 1/16 up to 1 inch – Seal cracks and joints with Sika Sealant and allow to skin ov and cure for 24 hours min. Apply a detail coat of Sikalastic 710 NP Base at 32 mils wet, 4" wide, centered ov the crack. Allow to become tack free before overcoating.
	Joints over 1 inch – Should be treated as expansion joints and brought up through the Sikalastic Traffic Syste and sealed with Sika sealant.
	<b>Fabric Reinforcement</b> – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on eith side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.
	Panelized Joints – Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.
	NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which cas the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and seale with Sika sealant.
Mixing	Thoroughly mix coating using a mechanical mixer (Jiffy) at slow speed until a homogenous mixture and unifor color is obtained (typically 1 minute). Use care not to allow the entrapment of air into the mixture.
Application	Apply at the recommended coverage rate (see Sikalastic 710/715/735 AL System Guide) using a notche squeegee or trowel, and backroll using a phenolic resin core roller. Extend base coat over entire area incluing previously detailed cracks and joints. Allow coating to cure a minimum of 16 hours at 70°F and 50% F or until tack fee before top coating. Allow coating to cure for a minimum of 72 hours before installing separa concrete pavement or tile wear course.
Removal	Remove liquid coating immediately with dry cloth. Once cured, coating can only be removed by mechanic means.
Limitations	<ul> <li>To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.</li> <li>Maximum moisture content for primerless applications of concrete substrate by weight when measured with a Tramex CME or CMExpert type when concrete moisture meter is &lt; 4%. Please see priming section for applications where substrate moisture is between 4% and 6% maximum.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 0.6°C (25°C)</li> </ul>
	<ul> <li>maximum is 95°F (35°C).</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not thin with solvents.</li> </ul>
	<ul> <li>Do not thin with solvents.</li> <li>Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> </ul>
	<ul> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> </ul>
	<ul> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> <li>When applying over existing coatings compatibility and adhesion testing is recommended.</li> </ul>
	Precautions should be taken to prevent odors and/or vapors from entering the building/structure, includ ing but not limited to turning off and sealing air intake vents or other means of ingress for odors and for vapors into the building/structure during product application and cure.
R IDDI	On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications
KA INST SHE PAR TO F	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS A TRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DA EET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE I RTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATI READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CL IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

- evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.
- Waterproofing applications under overburden, including concrete pavement, and tile in a cementitious setting bed, require further technical evaluation - contact Sika regarding recommendations.
- Do not subject to continuous immersion.
- Sikalastic 710 NP is not UV stable and must be top coated or protected by a separate wearing course.
  - Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

Primina

Primer Selection - Determine maximum moisture content of concrete substrate by weight with a Tramex CME or CMExpert type concrete moisture meter.

Maximum moisture content for primerless applications of concrete substrate by weight when measure with a Tramex CME or CMExpert type when concrete moisture meter is:

<u>≤</u> 4%		4% <u>≤</u> 5%		5% <u>≤</u> 6%	
Interior	Exterior	Interior	Exterior	Interior	Exterior
Primerless	Primerless	1 coat Sika- lastic FTP Lo- VOC Primer or 1 coat Sikalas- tic PF Lo-VOC Primer	2 coats Sikalastic FTP Lo-VOC Primer or 2 coats Sikalastic PF Lo-VOC Primer	2 coats Sikalastic MT Primer	2 coats Sikalastic MT Primer
NOTE: See separate Primer product data sheets					

NOTE: See separate Primer product data sheets

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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL MARC CALLING 201-933-8800.

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Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# Sikalastic<sup>®</sup> 715 Lo-VOC/715 Lo-VOC **Traffic System**

Single component, single product, low VOC, elastomeric, crackbridging, waterproofing traffic system

Description	The Sikalastic 715 Lo-VOC/715 Lo-VOC T VOC, moisture cured, elastomeric polyur brane for pedestrian and vehicular traffic b two-component products. System components are: Sikalastic FTP Primer (see separate data = Sikalastic FTP Lo-VOC primer (see separate Sikalastic PF Lo-VOC primer (see separate Sikalastic PF Lo-VOC primer (see separate) Sikalastic MT primer (moisture-tolerant pri Sikalastic 715 Top Lo-VOC one-componer for UV exposure)	ethane coating system design earing surfaces. Booster prov sheet) ate data sheet) e data sheet) mer - see separate data shee	t)		
Where to Use	Sikalastic 715 Lo-VOC/715 Lo-VOC Traffic System is suitable for use on structurally sound concrete, ce- mentitious or plywood surfaces exposed to vehicular or pedestrian traffic.  Multi-story parking garages Parking decks and ramps Foot bridges and walkways Mechanical rooms Stadiums and arenas Plaza and rooftop decks Balconies				
Advantages	<ul> <li>Fast turnaround with Booster</li> <li>Excellent crack-bridging properties and flexibility, even at low temperatures</li> <li>Outstanding resistance to abrasion and wear</li> <li>Impervious to water and deicing salts</li> <li>Range of standard colors</li> </ul>				
Coverage	Coverage rates provided are intended to achieve required wet film thickness under optimal conditions. Add tional material may be required depending on substrate surface roughness and porosity, material and substrate temperatures, and other site-dependent factors. This will result in a lower coverage rate.				
Cure Mechaniam	See Sikalastic Aliphatic Decorative Top Coats data sheet for decorative quartz/flake systems.				
Cure Mechanism	Moisture Cure				
Packaging	715 Top Lo-VOC: 4.75 gal. (net) pails, 50 g 715 Top Lo-VOC Booster: 1 quart cans (4				
	Typical Data (Material and curing con RESULTS MAY DIFFER BASED UPON STATISTICAL VARIAT METHODS, TEST METHODS, ACTUAL SITE CONDITIONS A	TIONS DEPENDING UPON MIXING METHODS			
	Shelf Life:	1 year in original, unopened	containers		
	Storage Conditions:	Store dry at 40°-95°F (4°-35°C).			
	Product Conditioning:	Condition material to 65°-85°F (18°-30°C) before using.			
	Colors:				
	Sikalastic 715 Top Lo-VOC: Gray, Ch		Charcoal and Tan		
	Viscosity	<b>715 Lo-VOC w/o Booster</b> 4000 ± 2000 cps	<b>715 Lo-VOC w/ Booster</b> 4000 ± 2000 cps		
	Total Volume Solids (ASTM D-2697):	89%	86%		
	VOC Content (ASTM D-2369-81):	96 g/L	100 g/L		

<u> </u>				
	Tensile Strength (ASTM D-412):	3400 ± 300 psi	3400 ± 300 psi	
	Elongation at Break (ASTM D-412):	450 ± 50%	$450 \pm 50\%$	
	Tear Resistance (Die C, ASTM D-624):	350 ± 50 pli	350 ± 50 pli	
	Hardness (ASTM D-2240):	85 ± 5 Shore A	80 ± 5 Shore A	
How to Use Surface Preparation	Surface must be clean, dry and sound with a bond inhibiting impregnations, waxes, and a dressed off to achieve a level surface prior	any other contaminants. All pro		
	<b>Concrete -</b> Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).			
	Route out all cracks and joints as part of surface preparation.			
	<b>Plywood -</b> Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported according to APA guidelines. Seams should be sealed with Sikaflex 2c or 1a and detailed and ma need embedded fabric reinforcement.			
	Metal - Should be thoroughly cleaned by g	rinding or blast cleaning to nea	ar white metal (SSPC SPS-10).	
Application	Priming			
	Primer Selection - Determine maximum m or CMExpert type concrete moisture meter.		estrate by weight with a Tramex CM	
	Sikalastic FTP Primer – For concrete decks decks, apply Sikalastic FTP Primer with a gal. and work well into the substrate to en Sikalastic FTP Primer is not suitable for m information.	flat squeegee or phenolic resir sure adequate penetration and	n core roller at approximately 300 s d sealing, and puddles are avoided	
	Sikalastic FTP Lo-VOC Primer - For exterior exposed concrete decks with a maximum moisture content of 4% by weight, interior protected concrete decks with a maximum moisture content of 5% by weight, and plywood decks, apply Sikalastic FTP Lo-VOC Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf/gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. For exterior exposed concrete decks with a maximum moisture content of 5% by weight two applications of Sikalastic FTP Lo-VOC Primer are required. Sikalastic FTP Lo-VOC Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.			
	Sikalastic PF Lo-VOC Primer - For concre- flanges and penetrations, use Sikalastic PF mum moisture content of 4% by weight, inte 5% by weight, and plywood decks, apply S core roller at approximately 200 sf/gal. and sealing, and puddles are avoided. For exte 5% by weight, two applications of Sikalast sheet for additional information.	E Lo-VOC Primer. For exterior e erior protected concrete decks ikalastic PF Lo-VOC Primer w d work well into the substrate t erior exposed concrete decks w	exposed concrete decks with a max with a maximum moisture content of ith a flat squeegee or phenolic resi to ensure adequate penetration an with a maximum moisture content of	
	Sikalastic MT Primer - For concrete with a and penetrations, apply Sikalastic MT Prin concrete decks with a maximum moisture Primer with a flat squeegee or phenolic re- well into the substrate to ensure adequate p primer data sheet for additional information	ner with a flat squeegee or rol content of 6% by weight, app sin roller at approximately 175 enetration and sealing, and put	ler at approximately 175 sf/gal. Fo ly two applications of Sikalastic M sf/gal per application. Work prime	
	Sikalastic Recoat Primer – For existing po as an interlaminate primer, apply Sikalastic at approximately 300 sf/gal. and work will in puddles are avoided. Sikalastic Recoat Pri data sheet for additional information.	c Recoat Primer with a flat squ nto the substrate to ensure add	ueegee or phenolic resin core rolle equate penetration and sealing, an	
	Primer Mixing			
	Sikalastic FTP Primer – Premix Part A and mechanical mixer and Jiffy Paddle at slow s scrape the solids from the bottom and side may appear black in the container. Sikalast FTP Part A to the 1.25 gallons of Part B in until a homogenous mixture and uniform of a light olive green color. Slowly add 1.25 g additional 2 minutes until the mixture is fully white in color.	peed to obtain uniform color (ty s of the pail. Sikalastic FTP Pa tic FTP Part A is light amber in the short filled Part B pail. Mi olor is obtained (typically 3 mi pallons of potable water to the	pically 30 seconds), making sure t art B is dark olive green in color an color. Add the 1 gallon of Sikalasti x the combined material thoroughl nutes). This mixture will appear as mixture under agitation. Mix for a	
INST SHEE PART TO R	OR TO EACH USE OF ANY SIKA PRODUCT, TH RUCTIONS ON THE PRODUCT'S MOST CURR ET WHICH ARE AVAILABLE ONLINE AT HTTP: TMENT AT 800.933.7452 NOTHING CONTAINED EAD AND FOLLOW THE WARNINGS AND INST T PRODUCT DATA SHEET, PRODUCT LABEL A	ENT PRODUCT DATA SHEET, P //USA.SIKA.COM/ OR BY CALLII IN ANY SIKA MATERIALS RELIE FRUCTIONS FOR EACH SIKA PR	RODUCT LABEL AND SAFETY DAT/ NG SIKA'S TECHNICAL SERVICE DE VES THE USER OF THE OBLIGATION ODUCT AS SET FORTH IN THE CUR	

**Sikalastic FTP Lo-VOC Primer -** Premix Part A (blue liquid) and Part B (yellow liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For the 3 gallon kit, pour Part B into Part A slowly and while mixing scrape the side of the container, For the 15 gallon kit, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 2 parts A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic PF Lo-VOC Primer -** Premix Part A (black liquid) and Part B (white liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 gallon kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic MT Primer** - Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic Recoat Primer** – Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part A into a separate container. Pour Part B into Part A slowly and while mixing scrape the side of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). In the event that a faster cure is required, Sikalastic Recoat Primer can be applied with Sikalastic 700 ACL as an accelerator. Add two quarts Sikalastic 700 ACL into 10 gallons of mixed primer. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

#### **Detailing**

**Non-structural cracks up to 1/16 inch -** Apply a detail coat of Sikalastic 715 Lo-VOC Top with Sikalastic 715 Lo-VOC Booster at 26 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.

**Cracks and joints over 1/16 up to 1 inch** – Rout and seal with Sikaflex<sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic 715 Lo-VOC Top with Sikalastic 715 Lo-VOC Booster at 26 wet mils, 4" wide, centered over the crack. Allow to become tack free before over coating.

**Joints over 1 inch -** Should be treated as expansion joints and brought up through the Sikalastic 715 Lo-VOC Top with Sikalastic 715 Lo-VOC Booster waterproofing membrane and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant.

**Fabric Reinforcement** – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.

**Panelized Joints** - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.

NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.

#### Base Coat

Thoroughly mix Sikalastic 715 Top Lo-VOC using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 715 Top Lo-VOC Booster into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 1/4" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and control joints. Allow coating to cure a minimum of 6 hours at 70°F and 50% RH or until tack free before top coating.

#### Top Coats

Thoroughly mix Sikalastic 715 Top Lo-VOC using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 715 Top Lo-VOC Booster (if required) into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Add a maximum of 1 quart to 4.75 gallons (or 1:19 ratio) and only to material that will be applied in the next hour. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, or phenolic resin core roller, and



backroll. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating and backroll if required (see System Guide). Allow coating to cure a minimum of 16 hours (6 hours with Booster) 70 degrees F and 50% RH or until tack free between coats, and a minimum of 72 hours (36 hours with Booster) before opening to vehicular traffic.

#### Aggregate

Use clean, rounded, oven dried quartz sand with a minimum gradation of 16-30 or 12-20 mesh for vehicular traffic and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means and even, light broadcast short of to refusal. Any loose aggregate must be removed prior to recoating. Backroll aggregate only where indicated.

#### **Boosters**

Sikalastic 715 Top Lo-VOC Booster may be added to Sikalastic 715 Lo-VOC Top in order to speed cure time. The use of Sikalastic 715 Top Lo-VOC Booster is required for all Sikalastic 715 Top Lo-VOC applications exceeding 19 wet mils including use as Base Coat. Mix thoroughly prior to application. Add a maximum of 1 quart to 4.75 gallons (or 1:19 ratio) and only to material that will be applied within 45 minutes typical.

System Guide	Pedestrian Traffic	Heavy Pedestrian / Light Vehicular - Seed and Lock	Heavy Pedestrian / Light Vehicular Seed and Backroll**	Heavy Vehicular Traffic - Seed and Lock	Heavy Vehicular Traffic - Seed and Backroll
Primer	Sikafloor FTP - 30	) sf/gal. Consult Sika for	other primer options for r	ecover and high moisture	content substrates.
715 Lo-VOC Top Detail Coat		26* mils wet over properly treated cracks and joints.			
715 Lo-VOC Top Base Coat		26* mils wet (23 mils dry) - 61 sf/gal.			
715 Top Lo-VOC	11 mils wet (10 mils dry) - 145 sf/gal	9 mils wet (8 mils dry) - 178 sf/gal	23* mils wet (20 mils dry) - 69 sf/gal (see NOTE)	9 mils wet (8 mils dry) - 178 sf/gal	18 mils wet (16 mils dry) - 89 sf/gal
Aggregate	5-10 lbs/100 sf -seeded/backrolled	10-15 lbs/100 sf -seeded	15-20 lbs/100 sf - seeded/backrolled	10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/backrolled
715 Top Lo-VOC		13 mils wet (12 mils dry) - 123 sf/gal		13 mils wet (12 mils dry) - 123 sf/gal	18 mils wet (16 mils dry) - 89 sf/gal
Aggregate				10-15 lbs/100 sf -seeded	15-20 lbs/100 sf -seeded/backrolled
715 Top Lo-VOC				13 mils wet (12 mils dry) - 123 sf/gal	
Total Thickness	33 mils dry (excluding aggregate)	43 mils dry (excluding aggregate)	43 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)
NOTE: **Requires u	se of 715 Top Lo-VOC Boos	ter with 715 Top Lo-VOC	Top Coat, and 700 ACL	Accelerator with 736 AL L	o-VOC Top Coat

**NOTE:** Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.



#### Recoat Windows

In the event of an unforeseen rain event or delays beyond the stated recoat window referenced in each product's current PDS, observe the following.

Product	Recoat Window	Required Surface Preparation After Recoat Window is Exceeded
Sikalastic FTP	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic FTP Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic PF Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic MT	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic Recoat	Tack-free to 12 hours	Heavily abrade and reprime
Sikalastic Recoat with 700 ACL Accelerator	Tack-free to 6 hours	Heavily abrade and reprime
Sikalastic 715 Top Lo-VOC	Tack-free to 48 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer
Sikalastic 715 Top Lo-VOC with 715 Top Lo-VOC Booster	6-24 hours	Clean and solvent wipe or Clean and Sikalastic Recoat Primer

Notes:

- 1. Heavy abrasion of epoxy-based materials is intended to achieve an open, porous surface and to re move any amine blush that may interfere with bonding.
- 2. Abrasion of polyurethane-based materials is intended to achieve an open, porous surface.
- 3. Cleaning is intended to remove dirt, debris, contaminants, and residue from mechanical surface preparation methods.
- 4. Recommended solvents include high quality xylene and acetone. Handling and use of all solvents must be done in accordance with the manufacturer's warnings and instructions for use.

<u>Removal</u>	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means
Maintenance/Repair	Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow removal equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to well adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.
Limitations	To avoid dew point conditions during application relative humidity must be no more than 95% and sub-

- To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.
  - Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for Sikalastic FTP Primer; 4% for exterior exposed decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior exposed decks with two applications of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for interior protected decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior and interior decks with one application of Sikalastic MT Primer; 6% for exterior and interior decks with two applications of Sikalastic MT Primer. (see separate Primer product data sheets).
  - Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 95°F (35°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
  - Coating materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield.
  - Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.
  - Do not thin with solvents.
  - Use properly graded, oven dried aggregates only.
  - Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
  - Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system
  - Precautions should be taken to prevent vapors and/or odors from entering the building/structure. including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.
  - Do not apply to a porous or damp surface where moisture vapor transmission will occur during applica-tion and cure.
  - Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not pro-ceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after

rain or inclement weather as there is the potential for bonding problems.

- When applying over existing coatings compatibility and adhesion testing is recommended.
- Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.
  - Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.
  - On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
  - Unvented metal pan decks or decks containing a between-slab membrane require further technical evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.
  - Do not subject to continuous immersion.
  - Sikalastic 715 Top Lo-VOC is UV resistant, but will chalk, fade or discolor over time when exposed to UV and under certain artificial lighting conditions. Sikalastic 736AL Lo-VOC aliphatic top coat provides superior color and gloss retention.
  - Base and intermediate coats must be kept clean and re-coated within 48 hours, or 24 hours if Boosters are used.
  - Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

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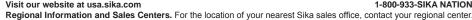
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL MARCE. CALLING 201-933-8800.

C.P. 76920

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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**F50** 

Product Data Sheet Edition 7.18.2016 Sikalastic® 720/745 AL Traffic System

traffic system

Sikalastic® 720/745 AL Traffic System

Two component, fast curing, solvent-free,

elastomeric, crack-bridging, waterproofing



#### SEALANT• WATERPROOFING & RESTORATION INSTITUTE

Issued to: Sika Corporation Product: Sikalastic 720/745 AL Traffic System ASTM D 412: Tensile Strength of Topcoat Sikalastic 745 AL Topcoat Tensile Strength: 2,912 ps; Elongation: 254% ASTM D 4541: Adhesion of Base Coat

ASTM D 4541: Adhesion of Base Coat Sikalastic 720 with Fast Track Primer Pull-off Adhesion: 531 psi

ASTM D 4060: Abrasion Resistance of Top Coat

Pass 🖌

Sikalastic 745 AL Topcoat Abrasion Resistance: 4 mgms loss Pass 🛩

Validation Date: 10/12/15-10/11/20

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			DECK COATING VALIDATION www.swrionline.org
Description	Sikalastic <sup>®</sup> 720/745 AL Traffic System is a two- system designed for use as a waterproofing n System components are:	component, chemically contemporate for pedestrian	ured, elastomeric polyurethane coatin and vehicular traffic bearing surface
	Sikalastic <sup>®</sup> FTP Primer (see separate data she	eet).	
	Sikalastic <sup>®</sup> MT Primer - moisture tolerant prim		
	Sikalastic <sup>®</sup> 720 Base two-component, high so Sikalastic <sup>®</sup> 745 AL two-component, high solids		
	Sikalastic® 735 AL, 736 AL Lo-VOC and 748 F		
	phatic Top Coats data sheet).		
Where to Use	Sikalastic <sup>®</sup> 720/745 AL Traffic System is suitable surfaces exposed to vehicular or pedestrian tr		ound concrete, cementitious or plywoo
	<ul> <li>Multi-story parking garages.</li> </ul>		
	<ul><li>Parking decks and ramps.</li><li>Foot bridges and walkways.</li></ul>		
	<ul> <li>Mechanical rooms.</li> </ul>		
	Stadiums and arenas.		
	<ul><li>Plaza and rooftop decks.</li><li>Balconies.</li></ul>		
Advantages	<ul> <li>Low odor and fast turnaround.</li> <li>Excellent crack-bridging properties and flex</li> </ul>	vibility even at low temp	araturas
	<ul> <li>Outstanding resistance to abrasion and we</li> </ul>		eratures.
	Impervious to water and deicing salts.		
	Range of standard colors and decorative of standard colors and decorative of standard colors.	•	
Coverage	Coverage rates provided are intended to achieve required wet film thickness under optimal conditions. Add tional material may be required depending on substrate surface roughness and porosity, material and substrate temperatures, and other site-dependent factors. This will result in a lower coverage rate.		
Cure Mechanism	Chemical Cure.		
Packaging	Sikalastic <sup>®</sup> 720 Base: 20 gal. kit - four 5 ga Sikalastic <sup>®</sup> 745 AL:17.6 gal. kit - four 5 gal. pails		
	Typical Data (Material and curing con	ditions @ 75°F (24°C) a	and 50% RH)
	RESULTS MAY DIFFER BASED UPON STATISTICAL V TEMPERATURE, APPLICATION METHODS, TEST MET	ARIATIONS DEPENDING UPON	MIXING METHODS AND EQUIPMENT,
	Shelf Life:	1 year in original,	unopened containers.
	Storage:	Store dry at 40°-9	95°F (4°-35°C).
	Product Conditioning:	Condition material	to 65°-85°F (18°-30°C) before using.
	Colors:		
	Sikalastic <sup>®</sup> 720 Base: Gray Sikalastic <sup>®</sup> 745 AL: Gray, Charcoal and Ta	n: custom colors availab	le.
		720 Base	745 AL
	Pot Life:	10-15 minutes	20-30 minutes
	Total Volume Solids (ASTM D-2697):	95%	100%
	VOC Content (ASTM D-2369-81):	<10 g/l	<10 g/l
	Tensile Strength (ASTM D-412):	2500 ± 100 psi	3200 ± 300 psi
	<b>.</b> . ,	800% ± 100 %	300% ± 50 %
	Elongation at Break (ASTM D-412):	00070 10070	000/0 ± 00 /0
	Tear Resistance (Die C, ASTM D-412):	300 ± 25 pli	300 ± 30 pli

	Adhesion: Abrasion Resistance (ASTM D4060):	525 psi n/a	n/a 4 mg
	Test 1000 cycles, 1000g and CS-17 wheel UV Resistance and Recovery from Elongation (ASTM C-957)	n/a	PASS
low to Use	Surface must be clean, dry and sound with an ope	en texture. Remove	dust. laitance, grease, curing compound
	bond inhibiting impregnations, waxes, and any of dressed off to achieve a level surface prior to ap	ther contaminants. A	
	<b>Concrete-</b> Should be cleaned and prepared to ac by blast cleaning or equivalent mechanical mean	ns (CSP 3-4 per ICF	
	Route out all cracks and joints as part of surface		
	<b>Plywood-</b> Should be clean and smooth, APA a supported according to APA guidelines. Joints sh need embedded fabric reinforcement.		
	Metal- Should be thoroughly cleaned by grinding	g or blast cleaning.	
Application	Priming		
	<b>Primer Selection -</b> Determine maximum moistur or CMExpert type concrete moisture meter.	e content of concret	e substrate by weight with a Tramex CM
	<b>Sikalastic FTP Primer</b> – For concrete decks with decks, apply Sikalastic FTP Primer with a flat so gal. and work well into the substrate to ensure a Sikalastic FTP Primer is not suitable for metal s information.	ueegee or phenolic adequate penetratic	resin core roller at approximately 300 s n and sealing, and puddles are avoided
	Sikalastic FTP Lo-VOC Primer - For exterior of 4% by weight, interior protected concrete dee plywood decks, apply Sikalastic FTP Lo-VOC 1 approximately 300 sf/gal. and work well into the puddles are avoided. For exterior exposed concr two applications of Sikalastic FTP Lo-VOC Prime for metal substrates. Refer to separate primer da	cks with a maximun Primer with a flat s substrate to ensur ete decks with a ma er are required. Sika	n moisture content of 5% by weight, an queegee or phenolic resin core roller e adequate penetration and sealing, an ximum moisture content of 5% by weigh alastic FTP Lo-VOC Primer is not suitab
	Sikalastic PF Lo-VOC Primer - For concrete and flanges and penetrations, use Sikalastic PF Lo-V mum moisture content of 4% by weight, interior p 5% by weight, and plywood decks, apply Sikalas core roller at approximately 200 sf/gal. and worl sealing, and puddles are avoided. For exterior e 5% by weight, two applications of Sikalastic PF sheet for additional information.	OC Primer. For extent protected concrete d stic PF Lo-VOC Prin k well into the subst exposed concrete de	erior exposed concrete decks with a max ecks with a maximum moisture content of ner with a flat squeegee or phenolic res rate to ensure adequate penetration an ecks with a maximum moisture content of
	<b>Sikalastic MT Primer -</b> For concrete with a maxi and penetrations, apply Sikalastic MT Primer w concrete decks with a maximum moisture conter Primer with a flat squeegee or phenolic resin ro well into the substrate to ensure adequate penetre primer data sheet for additional information.	ith a flat squeegee ent of 6% by weight Iler at approximatel	or roller at approximately 175 sf/gal. Fo , apply two applications of Sikalastic M y 175 sf/gal per application. Work prime
	Sikalastic Recoat Primer – For existing polyure as an interlaminate primer, apply Sikalastic Rec at approximately 300 sf/gal. and work will into th puddles are avoided. Sikalastic Recoat Primer i data sheet for additional information.	coat Primer with a fl e substrate to ensu	at squeegee or phenolic resin core rolle re adequate penetration and sealing, ar
	Primer Mixing		
	Sikalastic FTP Primer – Premix Part A and Par mechanical mixer and Jiffy Paddle at slow speed scrape the solids from the bottom and sides of th may appear black in the container. Sikalastic FT FTP Part A to the 1.25 gallons of Part B in the s until a homogenous mixture and uniform color i a light olive green color. Slowly add 1.25 gallon additional 2 minutes until the mixture is fully disp white in color.	to obtain uniform of he pail. Sikalastic F P Part A is light am short filled Part B pa s obtained (typically s of potable water f	blor (typically 30 seconds), making sure TP Part B is dark olive green in color ar ber in color. Add the 1 gallon of Sikalast ail. Mix the combined material thorough y 3 minutes). This mixture will appear a o the mixture under agitation. Mix for a
Ka INS SHI PAF TO	Sikalastic FTP Lo-VOC Primer - Premix Part A using a low speed (400-600 rpm) mechanical n OR TO EACH USE OF ANY SIKA PRODUCT, THE US TRUCTIONS ON THE PRODUCT'S MOST CURRENT EET WHICH ARE AVAILABLE ONLINE AT HTTP://USA RTMENT AT 800.933.7452 NOTHING CONTAINED IN AN READ AND FOLLOW THE WARNINGS AND INSTRUC NT PRODUCT DATA SHEET, PRODUCT LABEL AND S	nixer and Jiffy Pado SER MUST ALWAYS I PRODUCT DATA SHI SIKA.COM/ OR BY ( NY SIKA MATERIALS TIONS FOR EACH SI	Ile at slow speed to obtain uniform colo READ AND FOLLOW THE WARNINGS AN EET, PRODUCT LABEL AND SAFETY DAT CALLING SIKA'S TECHNICAL SERVICE DE RELIEVES THE USER OF THE OBLIGATIO KA PRODUCT AS SET FORTH IN THE CUF



(typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For the 3 gallon kit, pour Part B into Part A slowly and while mixing scrape the side of the container, For the 15 gallon kit, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 2 parts A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic PF Lo-VOC Primer -** Premix Part A (black liquid) and Part B (white liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 gallon kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic MT Primer** - Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

**Sikalastic Recoat Primer** – Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part A into a separate container. Pour Part B into Part A slowly and while mixing scrape the side of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). In the event that a faster cure is required, Sikalastic Recoat Primer can be applied with Sikalastic 700 ACL as an accelerator. Add two quarts Sikalastic 700 ACL into 10 gallons of mixed primer. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

#### <u>Detailing</u>

Non-structural cracks up to 1/16 inch - Apply a detail coat of Sikalastic<sup>®</sup> 720 Base at 23 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.

**Cracks and joints over 1/16 up to 1 inch -** Rout and seal with Sikaflex<sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic<sup>®</sup> 720 Base at 23 mils, 4" wide, centered over the crack. Allow to become tack free before over coating.

Joints over 1 inch - Should be treated as expansion joints and brought up through the Sikalastic<sup>®</sup> 720 Base waterproofing membrane and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant.

**Fabric Reinforcement** – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.

Panelized Joints - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.

NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.

#### Base Coat

Premix mix Sikalastic<sup>®</sup> 720 Base Part A and Part B material (typically 30 seconds) using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the sides of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel and back roll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and joints. Allow coating to cure a minimum of 3-4 hours at 70°F and 50% RH or until tack free before top coating.

#### Top Coats

Premix Sikalastic<sup>®</sup> 745 AL Part A using a using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Add Part B and continue mixing until a homogenous mixture and color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, or phenolic resin core roller, and back roll. Apply aggregate evenly distributed at the appropriate rate immediately into the wet coating and back roll if required (see System Guide). Allow coating to cure a minimum of 3-4 hours at 70°F and 50% RH or until tack free between coats, and a minimum of 36 hours before opening to vehicular traffic.



#### Aggregate

Use clean, rounded, oven dried, quartz sand with a minimum gradation of 16-30 or 12-20 mesh for vehicular traffic and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means and even, light broadcast short of to refusal. Any loose aggregate must be removed prior to re-coating. Back roll aggregate only where indicated.

System Guide	Pedestrian Traffic	Heavy Pedestrian /Light Vehicular	Heavy Vehicular Traffic		
Primer	Sikalastic FTP - 300 ft²/gal. Consi	Sikalastic FTP - 300 ft <sup>2</sup> /gal. Consult Sika for other primer options for recover and high moisture content substrates.			
720 Detail Coat	23 mils	wet over properly treated cracks a	ind joints.		
720 Base Coat		23 mils wet (23 mils dry) - 70 ft²/ga	al.		
745 Top Coat I	12 mils wet (12 mils dry) - 133 ft²/ gal.	18 mils wet (18 mils dry) - 90 ft²/gal.	14 mils wet (14 mils dry) - 115 ft²/gal.		
Aggregate	5-10 lbs/100 ft <sup>2</sup> - seeded/back- rolled	10-20 lbs/100 sf - seeded/ backrolled	10-15 lbs/100 ft <sup>2</sup> seeded (backroll optional)		
745 Top Coat II			18 mils wet (18 mils dry) - 90 ft²/gal		
Aggregate			10-20 lbs/100 ft <sup>2</sup> - seeded/backrolled		
Total Thickness	35 mils dry (excluding aggregate)	41 mils dry (excluding ag- gregate)	55 mils dry (excluding aggregate)		
See separate Sikalastic <sup>®</sup> Aliphatic Top Coats data sheet for DecoQuartz <sup>®</sup> and DecoFlake <sup>®</sup> systems.					
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.					

**Recoat Windows** 

In the event of an unforeseen rain event or delays beyond the stated recoat window referenced in each product's current PDS, observe the following.

Product	Recoat Window	Required Surface Preparation After Recoat Window is Exceeded
Sikalastic FTP	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic FTP Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic PF Lo-VOC	Tack-free to 16 hours	Heavily abrade and reprime
Sikalastic MT	Tack-free to 48 hours	Heavily abrade and reprime
Sikalastic Recoat	Tack-free to 12 hours	Heavily abrade and reprime
Sikalastic Recoat with 700 ACL Accelerator	Tack-free to 6 hours	Heavily abrade and reprime
Sikalastic 720	Tack-free to 24 hours	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 745 AL	Tack-free to 24 hours	Abrade, clean and solvent wipe <b>or</b> Abrade, clean and Sikalastic Recoat Primer

Notes:

- 1. Heavy abrasion of epoxy-based materials is intended to achieve an open, porous surface and to remove any amine blush that may interfere with bonding.
- 2. Abrasion of polyurethane-based materials is intended to achieve an open, porous surface.
- 3. Cleaning is intended to remove dirt, debris, contaminants, and residue from mechanical surface preparation methods.
- 4. Recommended solvents include high quality xylene and acetone. Handling and use of all solvents must be done in accordance with the manufacturer's warnings and instructions for use.

Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.

Maintenance/Repair

Removal

ir Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow removal equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to well adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.



#### Limitations

- To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.
- Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for Sikalastic FTP Primer; 4% for exterior exposed decks with one application of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for exterior exposed decks with two applications of Sikalastic FTP Lo-VOC Primer or Sikalastic PF Lo-VOC Primer; 5% for interior protected decks with one application of Sikalastic FTP Lo-VOC Primer; 5% for exterior and interior decks with one application of Sikalastic MT Primer; 6% for exterior and interior decks with two applications of Sikalastic MT Primer. (see separate Primer product data sheets).
- Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 95°F (35°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
- Coating materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield.
- Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.
- Do not thin with solvents.
- Use properly graded, oven dried aggregates only.
- Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- Precautions should be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.
- Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is emminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.
- When applying over existing coatings compatibility and adhesion testing is recommended.
- Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.
- Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.
- On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic<sup>®</sup> Traffic Systems.
- Unvented metal pan decks or decks containing between-slab membrane require further technical evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.
- Do not subject to continuous immersion. Ponding water up to 72 hours duration is not considered to be continuous immersion.
- Sikalastic<sup>®</sup> 720 Base coat is not UV stable and must be top coated.
- Base and intermediate coats must be kept clean and re-coated within 24 hours. If this recoat window is
  exceeded, contact Sika for recommendations.
- Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



## Sikalastic<sup>®</sup> 720 SG Base

Two-component, fast-curing, summer grade, solvent-free, crack-bridging, elastomeric polyurethane base coat

Description	Sikalastic <sup>®</sup> 720 is a two-component, aromatic, chemically cured, elastomeric polyurethane coating intended for use as the waterproofing base coat under polyurethane or epoxy wearing surfaces for pedestrian and vehicular traffic bearing applications, and as the waterproofing base coat under a separate wearing course such as concrete, and tile in a setting bed.
Where To Use	<ul> <li>Multi-story parking garages.</li> <li>Parking decks and ramps.</li> <li>Foot bridges and walkways.</li> <li>Mechanical rooms.</li> <li>Stadiums and arena.</li> <li>Plaza and rooftop decks.</li> <li>Balconies.</li> </ul>
Advantages	<ul> <li>Low odor and fast turnaround.</li> <li>Extended working time in warmer weather conditions.</li> <li>Excellent crack-bridging properties and flexibility, even at low temperatures.</li> <li>Resistant to water and de-icing salts.</li> <li>Alkaline resistant.</li> </ul>
Coverage	70 ft²/gal. @ 23 wet mils (23 dry mils).
Packaging	5 gal. kit - Part A (4 gal.) and Part B (1 gal.). Minumum order: 20 gal. kit (4 x 5 gal. kits)
Cure Mechanism	Chemical cure.
Chemical Resistance	Resistant to de-icing salts, and alkaline concrete and cementitious mortars/tile adhesives.
	Typical Data (Material and curing conditions at 75°F (24°C) and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,

Shelf Life	1 year in original, unopened containers.		
Storage Conditions	Store dry at 40°-95°F (4°- before using.	Store dry at 40°-95°F (4°-35°C). Condition material to 65°- 85°F (18°- 30°C) before using.	
Color	Medium Gray		
Pot Life		15-20 minutes	
Total Volume Solids	(ASTM D-2697)	95%	
VOCs (ASTM D-2369-81)		< 5 g/l	
Tensile Strength (ASTM D-412)		2100 +/- 200 psi	
Elongation at Break	(ASTM D-412)	900 +/- 100%	
Tear Resistance (Die C, ASTM D-624)		250 +/- 25 pli	
Hardness (ASTM D-2	240)	70 +/- 5 Shore A	

TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.



#### Surface Preparation

n Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application.

**Concrete** - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).

**Plywood** - Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported according to APA guidelines. Joints should be sealed with Sikaflex<sup>®</sup> 2c or 1a and detailed and may need embedded fabric reinforcement.

Metal - Should be thoroughly cleaned by grinding or blast cleaning.

#### <u>Priming</u>

Refer to separate primer data sheets for more detailed information.

**Concrete** - For concrete decks with a maximum moisture content of 4% by weight, apply Sikalastic<sup>®</sup> FTP with a flat squeegee or roller at approximately 300 ft<sup>2</sup>/gal. For concrete decks with a maximum moisture content of 5% by weight, apply Sikalastic<sup>®</sup> MT with a flat squeegee or roller at approximately 150 ft<sup>2</sup>/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic<sup>®</sup> MT with a flat squeegee or roller at approximately 150 ft<sup>2</sup>/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic<sup>®</sup> MT with a flat squeegee or roller at approximately 150 ft<sup>2</sup>/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic<sup>®</sup> MT with a flat squeegee or roller at approximately 150 ft<sup>2</sup>/gal. per application. Work primer well into the substrate to ensure adequate penetration and sealing, and puddles are avoided.

**Plywood** - Apply Sikalastic<sup>®</sup> FTP with a flat squeegee or roller at approximately 300 ft<sup>2</sup>/gal, working primer well into the substrate to ensure adequate penetration and sealing, and puddles are avoided.

Metal - Consult Sika regarding primer recommendations.

#### Detailing

**Non-structural cracks up to 1/16 inch -** Apply a detail coat of Sikalastic<sup>®</sup> 720 SG at 23 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.

**Cracks and joints over 1/16 up to 1 inch -** Rout and seal with Sikaflex<sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic<sup>®</sup> 720 SG at 23 mils, 4" wide, centered over the crack. Allow to become tack free before over coating.

Joints over 1 inch - Should be treated as expansion joints and brought up through the Sikalastic<sup>®</sup> 720 SG waterproofing membrane and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant.

**Fabric Reinforcement** – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.

**Panelized Joints** - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.

NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex<sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.

Premix Part A and Part B components using a mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Pour part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture.

ApplicationApply at the recommended coverage rate (see appropriate System Guide) using a notched squeegee or trowel,<br/>and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed<br/>cracks and joints. Allow coating to cure a minimum of 3-4 hours at 70°F and 50% RH or until tack fee before<br/>top coating. Allow coating to cure for a minimum of 36 hours before installing separate wear course.

- Removal Remove liquid coating immediately with dry cloth. Once cured, coating can only be removed by mechanical means.
  - To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.
    - Maximum moisture content of substrate: 4% by weight with Sikalastic<sup>®</sup> FTP primer, and 6% by weight with Sikalastic<sup>®</sup> MT.
    - Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 95°F (35°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
    - Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials
      with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and
      moisture. Observe temperature storage and conditioning requirements.
    - Do not thin with solvents.
    - Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
    - Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

Mixing

Limitations



- Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.
- When applying over existing coatings compatibility and adhesion testing is recommended.
- On grade, lightweight concrete, asphalt pavement, and applications where chained or studded tires may be used should not be coated with Sikalastic® traffic systems.
  - Unvented metal pan decks or decks containing between-slab membranes require further technical evaluation and priming with a moisture-blocking primer - contact Sika regarding recommendations.
  - Waterproofing applications under overburden, including concrete pavement, and tile in a cementitious setting bed, require further technical evaluation - contact Sika regarding recommendations.
- Do not subject to continuous immersion.
- Sikalastic® 720 SG is not UV stable and must be top coated or protected by a separate wearing course.
- Primer and base coat must be kept clean and recoated primer within 48 hours, base coat within 24 hours. If this window is exceeded, contact Sika for recommendations.
- Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

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KEEP CONTAINER TIGHTLY CLOSED, KEEP OUT OF REACH OF CHILDREN, NOT FOR INTERNAL CONSUMPTION, FOR INDUSTRIAL USE ONLY, FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on SIKA Warrains und product for one year from date of instantation to be needed in infandiatuming defects and beet were the current product by the current product by the current product by the current product by the current suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALL NOT OR 102 8900 CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera

Visit our website at usa.sika.com

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center. Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

(R)

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

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**F70** 

# Sikalastic<sup>®</sup> 390/391/395 Traffic System

# Two-component, solvent-free, elastomeric, crack-bridging, waterproofing traffic system

		T	mnonent chemically	cured elastomeri
Description		stem designed for use as a ring surfaces. System is a two-co	waterproofing mem	
	Sikalastic 390 two-compor Sikalastic 391 two-compor	bisture tolerant primer (see s onent, high solids, aromatic nent, high solids, aromatic pol onent, high solids, aliphatic	polyurethane base yurethane intermediat	coat te and interior top coa
Where to Use	Sikalastic 390/391/395 T	raffic System is suitable for	use on structurally s	sound concrete.
		surfaces exposed to vehicu		
	Multi-story parking gar			
	Parking decks and ran			
	<ul> <li>Foot bridges and walk</li> <li>Mechanical rooms</li> </ul>	ways		
	<ul> <li>Stadiums and arenas</li> </ul>			
	Plaza and rooftop decl	ks		
	Balconies			
Advantages	Low odor and fast turn	naround		
	-	ng properties and flexibility,	even at low tempera	atures
	<ul> <li>Outstanding resistand</li> </ul>			
	<ul> <li>Impervious to water, id</li> <li>Resistant to deicing statements</li> </ul>			
		typical concrete substrate	application condition	S
	Range of standard co	lors		
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PackagingSikalastic 390: 5 gal. two component kit, 3.33 gal. comp. A, 1.67 gal. comp. BSikalastic 391: 5 gal. two component kit, 3.89 gal. comp. A, 1.11 gal. comp. BSikalastic 395: 5 gal. two component kit, 4.5 gal. comp. A, 0.5 gal. comp. B

Approvals

Sikalastic materials tested in accordance wit	th ASTM C957
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#### Coverage

System Guide	Pedestrian Traffic	Heavy Pedestrian / Light Vehicular	Heavy Vehicular Traffic	
Primer	No primer required for typical new and recover applications. See Limitations.			
390 Detail Coat		30 mils wet over properly treated cracks	and joints.	
390 Base Coat		20 mils wet (20 mils dry) - 80 sf/gal.		
391/395 Top Coat I	15 mils wet (15 mils dry) - 107 sf/gal	20 mils wet (20 mils dry) - 80 sf/gal	15 mils wet (15 mils dry) - 107 sf/gal	
Aggregate	5-10 lbs/100 sf -seeded/backrolled	10-15 lbs/100 sf -seeded/backrolled	10-15 lbs/100 sf -seeded (backroll optional)	
391/395 Top Coat II		20 mils wet (20 mils dry) - 80 sf/gal		
Aggregate			10-15 lbs/100 sf -seeded/backrolled	
Total Thickness	35 mils dry (excluding aggregate)	40 mils dry (excluding aggregate)	55 mils dry (excluding aggregate)	
Sikalastic 391 is not long term UV resistant. Use Sikalastic 395 for all top coats directly exposed to UV.				

How To Use Surface Prepar	ation Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to application.
	<b>Concrete</b> - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).
	<b>Plywood</b> - Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported according to APA guidelines. Seams should be sealed with Sikaflex 2c or 1a and detailed and may need embedded fabric reinforcement.
	Metal - Should be thoroughly cleaned by grinding or blast cleaning.
Application	Priming
	For concrete decks with a maximum moisture content of 4% by weight, no priming is required. For concrete decks with a maximum moisture content of 5% by weight, apply Sikalastic MT Primer with a flat squeegee or roller at approximately 175 sf/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic MT Primer with a flat squeegee or roller at approximately 175 sf/gal. Work primer well into the substrate to ensure adequate penetration and sealing, and puddles are avoided.
	Consult Sika for primer options for wood and metal substrates.
	Detailing
	<b>Non-structural cracks up to 1/16 inch -</b> Apply a detail coat of Sikalastic 390 Base at 30 wet mils, 4" wide, centered over the crack. Allow to become tack free before overcoating.
	<b>Cracks and joints over 1/16 up to 1 inch -</b> Route and seal with Sikaflex 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic 390 Base at 30 wet mils, 4" wide, centered over crack. Allow to skin over and become tack free before overcoating.
	<b>Joints over 1 inch -</b> Should be treated as expansion joints and brought up through Sikalastic 390 Base and sealed with Sikaflex 2c or 1a sealant.
	<b>Fabric Reinforcement –</b> An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.
	<b>Panelized Joints</b> - Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.
	NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex <sup>®</sup> 2c or 1a sealant. For additional questions please contact
ka®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

#### Sika Technical Services. Base Coat

Premix mix Sikalastic 390 Base Part A and Part B components using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the sides of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and joints. Allow coating to cure a minimum of 5-6 hours at 70 degrees F and 50% RH; base coat must be tack free before overcoating.

#### Top Coats

Premix Sikalastic 391 or 395 Part A and Part B components using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Add Part B into Part A slowly and continue mixing until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, and backroll using a phenolic resin core roller. Apply aggregate evenly distributed at the appropriate rate immediately into the wet coating and backroll if required (see System Guide). Allow coating to cure a minimum of 10 hours (Sikalastic 391) or 4 hours (Sikalastic 391) or 36 hours (Sikalastic 395) before opening to vehicular traffic.

#### Aggregate

Use clean, rounded or semi-angular oven dried quartz sand with a minimum gradation of 12-20 or 16-30 mesh for vehicular traffic, and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means an even, light broadcast short of refusal. A full broadcast of aggregate means a heavy application to refusal. Any loose aggregate must be removed prior to recoating.

Backroll aggregate only where indicated.

**Removal** Remove liquid coating immediately with dry cloth. Once cured, coating can only be removed by mechanical means.

#### Limitations Maintenance/Repair

Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow removal equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to well adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.

#### Limitations/Precautions

- To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.
- Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter : 4% for unprimed applications; 5% with one application of Sikalastic MT primer; 6% with two applications of Sikalastic MT primer (see separate Sikalastic MT Primer product data sheet).
- Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 95°F. Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
- Coating materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield.
- Do not store materials outdoors exposed to sunlight for prolonged periods.
- Do not thin with solvents.



- Use properly graded, oven dried aggregates only.
- Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
  - Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
  - Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
  - Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.
  - When applying over existing coatings compatibility and adhesion testing is recommended.
  - Opening prior to final cure may result in loss of aggregate, or permanent staining and subse quent premature failure.
  - Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.
  - On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
  - Unvented metal pan decks or decks containing between-slab membranes require further technical evaluation and priming with a moisture-tolerant primer - contact Sika regarding recommendations.
  - Do not subject to continuous immersion.
  - Sikalastic 390 base coat is not UV stable and must be top coated.
- Sikalastic 391 is not UV stable and must be top coated for exterior applications.
- Primer, base and intermediate coats must be kept clean and recoated within 48 hours. If this recoat window is exceeded, contact Sika for recommendations.
- Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended

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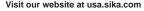
Fracc. Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5



Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.







# Sikalastic<sup>®</sup> 735 AL, 736 AL Lo-VOC and 748 PA Aliphatic Top Coats

High performance top coats for Sikalastic 710/715 and 720/745 Traffic Systems

Description	Sikalastic Aliphatic Top Coats are optional top coats for the Sikalastic 710/715 and 720/745 Traffic Systems. They provide superior UV resistance, color stability and cleanability as well as more decorative options. The series includes:			
	Sikalastic 735 AL one-component, moisture	cured, aliphatic polyurethane top coat		
	Sikalastic 736 AL Lo-VOC one-component,	moisture cured, low-VOC, aliphatic polyurethane top coat		
	Sikalastic 748 PA two-component, chemica	lly cured, low-VOC, aliphatic polyaspartic top coat		
	Sikalastic 700 ACL optional accelerator			
Where to Use		kalastic Traffic Systems, which are suitable for use on r plywood surfaces exposed to vehicular or pedestrian traffic.		
	<ul> <li>Multi-story parking garages</li> <li>Parking decks and ramps</li> <li>Foot bridges and walkways</li> <li>Mechanical rooms</li> <li>Stadiums and arenas</li> <li>Plaza and rooftop decks</li> <li>Balconies</li> </ul>			
Advantages	<ul> <li>Superior color and gloss retention and cleanability</li> <li>Outstanding resistance to abrasion and wear</li> <li>Impervious to water and deicing salts</li> <li>Range of standard colors as well as custom and decorative options</li> </ul>			
Packaging	Sikalastic 735 AL and 736 AL Lo-VOC	5 gal. pails		
	Sikalastic 748 PA	4 gal. unit (2, 1 gal. cans Part A and 2, 1 gal. cans Part B)		
	Sikalastic 700 ACL	1 quart cans (9 cans per carton)		
Colors	Sikalastic 735 AL and 736 AL Lo-VOC Sikalastic 748 PA	Gray, Charcoal and Tan; custom colors available Clear; custom colors available		
How to Use Surface Preparation	Sikalastic Aliphatic Top Coats are designed as alternate top coats for the Sikalastic 710/715 and 720/7 Traffic Systems (see separate data sheets for substrate preparation guidelines). When applying over existing coatings surface must be clean, dry and sound. Remove dust, laitance, grease, curing compo bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. s be dressed off to achieve a level surface prior to application.			

#### Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON Mixing METHODS AND EqUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Storage	Store dry at 40-95°F (4-35°C). Condition material to 65-85°F (18-30°C) before using.
Shelf Life	1 year in original, unopened containers.

	<u>735 AL</u>	736 AL Lo-VOC	748 PA Clear	748 PA Pigmented
Viscosity	2500 ± 700 cps	3500 ± 700 cps	200 ± 50 cps	200/300 ± 50 cps
Total Volume Solids (ASTM D-2697)	74%	83%	78%	80%
VOCs (ASTM D-2369-81)	225 g/l	99 g/l	100 g/l	95 g/l
Tensile Strength (ASTM D-412)	4200 ± 300 psi	4000 ± 300 psi	2500 ± 300 psi	2300 ± 300 psi
Elongation at Break (ASTM D-412)	230 ± 50 %	250 ± 50 %	75 ± 25 %	50 ± 20 %
Tear Resistance (Die C, ASTM D-624)	400 ± 50 pli	400 ± 50 pli	300 ± 50 pli	300 ± 50 pli
Hardness (ASTM D-2240)	90 ± 5 Shore A	90 ± 5 Shore A	50 ± 5 Shore D	50 ± 5 Shore D
Pot Life			45-60 minutes	45-60 minutes



Application

**Sikalastic 735 AL**, **736 AL Lo-VOC** - Thoroughly mix Sikalastic 735 AL and 736 AL Lo-VOC using a mechanical mixer (Jiffy) at slow speeds until a homogenous mixture and color is obtained. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) and backroll using a phenolic resin core roller. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating. Allow coating to cure a minimum of 16 hours at 70°F and 50% RH or until tack free between coats, and a minimum of 72 hours before opening to vehicular traffic.

**Sikalastic 748 PA** - Premix Sikalastic 748 PA Part A and Part B before combining. Add equal amounts of Part B to Part A while mixing using a mechanical mixer (Jiffy) at medium speed. Mix until a homogenous mixture and color is obtained (at least 3 minutes) and mix frequently during application to maintain uniform color. Scrape the sides of the container to ensure that no unmixed material remains and use care not to whip air into the material as this may result in pinhole blisters or shortened pot life. Pot life is 45-60 minutes at 75°F and 50% RH. Do not dilute under any circumstances. Apply at the recommended coverage rate (see System Guide) and backroll using a phenolic resin core roller. Allow 2-4 hours at 70°F and 50% RH or until tack free between coats and 24-48 hours before permitting heavy pedestrian or vehicular traffic.

**Aggregate** - Use clean, rounded oven, dried quartz sand with a minimum size gradation of 16-30 mesh for vehicular traffic and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means an even, light broadcast short of to refusal. Any loose aggregate must be removed prior to recoating. Backroll aggregate where indicated.

**Accelerator** - Sikalastic 700 ACL may be added to Sikalastic 735 AL or 736 AL Lo-VOC in order to speed cure time particularly in cold weather conditions. Mix thoroughly prior to application. Add a maximum of 1 quart to 5 gallons (or 1:20 ratio) and only to material that will applied within 2-3 hours.

System Guide -				
Product	Pedestrian Traffi	Heavy Pedestrian	Decorative quartz	Decof lake <sup>®</sup>
Primer		Sikafloor FTP - 300 sf/gal. Cons	ult Sika for other primer options	•
710 Detail Coat	32 mils wet ov	ver properly treated cracks and j	oints - see 710/715 Traffic Syste	ems data sheet
710 Base Coat	32 mil	s wet (23 mils dry) - 50 sf/gal s	ee 710/715 Traffic Systems data	a sheet
735 AL Top I	14 mils wet (10 mils dry) 115 sf/gal.	11 mils wet (8 mils dry) 145 sf/gal.	14 mils wet (10 mils dry) 115 sf/gal.	14 mils wet (10 mils dry) 115 sf/gal.
Aggregate	5-10 lbs/100 sf seeded/backrolled	10-15 lbs/100 sf - seeded	40-50 lbs/100 sf - broadcast	2-4 lbs/100 sf - seeded
735 AL Top II		16 mils wet (12 mils dry) 100 sf/gal.		
748 PA Top			13 mils wet (10 mils dry) 125 sf/gal.	9 mils wet (7 mils dry) 175 sf/gal.
Total Thickness	33 mils dry (excl. aggregate)	43 mils dry (excl. aggregate)	43 mils dry (excl. aggregate)	40 mils dry (excl. aggregate)

System Guide -				
Product	Pedestrian Traffi	Heavy Pedestrian	Decorative quartz	Decof lake <sup>®</sup>
Primer		Sikafloor FTP - 300 sf/gal. Cons	ult Sika for other primer options	
720 Detail Coat	23 mils wet ov	ver properly treated cracks and j	oints - see 720/745 Traffic Syste	ms data sheet
720 Base Coat	23 mil	s wet (23 mils dry) - 70 sf/gal s	ee 720/745 Traffic Systems data	a sheet
736 AL Lo-VOC I	12 mils wet (10 mils dry) 133 sf/gal.	10 mils wet (8 mils dry) 160 sf/gal.	12 mils wet (10 mils dry) 133 sf/gal.	12 mils wet (10 mils dry) 133 sf/gal.
Aggregate	5-10 lbs/100 sf seeded/backrolled	10-15 lbs/100 sf - seeded	40-50 lbs/100 sf - broadcast	2-4 lbs/100 sf - seeded
736 AL Lo-VOC II		14 mils wet (12 mils dry) 115 sf/gal.		
748 PA Top			13 mils wet (10 mils dry) 125 sf/gal.	9 mils wet (7 mils dry) 175 sf/gal.
Total Thickness	33 mils dry (excl. aggregate)	43 mils dry (excl. aggregate)	43 mils dry (excl. aggregate)	40 mils dry (excl. aggregate)



Limitations

- To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.
   Maximum moisture content of substrate: 4% by weight.
- Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 90°F (32°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
- Do not store materials outdoors exposed to sunlight for prolonged periods.
- Do not thin with solvents.
- Use properly graded, oven dried aggregates only.
- Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika
  representative for guidance on various product solutions). Surface irregularities may reflect through the
  cured system.
- Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not
  proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry
  after rain or inclement weather as there is the potential for bonding problems.
- When applying over existing coatings, compatibility and adhesion testing is recommended.
- Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.
- Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.
- On grade, unvented metal pan, split/sandwich slab and buried membrane conditions as well as lightweight concrete and asphalt or where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
- Do not subject to continuous immersion.
- Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

Caution

#### Sikalastic 735 AL

**IRRITANT.** Contains Polyurethane Prepolymer (Mixture), Solvent Naphtha Petroleum (64742-95-6), n-Butyl Acetate (CAS:123-86-4) and 3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate (CAS:4098-71-9). Causes eye and skin irritation.

#### Sikalastic 736 AL Lo-VOC

**IRRITANT:** Contains Quartz SiO2 (CAS: 14808-60-7), Solvent Naphtha Petroleum (64742-95-6), 4-Chloroa,a,a-trifluorotoluene (CAS:98-56-6) and n-Butyl Acetate (CAS:123-86-4). Causes eye and skin irritation. **WARNING:** This product contains a chemical known to the State of California to cause cancer.

#### Sikalastic 748 PA

Part A: DANGER: FLAMMABLE, IRRITANT, SENSITIZER. Contains Hexamethylene Diisocyanate, Oligomers (CAS: 28182-81-2), 4-Chloro-a,a,a-triflourotolene (CAS: 98-56-6) and 3-Isocyanatomethylcyclohexyl Isocyanate (CAS:4098-71-9). Keep away from heat, sparks, sunlight, electrical equipment, flame or other sources of ignition. VAPORS MAY IGNITE AND EXPLODE. DO NOT SMOKE. Use only in well ventilated areas. Open doors and windows during use. Causes eye/skin/respiratory irritation. May cause skin and respiratory sensitization. Inhalation can result in headaches and dizziness. Harmful if swallowed. intentional misuse by deliberate concentration and inhalation of vapors may be harmful or fatal. Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. intentional misuse by deliberate concentration and inhalation of vapors may be harmful or fatal.

Part B: DANGERR: FLAMMABLE, CORROSIVE, IRRITANT. Avoid direct contact. Contains Cyclohexanamine, 4,4'-methylenebis-(1-methylpropyl) (CAS: 154279-60-4) and 4-Chloro-a,a,a-triflourotoluene (CAS: 98-56-6). Keep away from heat, sparks, sunlight, electrical equipment, flame or other sources o ignition. VAPORS MAY IGNITE AND EXPLODE. DO NOT SMOKE. Use only in well ventilated areas. Open doors and windows during use. Corrosive to eyes/skin/digestive tract. Causes burns to eyes/skin/ digestive tract. Causes respiratory irritation. Inhalation can result in headaches and dizziness. Harmful if swallowed. Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions. Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. intentional misuse by deliberate concentration and inhalation of vapors may be harmful or fatal.



Handling & Storage	Avoid direct contact with eyes and skin. Wear chemical resistant gloves/goggles/clothing. Avoid breathing vapors. Use with adequate general and local ventilation. In absence of adequate ventilation, use properly fitted NIOSH approved respirator. Wash thoroughly after handling product. Store in a cool, dry, well ventilated area. Keep containers tightly closed.
f irst Aid	<b>Eyes</b> – Hold eyelids apart and flush thoroughly with water for 15 minutes. <b>Skin</b> – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. <b>inhalation</b> – Remove to fresh air. <b>ingestion</b> – Do not induce vomiting. Dilute with water. Contact physician. <b>in all cases contact a physician immediately if symptoms persist.</b>
Clean Up	Wear chemical resistant gloves/goggles/clothing. In absence of proper ventilation use properly fitted NIOSH respirator. Confine spill, collect using absorbent material and place in properly sealed container. Dispose of excess product in accordance with applicable local, state and federal regulations.
Maintenance/Repair	Clean with non-sudzing detergent and water and inspect regularly for mechanical damage. Snow removal equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to well adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.

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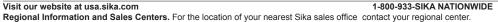
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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C P 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





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**F90** 

Product Data Sheet Edition 7.18.2016 Sikalastic 22 Lo-Mod Traffic System

## Sikalastic<sup>®</sup> 22 Lo-Mod Hybrid Traffic System Waterproofing traffic system with Sikalastic base coat and Sikadur<sup>®</sup> 22 Lo-Mod for added abrasion resistance

coat and Sikadur 22 Lo-Mod low-modulus epoxy top coat. It is designed for heavy vehicular or pedestria		
vehicular or pedestrian traffic.         • Multi-story parking garages         • Parking decks and ramps         • Foot bridges and walkways         • Mechanical rooms         • Stadiums and arenas         • Loading docks         • Balconies         • Surfaces around turns or corners subjected to more severe traffic conditions         Advantages         • Excellent crack-bridging properties of base coat, even at low temperatures         • Maximum resistance to abrasion and wear         • Impervious to water and deicing salts         Packaging         Sikalastic 710 Base: 5 gal. pails, 50 gal. (net) drums         Sikalastic 720 Base: 20 gal. kit - 3.33 gal. Part A, 1.67 gal. Part B         Sikalastic 710, 710 Lo-VOC, and 720 Base: Gray         Sikalastic 710, 710 Lo-VOC, and 720 Base: Gray         Sikalastic 390 Base: Brown	Description	Sikafloor FTP primer (separate data sheet available) Sikalastic MT primer (separate data sheet available) Option 1: Sikalastic 710 Base one-component aromatic polyurethane base coat Option 2: Sikalastic 710 Lo-VOC one-component aromatic polyurethane base coat Option 3: Sikalastic 720 Base two-component, high solids, fast curing polyurethane base coat Option 4: Sikalastic 390 two-component, high solids, polyurethane base coat Sikadur 22 Lo-Mod or Sikadur 22 Lo-Mod Fast Set, low-modulus medium viscosity epoxy resin binder Optional top coats: Sikalastic 735 AL, 736 AL Lo-Voc, 745 AL, or Sikalastic 391 and 395. See separate Sikadur 22 Lo-Mod, Sikalastic 710, 710 Lo-VOC 720, 735 AL, 736 AL Lo-VOC, 745 AL, and
Maximum resistance to abrasion and wear     Impervious to water and deicing salts      Packaging     Sikalastic 710 Base: 5 gal. pails, 50 gal. (net) drums     Sikalastic 710 Lo-VOC Base: 4.75 gal. pails, 50 gal (net) drums     Sikalastic 720 Base: 20 gal. kit - four 5 gal. pails (net 4 gal. each) Part A and four 1 gal. cans Part B     Sikalastic 390: 5 gal. kit - 3.33 gal. Part A, 1.67 gal. Part B     Sikalastic 710, 710 Lo-VOC, and 720 Base: Gray     Sikalastic 390 Base: Brown	Where to Use	vehicular or pedestrian traffic. <ul> <li>Multi-story parking garages</li> <li>Parking decks and ramps</li> <li>Foot bridges and walkways</li> <li>Mechanical rooms</li> <li>Stadiums and arenas</li> <li>Loading docks</li> <li>Balconies</li> </ul>
Sikalastic 710 Lo-VOC Base: 4.75 gal. pails, 50 gal (net) drums         Sikalastic 720 Base: 20 gal. kit - four 5 gal. pails (net 4 gal. each) Part A and four 1 gal. cans Part B         Sikalastic 390: 5 gal. kit - 3.33 gal. Part A, 1.67 gal. Part B         Sikadur 22 Lo-Mod: 4 gal. unit - 2 gal. can Part A and 2 gal can Part B         Sikalastic 710, 710 Lo-VOC, and 720 Base: Gray         Sikalastic 390 Base: Brown	Advantages	<ul> <li>Excellent crack-bridging properties of base coat, even at low temperatures</li> <li>Maximum resistance to abrasion and wear</li> </ul>
Sikalastic 390 Base: Brown	Packaging	Sikalastic 710 Lo-VOC Base: 4.75 gal. pails, 50 gal (net) drums Sikalastic 720 Base: 20 gal. kit - four 5 gal. pails (net 4 gal. each) Part A and four 1 gal. cans Part B Sikalastic 390: 5 gal. kit - 3.33 gal. Part A, 1.67 gal. Part B
	Colors	Sikalastic 390 Base: Brown

#### Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, AP-PLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

#### Storage Conditions Store dry at 40-95°F (4-35°C). Condition material to 65-85°F (18-30°C)

before using

	Sikalastic 710 Base	Sikalastic 710 Lo- VOC Base	Sikalastic 720 Base	Sikalastic 390 Base	Sikalastic 22 LM
Shelf Life (in original unopened containers)	1 year	1 year	1 year	1 year	2 year
Viscosity / Pot Life	6500 ± 3000 cps	6500 ± 3000 cps	10-15 minutes	15-20 minutes	~2000 cps / ~30 min
Total Volume Solids (ASTM D-2697	71%	89%	100%	100%	100%
VOC Content (ASTM D-2369-81)	240 g/l	93 g/l	<10 g/l	<10 g/l	56 g/l
Tensile Strength (ASTM D-412)	800 ± 100 psi	1200 ± 300 psi	2500 ± 100 psi	1,320 psi	5700 psi (D-638)
Elongation at Break (ASTM D-412)	500 ± 50%	450 ± 50%	800 ± 100%	435%	>30% (D-638)
Tear Resistance (Die C, ASTM D-624)	170 ± 25 pli	195 ± 25 pli	300 ±25 pli	218 pli	n/a
Hardness (ASTM D-2240)	55 ± 5 Shore A	75 ± 5 Shore A	80 ± 5 Shore A	80 ± 5 Shore A	70 Shore D



How to Use	
Surface Preparation	Surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, cur ing compounds, bond inhibiting impregnations, waxes, and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to application.
	<b>Concrete -</b> Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means (CSP 3-4 per ICRI guidelines).
	Route out all cracks and joints as part of surface preparation.
	Metal - Should be thoroughly cleaned by grinding or blast cleaning.
Application	
Priming	<b>Primer Selection</b> - Determine maximum moisture content of concrete substrate by weight with a Tramex CME or CMExpert type concrete moisture meter.
	Sikalastic FTP Primer – For concrete decks with a maximum moisture content of 4% by weight, and for plywood decks, apply Sikalastic FTP Primer with a flat squeegee or phenolic resin core roller at approximately 300 sf/gal. and work well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Sikalastic FTP Primer is not suitable for metal substrates. Refer to separate primer data sheet for additional information.
	Sikalastic MT Primer - For concrete with a maximum moisture content of 5% by weight, and for metal flanges and penetrations, apply Sikalastic MT Primer with a flat squeegee or roller at approximately 175 sf/gal. For concrete decks with a maximum moisture content of 6% by weight, apply two applications of Sikalastic MT Primer with a flat squeegee or phenolic resin roller at approximately 175 sf/gal per application. Work primer well into the substrate to ensure adequate penetration and sealing, and puddles are avoided. Refer to separate primer data sheet for additional information. Primer Mixing
	Sikalastic FTP Primer – Premix Part A and Part B components separately using a low speed (400-600 rpm)
	Sikalastic FTP Finite – Preink Part A and Part B components separately using a low speed (400-000 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Sikalastic FTP Part B is dark olive green in color and may appear black in the container. Sikalastic FTP Part A is light amber in color. Add the 1 gallon of Sikalastic FTP Part A to the 1.25 gallons of Part B in the short filled Part B pail. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). This mixture will appear as a light olive green color. Slowly add 1.25 gallons of potable water to the mixture under agitation. Mix for an additional 2 minutes until the mixture is fully dispersed. Fully dispersed material will appear as light yellow to white in color.
	Sikalastic MT Primer - Premix Part A and Part B components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds), making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.
Detailing	Non-structural cracks up to 1/16 inch – Apply a detail coat of Sikalastic 710 Base at 32 mils wet, Sikalastic 710 Lo-VOC Base at 26 mils wet, Sikalastic 720 Base at 23 mils wet, or Sikalastic 390 Base at 30 mils wet, 4" wide, centered over the crack. Allow to become tack free before overcoating.
	Cracks and joints over 1/16 up to 1 inch - Rout and seal with Sikaflex <sup>®</sup> 2c or 1a sealant and allow to cure. Apply a detail coat of Sikalastic 710 Base at 32 mils wet, Sikalastic 710 Lo-VOC Base at 26 mils wet, Sikalas- tic 720 Base at 23 mils wet, or Sikalastic 390 Base at 30 mils wet, 4" wide, centered over the crack. Allow to become tack free before overcoating.
	Joints over 1 inch – Should be treated as expansion joints and brought up through the Sikalastic 710 Base, Sikalastic 710 Lo-VOC Base, Sikalastic 720 Base, or Sikalastic 390 Base waterproofing membrane and sealed with Sikaflex <sup>®</sup> 2c or 1a sealant.
	<b>Fabric Reinforcement</b> – An optional 3" or 6" wide Sikalastic Flexitape Heavy fabric strip may be embedded within the base coat. Flexitape width shall be chosen such that a minimum of 1" tape is embedded on either side of the crack/joint. Apply additional coating as required to fully embed the Flexitape in the coating.
	Panelized Joints – Panelized joints that are restrained across the joint and without differential movement may be sealed and the deck coating, including detail coat, applied over the joint.
	NOTE: movement within panelized joints may cause deterioration of the aggregated wear coat, in which case the joints should be treated as expansion joints and brought up through the Sikalastic Traffic System and sealed with Sikaflex <sup>®</sup> 2c or 1a sealant. For additional questions please contact Sika Technical Services.
Base Coats	<b>Sikalastic 710 Base</b> – Thoroughly mix (typically 30 seconds) using a low speed (400-600 rpm) drill with me- chanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and control joints. Allow coating to cure a minimum of 16 hours at 70°F and 50% RH; base coat must be tack free before over coating.
ka®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Sikalastic 710 Lo-VOC Base - Thoroughly mix Sikalastic 710 Base Lo-VOC using a low speed (400-600 rpm drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Add Sikalastic 710 Base Lo-VOC Booster (if required) into premixed coating and continue mixing until homogenous mixture and color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a ¼" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and control joints. Allow coating to cure a minimum of 16 hours (6 hours with Booster) at 70°F and 50% RH or until tack free before top coating. Sikalastic 720 Base - Premix Part A and Part B material (typically 30 seconds) using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color. Making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the sides of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and joints. Allow coating to cure a minimum of 3-4 hours at 70°F and 50% RH; base coat must be tack free before over coating. It is important to overcoat within 24 hours. Contact Sika if this window is exceeded. Sikalastic 390 - Premix Part A and Part B material (typically 30 seconds) using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Pour Part B into Part A slowly and while mixing scrape the sides of the container. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel and backroll using a phenolic resin core roller. Extend base coat over entire area including previously detailed cracks and joints. Allow coating to cure a minimum of 5-6 hours at 70°F and 50% RH; base coat must be tack free before over coating. It is important to overcoat within 48 hours. Contact Sika if this window is exceeded. **Binder Coats** Premix Sikadur 22 Lo-Mod Part A and Part B and proportion equal parts by volume into a clean mixing container. Mix with a low-speed (400-600 rpm) mechanical mixer (Jiffy), scraping the sides of the container while mixing, and using care not to allow the entrapment of air into the mixture. Mix the combined materials thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Apply at the recommended coverage rate (see System Guide) using a notched 3/16" squeegee and backroll using a phenolic resin core roller. Apply aggregate evenly distributed at the appropriate rate immediately into wet coating. For full broadcast applications, slowly broadcast so the aggregate falls vertically into the binder making several passes, allow the binder to bleed through the sand before making the next pass. Cover completely before binder becomes tack free. Allow coating to cure a minimum of 8 hours at 70 degrees F and 50% RH or until tack free between coats. Remove all loose aggregate before top coating or opening to traffic. If no top coat is to be applied, allow coating to cure a minimum of 24 hours (720 Base, 710 Lo-VOC w/Booster), 36 hours (390), or 48 hours (710 Base, 710 Lo-VOC) before opening to vehicular traffic. For seed and backroll applications, apply aggregate distributed at the appropriate rate immediately into wet coating and backroll. Allow coating to cure a minimum of 8 hours or until tack free before top coating. Use clean, rounded, oven dried quartz sand with a minimum size gradation of 16-30 mesh for vehicular traffic Aggregate and 20-40 mesh for pedestrian traffic, and a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. Seeding of aggregate means an even, light broadcast short of refusal, at an application rate of 10-20 lbs. per 100 square feet, and requires backrolling. A full broadcast of aggregate means a heavy application to refusal; slowly broadcast so the aggregate falls vertically into the binder making several passes, allowing the binder to bleed through the sand before making the next pass; cover completely at a total rate of 1.25 to 1.5 lbs. per square foot before binder becomes tack free; after tack free remove all loose aggregate prior to top coating or opening to traffic. **Top Coats** Sikalastic 735 AL, 736 AL Lo-VOC - Thoroughly mix (typically 30 seconds) using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed until a homogenous mixture and color is obtained. Use care not to allow the entrapment of air into the mixture. Apply at the recommended overage rate (see System Guide) and backroll using a phenolic resin core roller. Allow coating to cure a minimum of 16 hours at 70°F and 50% RH or until tack free between coats, and a minimum of 72 hours before opening to vehicular traffic. Sikalastic 745 AL - Premix Sikalastic 745 AL Part A with a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Add Part B and continue mixing until a homogenous mixture and color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Apply at the recommended coverage rate (see System Guide) and backroll using a phenolic resin core roller. Allow coating to cure a minimum of 4 hours at 70°F and 50% RH or until tack free between coats, and a minimum of 36 hours before opening to vehicular traffic Sikalastic 391, 395 - Premix Sikalastic 391 or 395 Part A and Part B components using a low speed (400-600 rpm) drill with mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Add Part B into Part A slowly and continue mixing until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION

TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR

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the mixture. Apply at the recommended coverage rate (see System Guide) using a 3/16" notched squeegee or trowel, and backroll using a phenolic resin core roller. Allow coating to cure a minimum of 48 hours (391) or 36 hours (395) before opening to vehicular traffic.

## System Guides Sikalastic 710/22 Lo-Mod Traffic System – Single Component

System Guide	Standard Vehicular Traffic - Full Broadcast	Heavy Vehicular Traffic - Full Broadcast	Extra Heavy Vehicular Traffic - Full Broadcast
Primer	Sikalastic FTP - 300 sf/gal. Consu	Ilt Sika for other primer options for r substrates.	ecover and high moisture content
710 Detail Coat	32 mils	wet over properly treated cracks and	l joints.
710 Base Coat		32 mils wet (23 mils dry) - 50 sf/gal.	
22 Lo-Mod Binder I	20 mils wet (20 mils dry) - 70 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal
Aggregate I	1.25 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal
22 Lo-Mod Binder II			32 mils wet (32 mils dry) - 50 sf/gal
Aggregate II			1.5 lbs/sf broadcasted to refusal
715/735 AL Top Coat*	23 mils wet (18 mils dry) - 70 sf/ gal	23 mils wet (18 mils dry) - 70 sf/ gal	23 mils wet (18 mils dry) - 70 sf/ gal
Total Thickness	61 mils dry (excluding aggregate)	73 mils dry (excluding aggregate)	105 mils dry (excluding ag- gregate)
NOTE:* Top Coat is optional for all full broadcast systems.			

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.

System Guide	Heavy Vehicular Traffic - Seed & Backroll	Extra Heavy Vehicular Traffic - Seed & Backroll		
Primer	Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high mois- ture content substrates.			
710 Detail Coat	32 mils wet over properly	treated cracks and joints.		
710 Base Coat	32 mils wet (23 mils dry) - 50 sf/gal.			
22 Lo-Mod Binder I	16 mils wet (16 mils dry) - 100 sf/gal	16 mils wet (16 mils dry) - 100 sf/gal		
Aggregate I	10-20 lbs/100 sf seeded & backrolled	10-20 lbs/100 sf seeded & backrolled		
22 Lo-Mod Binder II		16 mils wet (16 mils dry) - 100 sf/gal		
Aggregate II		10-20 lbs/100 sf seeded & backrolled		
715/735 AL Top Coat	16 mils wet (12 mils dry) - 100 sf/gal	16 mils wet (12 mils dry) - 100 sf/gal		
Total Thickness	51 mils dry (excluding aggregate)	67 mils dry (excluding aggregate)		
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness				

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.



## System Guides Sikalastic 710 Lo-VOC/22 Lo-Mod Traffic System – Single Component

System Guide	Standard Vehicular Traffic - Full Broadcast	Heavy Vehicular Traffic - Full Broadcast	Extra Heavy Vehicular Traffic - Full Broadcast
Primer	Sikalastic FTP Lo-VOC - 300 sf/gal. Consult Sika for other primer options for recover and high moisture content substrates.		
710 Base Lo-VOC Detail Coat	26 mils	wet over properly treated cracks and	d joints.
710 Base Lo-VOC Base Coat		26 mils wet (23 mils dry) - 61 sf/gal.	
22 Lo-Mod Binder I	20 mils wet (20 mils dry) - 70 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal
Aggregate I	1.25 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal
22 Lo-Mod Binder II			32 mils wet (32 mils dry) - 50 sf/gal
Aggregate II			1.5 lbs/sf broadcasted to refusal
715 Top Lo-VOC /736 AL Lo-VOC Top Coat I*	21/23 mils wet (18 mils dry) - 76/70 sf/gal	21/23 mils wet (18 mils dry) - 76/70 sf/gal	21/23 mils wet (18 mils dry) - 76/70 sf/gal
Total Thickness	61 mils dry (excluding aggregate)	73 mils dry (excluding aggregate)	105 mils dry (excluding ag- gregate)
NOTE: *Top coat is optional for all full broadcast systems			
NOTE. Coverage rates provided are optimal and are not guaranteed, soverage rates will vary depending on temperature			

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.

System Guide	Heavy Vehicular Traffic - Seed & Backroll	Extra Heavy Vehicular Traffic - Seed & Backroll
Primer	Sikalastic FTP Lo-VOC - 300 sf/gal. Consult Sik moisture conte	a for other primer options for recover and high ent substrates.
710 Base Lo-VOC Detail Coat	26 mils wet over properly	treated cracks and joints.
710 Base Lo-VOC Base Coat	26 mils wet (23 m	ils dry) - 61 sf/gal.
22 Lo-Mod Binder I	16 mils wet (16 mils dry) - 100 sf/gal	16 mils wet (16 mils dry) - 100 sf/gal
Aggregate I	10-20 lbs/100 sf seeded & backrolled	10-20 lbs/100 sf seeded & backrolled
22 Lo-Mod Binder II		16 mils wet (16 mils dry) - 100 sf/gal
Aggregate II		10-20 lbs/100 sf seeded & backrolled
715 Top Lo-VOC /736 AL Lo-VOC Top Coat I	13/14 mils wet (12 mils dry) - 123/114 sf/gal	13/14 mils wet (12 mils dry) - 123/114 sf/gal
Total Thickness	51 mils dry (excluding aggregate)	67 mils dry (excluding aggregate)
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature		

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.



## System Guides Sikalastic 720/22 Lo-Mod Traffic System – Two Component

System Guide	Standard Vehicular Traffic - Full Broadcast	Heavy Vehicular Traffic - Full Broadcast	Extra Heavy Vehicular Traffic - Full Broadcast
Primer	Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high moisture content substrates.		
720 Detail Coat	23 mils	wet over properly treated cracks and	d joints.
720 Base Coat		23 mils wet (23 mils dry) - 70 sf/gal.	
22 Lo-Mod Binder I	20 mils wet (20 mils dry) - 70 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal
Aggregate I	1.25 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal
22 Lo-Mod Binder II			32 mils wet (32 mils dry) - 50 sf/gal
Aggregate II			1.5 lbs/sf broadcasted to refusal
745 AL Top Coat*	18 mils wet (18 mils dry) - 89 sf/ gal	18 mils wet (18 mils dry) - 89 sf/ gal	18 mils wet (18 mils dry) - 89 sf/ gal
Total Thickness	61 mils dry (excluding aggregate)	73 mils dry (excluding aggregate)	105 mils dry (excluding ag- gregate)
NOTE: *Top coat is optional for all full broadcast systems			
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.			

Heavy Vehicular Traffic - Seed & Extra Heavy Vehicular Traffic -System Guide Backroll Seed & Backroll Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high mois-Primer ture content substrates. 720 Detail Coat 23 mils wet over properly treated cracks and joints. 720 Base Coat 23 mils wet (23 mils dry) - 70 sf/gal. 22 Lo-Mod Binder I 16 mils wet (16 mils dry) - 100 sf/gal 16 mils wet (16 mils dry) - 100 sf/gal 10-20 lbs/100 sf seeded & backrolled Aggregate I 10-20 lbs/100 sf seeded & backrolled 16 mils wet (16 mils dry) - 100 sf/gal 22 Lo-Mod Binder II Aggregate II 10-20 lbs/100 sf seeded & backrolled 745 AL Top Coat 12 mils wet (12 mils dry) - 133 sf/gal 12 mils wet (12 mils dry) - 133 sf/gal Total Thickness 51 mils dry (excluding aggregate) 67 mils dry (excluding aggregate)

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.



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### **System Guides** Sikalastic 390/22 Lo-Mod Traffic System – Two Component

System Guide	Standard Vehicular Traffic - Full Broadcast	Heavy Vehicular Traffic - Full Broadcast	Extra Heavy Vehicular Traffic - Full Broadcast
Primer	Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high moisture content substrates.		
390 Detail Coat	30 mils	wet over properly treated cracks an	d joints.
390 Base Coat		20 mils wet (20 mils dry) - 80 sf/gal	
22 Lo-Mod Binder I	20 mils wet (20 mils dry) - 70 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal	32 mils wet (32 mils dry) - 50 sf/gal
Aggregate I	1.25 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal	1.5 lbs/sf broadcasted to refusal
22 Lo-Mod Binder II			32 mils wet (32 mils dry) - 50 sf/gal
Aggregate II			1.5 lbs/sf broadcasted to refusal
395 AL Top Coat*	18 mils wet (18 mils dry) - 89 sf/ gal	18 mils wet (18 mils dry) - 89 sf/ gal	18 mils wet (18 mils dry) - 89 sf/ gal
Total Thickness	58 mils dry (excluding aggregate)	70 mils dry (excluding aggregate)	102 mils dry (excluding ag- gregate)
NOTE: *Top coat is optional for all full broadcast systems			
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature,			

surface roughness and porosity, aggregate selection and embedment, and application technique.

System Guide	Heavy Vehicular Traffic - Seed & Backroll	Extra Heavy Vehicular Traffic - Seed & Backroll
Primer	Sikalastic FTP - 300 sf/gal. Consult Sika for other primer options for recover and high mois- ture content substrates.	
390 Detail Coat	30 mils wet over properly	treated cracks and joints.
390 Base Coat	20 mils wet (20 mils dry) - 80 sf/gal.	
22 Lo-Mod Binder I	16 mils wet (16 mils dry) - 100 sf/gal	16 mils wet (16 mils dry) - 100 sf/gal
Aggregate I	10-20 lbs/100 sf seeded & backrolled	10-20 lbs/100 sf seeded & backrolled
22 Lo-Mod Binder II		16 mils wet (16 mils dry) - 100 sf/gal
Aggregate II		10-20 lbs/100 sf seeded & backrolled
395 AL Top Coat	12 mils wet (12 mils dry) - 133 sf/gal	12 mils wet (12 mils dry) - 133 sf/gal
Total Thickness	48 mils dry (excluding aggregate)	64 mils dry (excluding aggregate)
NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness		

NOTE: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.



construction

#### **Recoat Windows**

In the event of an unforeseen rain event or delays beyond the stated recoat window referenced in each product's current PDS, observe the following.

Product	Recoat Window	Required Surface Preparation After Recoat Window is Exceeded
Sikalastic FTP	Tack-free to 48 hrs.	Heavily abrade and reprime
Sikalastic MT	Tack-free to 48 hrs.	Heavily abrade and reprime
Sikalastic 710	Tack-free to 72 hrs.	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 710 Lo-VOC	Tack-free to 48 hrs.	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 710 Lo-VOC with 710 Lo-VOC Booster	6 - 24 hrs.	Clean and solvent wipe <u>or</u> Clean and Sikalastic Recoat Primer
Sikalastic 720	Tack-free to 24 hrs.	Abrade, clean and solvent wipe <b>or</b> Abrade, clean and Sikalastic Recoat Primer
Sikalastic 390	Tack-free to 48 hrs.	Abrade, clean and solvent wipe <u>or</u> Abrade, clean and Sikalastic Recoat Primer
Sikadur 22 Lo-Mod - Seeded	Tack-free to 24 hrs.	Heavily abrade and reapply
Sikadur 22 Lo-Mod – Full Broadcast	Tack-free to 72 hrs.	Clean and power dry

Notes:

1. Heavy abrasion of epoxy-based materials is intended to achieve an open, porous surface and to remove any amine blush that may interfere with bonding.

2. Abrasion of polyurethane-based materials is intended to achieve an open, porous surface.

3. Cleaning is intended to remove dirt, debris, contaminants, and residue from mechanical surface preparation methods.

4. Recommended solvents include high quality xylene and acetone. Handling and use of all solvents must be done in accordance with the manufacturer's warnings and instructions for use.

Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means. Clean with non-sudsing detergent and water and inspect regularly for mechanical damage. Snow removal equipment must have shoes, rubber tips or small skis to prevent ruptures. The use of metal blades without protection is not recommended. Damaged areas should be repaired promptly. Remove delaminated coating back to well adhered material and reinstall patch according to procedures described above. Do not use asphalt or tar modified products. Consult a Sika representative for recommendations on top coat or wearing surface restoration.

- To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5 F (3 C) above measured dew point temperature.
  - Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter : 4% for Sikafloor FTP Primer applications; 5% with one application of Sikalastic MT Primer; 6% with two applications of Sikalastic MT Primer (see separate Sikalastic MT Primer product data sheet).
  - Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 95 F (35°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.
  - Coating materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect coverage rates.
  - Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials
    with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and
    moisture. Observe temperature storage and conditioning requirements.
  - Do not thin with solvents.
  - Use properly graded, oven dried aggregates only.
  - Minimum age of concrete must be 21-28 days, depending on curing and drying conditions.
  - Any repairs required to achieve a level surface must be performed prior to application (consult a Sika
    representative for guidance on various product solutions). Surface irregularities may reflect through the
    cured system.
  - Precautions should be taken to prevent odors and/or vapors from entering the building/structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and/or vapors into the building/structure during product application and cure.

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Removal

/Repair

Maintenance

Limitations

/Precautions



- Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is imminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.
- When applying over existing coatings compatibility and adhesion testing is recommended.
- Opening prior to final cure may result in loss of aggregate, or permanent staining and subsequent premature failure.
- Vehicle fluids and some high performance tires can stain the coating. Fluid spills should be removed promptly as the coating can in some cases be damaged from prolonged exposure.
- On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
- Unvented metal pan decks or decks containing between-slab membrane require further technical evaluation to determine substrate moisture content and priming with a moisture-tolerant primer contact Sika regarding recommendations.
- Do not subject to continuous immersion.
- Sikalastic 710, 710 Lo-VOC, 720, and Sikalastic 390 Base coats are not UV stable and must be top coated
- Base coats must be kept clean and recoated within 48 hours (710 Base, 710 Lo-VOC Base, 390 Base) or 24 hours (720 Base). If this recoat window is exceeded, contact Sika for recommendations.
- Sikadur 22 Lo-Mod may exhibit cracking due to excessive substrate movement and will chalk, fade, or discolor over time when exposed to UV and under certain artificial lighting conditions. Aliphatic top coats with superior color and gloss retention are available.
- Mockups to verify application methods and substrate conditions as well as desired skid resistance and aesthetics are highly recommended.

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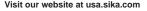
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C.P. 76920

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537



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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 hone: 514-697-2610 Fax: 514-694-2792

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## Sikalastic<sup>®</sup> FTP Primer Two-component, low odor, fast curing water-based primer

	Description
	Where to Use
	Advantages
5	
	Packaging
	Coverage
	Chemical resistance
	Cure Mechanism

Description	Sikalastic <sup>®</sup> FTP primer is a two-component, waterborne epoxy diluted with water in the field.
Where to Use	Use with Sikalastic <sup>®</sup> Traffic Systems as a primer on concrete, cementitious or plywood surfaces exposed to vehicular or pedestrian traffic. Refer to the Sikalastic <sup>®</sup> 710/715/735 AL Traffic System and Sikalastic <sup>®</sup> 720/745 Traffic System Product Data Sheets for system application instructions as well as limitations.
Advantages	Low VOC
	■ Fast dry time
	■ Low odor
	Moisture tolerant
Packaging	Sikalastic <sup>®</sup> FTP primer is packaged in pre-proportioned kits, both diluted with water in the field. 7gal. kit - two 1 gal. cans Part A and two short-filled pails Part B (1.25 gal. each). Kit yields 7 gal. after dilution with 2.5 gal. water (see mixing instructions). 1 gal. kit - short filled can of Part A (0.28 gal.) and a short filled gallon can Part B (0.35 gal.). The kit will yield one gallon of mixed product after dilution with 0.35 gal. water. (see mixing instructions).
Coverage	Approximately 300 ft. <sup>2</sup> /gal. Porous and rough substrates will increase consumption.
Chemical resistance	No Chemical Resistance Guide for this product, requires over coating with a Sika water- proofing system.
Cure Mechanism	See application info.

#### Typical Data Material and curing conditions at 75° F (24°C) and 50 % RH

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	2 years in original unopened container under proper storage conditions.
Storage:	Store dry between 40°-90°F (4°-32°C). Condition material to 65°-85°F (18°-30°C) before using.
Pot Life:	Approx. 1 hour @ 77°F (25°C) and 50% relative humidity
VOC (ASTM D2369):	< 5 g/L
Flash Point:	>200°F (93.3°C)
Recoat time:	Up to 48 hrs. @ 77°F (25°C)
Cure time:	3-4 hrs. @ 77°F (25°C) and 50% relative humidity

#### **TYPICAL PHYSICAL PROPERTIES:**

Bond Strength (ACI 503R, Appendix A): >400 psi (100% concrete failure)



How to Use	
Surface Preparation	Concrete surface must be clean, sound and dry. Remove dust, laitance, grease, cur- ing compounds, bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application. Concrete should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by shot blasting to a minimum of (CSP 3-4 as per ICRI guidelines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. The compressive strength of the concrete substrate should be at least 3500 psi at 28 days and at least 250 psi in tension at the time of application of Sikalastic <sup>®</sup> FTP primer.
Mixing	<ul> <li>7 gal. kit: It is important to remember that this coating has a limited pot life of approximately 1 hour at 77°F (25°C) and 50% relative humidity. Do not use beyond this frame regardless of whether or not the product appears to still be usable. Review that all surface preparation is complete and application equipment is in good working order before starting the mixing sequence.</li> <li>1. Premix each component. Sikalastic<sup>®</sup> FTP primer, Part B is dark olive green in color and</li> </ul>
	may appear black in the container. Sikalastic® FTP primer, Part A is light amber in color.
	<ol> <li>Add the 1 gallon of Sikalastic<sup>®</sup> FTP primer, Part A to the 1.25 gallons of Part B in the short filled Part B pail.</li> </ol>
	<ol> <li>Mix thoroughly with a low speed (300 - 500 rpm) drill with Jiffy paddle for a minimum of 3 minutes. The mixture will appear as a uniform light olive green color.</li> </ol>
	4. Slowly add 1.25 gallons of potable water to the mixture under agitation.
	5. Mix for a minimum of 2 additional minutes until the mixture is fully dispersed. Fully dispersed material will appear as light yellow to white in color.
	<b>1 gal. kit:</b> It is important to remember that this coating has a limited pot life of approximately 1 hour at 77°F (25°C) and 50% relative humidity. Do not use beyond this frame regardless of whether or not the product appears to still be usable. Review that all surface preparation is complete and application equipment is in good working order before starting the mixing sequence.
	1. Premix each component. Sikalastic <sup>®</sup> FTP primer, Part B is dark olive green in color and may appear black in the container. Sikalastic <sup>®</sup> FTP primer, Part A is light amber in color.
	<ol> <li>Add the 0.28 gallons of Sikalastic<sup>®</sup> FTP primer, Part A to the 0.35 gallons of Part B in the short filled Part B can.</li> </ol>
	<ol> <li>Mix thoroughly with a low speed (300 - 500 rpm) drill with Jiffy paddle for a minimum of 3 minutes. The mixture will appear as a uniform light olive green color.</li> </ol>
	4. Slowly add 0.35 gallons of potable water to fill the gallon can under agitation.
	<ol> <li>Mix for a minimum of 2 additional minutes until the mixture is fully dispersed. Fully dispersed material will appear as light yellow to white in color.</li> </ol>
	<b>NOTE:</b> The order that the FTP components are mixed is critical to the performance of this product. Failure to mix properly may result in an incomplete cure, despite a dry appearance.
Application	Apply with flat squeegee or roller at the recommended rate. Allow for sufficient wetting of the slab and backroll, utilizing a ¼" or %" nap roller to eliminate puddles on the surface of the slab. Minimize the overlap from batch to batch or bead-to-bead applications while achieving complete slab coverage, as these areas of overlap may not bond.
Removal	Remove wet primer with MEK, xylene, or oxygenated solvents. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use.



Over Painting	Sikalastic <sup>®</sup> FTP primer has a recoat window of up to 48 hours. Do not apply a secon coat of Sikalastic <sup>®</sup> FTP primer, as it will not properly bond. There is no need for additiona mechanical or chemical preparation of the Sikalastic <sup>®</sup> FTP primer prior to the installatio of the topcoat, if recoated with in the recoat window, and the Sikalastic <sup>®</sup> FTP primer ha not been exposed to foot or vehicular traffic or similar. If the recoat window is missed (4 hours) the surface requires grinding or screening with 80 grit, followed by a broom swee and vacuum, prior to reapplication of Sikalastic <sup>®</sup> FTP primer.
Limitations	<ul> <li>Product must be protected from freezing. If frozen, discard.</li> <li>To avoid dew point conditions and prolonged cure during application, relative hurnicity must be no more than 85% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 90°F (32°C). Frequent monitoring of ambient and substrate temperatures should always be done when applying epoxy primers. Note that low temperatures will accelerate it.</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured b a Tramex CME or CMExpert type concrete moisture meter.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>The compressive strength of the concrete substrate should be at least 3500 psi at 28 day and at least 250 psi in tension at the time of application of Sikalastic<sup>®</sup> FTP Primer.</li> <li>Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>Protect freshly applied primer from freezing, dampness, condensation and water prior to top coating.</li> <li>Not intended for immersion applications, or any use where moisture can reach the underside of the primed surface.</li> <li>On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.</li> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/ structure, including but not limited to turning off and sealing air intake</li></ul>



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Fracc. Industrial Balvanera

Corregidora, Queretaro C.P. 76920

Phone: 52 442 2385800

Fax: 52 442 2250537

Visit our website at usa.sika.com

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# Sikalastic<sup>®</sup> FTP Lo-VOC Primer

Two-component high solids epoxy primer

Description	Sikalastic® FTP Lo-VOC primer is a two-component, high solids epoxy primer for use with Sikalas- tic traffic deck coatings.		
Where to Use	Use with Sikalastic® Traffic Systems as a primer on concrete, cementitious or plywood surfaces exposed to vehicular or pedestrian traffic. Refer to the Sikalastic® 710 Lo-VOC/715 Lo-VOC/736 Al Lo-VOC, the Sikalastic 710/715/735 AL, and the Sikalastic 720/745 Traffic System Data Sheets for system application instructions as well as limitations.		
Advantages	<ul> <li>Low VOC</li> <li>Fast dry time</li> <li>Low odor</li> <li>Moisture tolerant</li> </ul>		
Coverage	Approximately 300 s.f./gal. Porous and rough substrates will increase consumption.		
Packaging	3 gal. Kit: Component A: 2 US gal. (7.57 L)		
		Component B: 1 US gal. (3.78 L)	
		Components A+B: 3 US gal. (11.35 L)	
	15 gal. Kit:	Component A: 2 x 5 US gal. (2 x 18.9 L)	
		Component B: 1 x 5 US gal. (18.9 L)	
		Components A+B: 15 US gal. (56.7 L)	

#### Typical Data (Material and curing conditions at 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	1 year in original unopened container under proper storage con- ditions.
Storage Conditions	Store dry between 40° - 90°F (4°-32°C). Condition material to 65° - 85°F (18°-30°C) before using.
Color	Green transparent after mixing
Pot Life	Approx 20 - 30 minutes @ 75°F (24°C) and 50% relative humidity
Recoat Time	Up to 16 hrs. @ 75°F (24°C)
Cure Time	Approximately 4-6 hrs. @ 75°F (24°C) and 50% relative humidity
Flash Point	>200°F (93.3°C)
Shore D Hardness (7	days) ASTM D2240 70 +/- 5 Shore D
VOC Content	ASTM D2369 ≤ 90 g/L
Viscosity (approx.)	Components A + B: 600 +/- cps
Total Solids by Weigh	t ASTM D-2369 91%
Total Solids by Volum	e ASTM D-2697 90%



How to Use	
Surface Preparation	Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc. should be dressed off to achieve a level surface prior to the application. <b>Concrete</b> - Should be cleaned and prepared to achieve a laitance and contaminant-free, open textured surface by blast cleaning or equivalent mechanical means (CSP-3-4 per ICRI guidelines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. The compressive strength of the concrete sub strate should be at least 3500 psi at 28 days and at least 250 psi in tension at the time of application of Sikalastic® FTP Lo-VOC primer. <b>Plywood</b> - Should be clean and smooth, APA and exterior grade, not less than 1/2" thick, and spaced and supported accoprding to APA guidelines. Joints should be sealed with Sikaflex 2c or 1a and de tailed, and may need embedded fabric reinforcement.
Mixing	Premix Part A (blue liquid) and Part B (yellow liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds) making sure to scrape the solids from the bottom and sides of the pail. For the 3 gallon kit, pour Part B into Part A slowly and while mixing scrape the side of the container, For the 15 gallon kit, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 2 parts A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.
Application	Apply with flat squeegee or phenolic resin core roller at the recommended rate. Allow for sufficien wetting of the slab and backroll, utilizing a <sup>1</sup> / <sub>4</sub> " or <sup>3</sup> / <sub>8</sub> " nap roller to eliminate puddles on the surface of the slab.
Removal	Remove wet primer with MEK, xylene, or oxygenated solvents. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use.
Limitations	<ul> <li>To avoid dew point conditions and prolonged cure during application, relative humidity must be no more than 85% and substrate temperature must be at least 5 °F (3 °C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41 °F (5 °C); maximum is 95 °F (35 °C). Frequent monitoring of ambient and substrate temperature should always be done when applying epoxy primers. Note that low temperatures will slow down the cure, and high temperatures will accelerate it.</li> <li>Primer materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield. Material not preconditioned to at least 65°F (18°C) is likely to exhibit these characteristics.</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for exterior exposed decks with one application of Sikalastic FTP Lo-VOC Primer; 5% for interior protected decks with one application of Sikalastic FTP Lo-VOC Primer.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>The compressive strength of the concrete substrate should be at least 3500 psi at 28 days and at least 250 psi in tension at the time of application of Sikalastic FTP Lo-VOC Primer.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow</li> </ul>
	<ul> <li>sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>Protect freshly applied primer from freezing, dampness, condensation and water prior to top coating.</li> <li>Not intended for immersion applications, or any use where moisture can reach the underside of the primed surface.</li> <li>On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.</li> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/ structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may</li> </ul>
ka®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

reflect through the cured system.

- On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
- Unvented metal pan decks or decks containing between-slab membranes require further technical evaluation prior to coating with Sikalastic Traffic Systems - the use of a moisture tolerant primer such as Sikalastic MT primer is require - contact Sika regarding recommendations.
- Sikalastic FTP Lo-VOC Primer has a recoat window of 16 hours. If the recoat window is exceeded, the primed surface must be abraded (grinding or sanding), followed by a broom sweep and vacuum, prior to reapplication of Sikalastic FTP Lo-VOC Primer.
- Primer is not UV stable and must be topcoated.
- Not recommended for metal substrates.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# Sikalastic<sup>®</sup> PF Lo-VOC Primer Two-component high solids pore filling/ sealing epoxy primer

Description	Sikalastic® PF Lo-VOC primer is a two-component, high solids pore filling/sealing epoxy primer for use with Sikalastic traffic deck coatings.				
Where to Use	Use with Sikalastic® Traffic Systems as a primer on concrete, cementitious or plywood surfaces exposed to vehicular or pedestrian traffic. May also be used to prime metal flashings and penetrations. Refer to the Sikalastic® 710 Lo-VOC/715 Lo-VOC/736 AL Lo-VOC, the Sikalastic 710/715/735 AL, and the Sikalastic 720/745 AL Traffic System Data Sheets for system application instructions as well as limitations. Use with Sikalastic® 320 NS/SL - Single Conponent, bitumen modified waterproofing membrane as primer when required.				
Advantages	<ul> <li>s = Low VOC</li> <li>Fast dry time</li> <li>Low odor</li> <li>Fills and seals rough and porous substrates</li> <li>Moisture tolerant</li> </ul>				
Coverage	Approximately 200 s.f./gal. Porous and rough substrates will increase consumption.				
Packaging	2 gal. Kit: Component A: 1 US gal. (3.78 L)				
	Component B: 1 US gal. (3.78 L)				
	Components A+B: 2 US gal. (4.16 L)				
	10 gal. Kit: Component A: 5 US gal. (18.9 L)				
	Component B: 5 US gal. (18.9 L)				
	Components A+B: 10 US gal. (37.8 L)				
Typical Data (Material and curing conditions at 75°F (24°C) and 50% RH) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIN TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITION					
	Shelf life         1 year in original unopened container under proper storage con- ditions.				

ore dry between 40°- 90°F (4°- 32°C). Precondition material r at least 24 hours between 65°- 75°F (18°- 24°C).
rey after mixing
pprox 30 - 45 minutes @ 75°F (24°C) and 50% relative humidity
o to 16 hrs. @ 75°F (24°C)
pproximately 3-5 hrs. @ 75°F (24°C) and 50% relative humidity
<b>/s)</b> ASTM D2240 70 +/- 5 Shore D
ASTM D2369 ≤ 91 g/L
Components A + B: 30 +/- ps
ASTM D-2369 94%
ASTM D-2697 91%



Mixing	rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds) making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 galloc kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do not
Application	Premix Part A (black liquid) and Part B (white liquid) components separately using a low speed (400-600 rpm) mechanical mixer and Jiffy Paddle at slow speed to obtain uniform color (typically 30 seconds) making sure to scrape the solids from the bottom and sides of the pail. For both the 2 and 10 gallor kits, pour Part A into a separate mixing vessel and then pour part B into Part A. Mixing ratio is 1 part A to 1 part B. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). Use care not to allow the entrapment of air into the mixture. Do no mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field
	temperature
	Apply with flat squeegee or phenolic resin core roller at the recommended rate. Allow for sufficient wetting of the slab and backroll, utilizing a ¼" or %" nap roller to eliminate puddles on the surface of the slab.
	Remove wet primer with MEK, xylene, or oxygenated solvents. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use.
	<ul> <li>To avoid dew point conditions and prolonged cure during application, relative humidity must be no more than 85% and substrate temperature must be at least 5 °F (3 °C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41 °F (5 °C); maximum is 95 °F (35 °C). Frequent monitoring of ambient and substrate temperature should always be done when applying epoxy primers. Note that low temperatures will slow down the cure, and high temperatures will accelerate it.</li> <li>Primer materials will become more viscous at lower application temperatures and be more difficult to spread, which may affect yield. Material not preconditioned to at least 65°F (18°C) is likely to exhibit these characteristics.</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter: 4% for exterior exposed decks with one application of Sikalastic PF Lo-VOC Primer, 5% for exterior exposed decks with one application of Sikalastic PF Lo-VOC Primer, 5% for interior protected decks with one application of Sikalastic PF Lo-VOC Primer.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>The compressive strength of the concrete substrate should be at least 3500 psi at 28 days and at least 250 psi in tension at the time of application of Sikalastic PF Lo-VOC Primer.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Do not substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>Protect freshly applied primer from freezing, dampness, co</li></ul>

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- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications where chained or studded tires may be used should not be coated with Sikalastic Traffic Systems.
- Unvented metal pan decks or decks containing between-slab membranes require further technical evaluation prior to coating with Sikalastic Traffic Systems - the use of a moisture tolerant primer such as Sikalastic MT primer is required - contact Sika regarding recommendations.
- Sikalastic PF Lo-VOC Primer has a recoat window of 16 hours. If the recoat window is exceeded, the primed surface must be abraded (grinding or sanding), followed by a broom sweep and vacuum, prior to reapplication of Sikalastic PF Lo-VOC Primer.
- Primer is not UV stable and must be topcoated.

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C.P. 76920

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 hone: 514-697-2610 Fax: 514-694-2792

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# Sikalastic<sup>®</sup> MT Primer

Moisture Tolerant Primer

re content of the deck is ≥ 4% and exceeds limitations of standard primer requirements kalastic <sup>®</sup> traffic coating system data sheets). Sikalastic MT Primer is also intended as a for SikaLevel underlayments and patching products when the moisture content of the ≥ 4%. Sikalastic <sup>®</sup> MT Primer is required where a moisture content between ≥ 4 and ≤ 6% (pbw – part by weight) is measured on a concrete substrate with Tramex <sup>®</sup> CME or pert type concrete moisture meter. Also required for non-vented concrete/steel pan site decks and split-slab applications with encapsulated waterproofing. If moisture t exceeds 6% mass, use Sikafloor <sup>®</sup> 81 EpoCem as a pre-priming surface treatment. Illent penetration and adhesion. ture tolerant. Tensile Modulus. er Tensile Elongation. VOC. cal Cure 100 ft.²/gal. Note: Surface texture and porosity can affect coverage rate. nent A: 3 US gal. (11.3 L); Component B: 1.5 US gal. (5.7 L); Components A+B: 4.5 US. gal. (17 L) <b>Data</b> NY DIFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, RE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 2 years in original unopened container under proper storage conditions. dry between 40°- 90°F (4°- 32°C) Precondition material for at least 24 hours between 65°-			
Sikalastic® MT Primer is required where a moisture content between $\ge 4$ and $\le 6\%$ (pbw – part by weight) is measured on a concrete substrate with Tramex® CME or pert type concrete moisture meter. Also required for non-vented concrete/steel pan site decks and split-slab applications with encapsulated waterproofing. If moisture t exceeds 6% mass, use Sikafloor® 81 EpoCem as a pre-priming surface treatment. Illent penetration and adhesion. ture tolerant. Tensile Modulus. er Tensile Elongation. VOC. cal Cure t00 ft. <sup>2</sup> /gal. Note: Surface texture and porosity can affect coverage rate. nent A: 3 US gal. (11.3 L); Component B: 1.5 US gal. (5.7 L); Components A+B: 4.5 US. gal. (17 L) <b>Data</b> w DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, RE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 2 years in original unopened container under proper storage conditions. dry between 40° - 90°F (4° - 32°C) Precondition material for at least 24 hours between 65°-			
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ture tolerant. Tensile Modulus. er Tensile Elongation. VOC. cal Cure 200 ft. <sup>2</sup> /gal. Note: Surface texture and porosity can affect coverage rate. ment A: 3 US gal. (11.3 L); Component B: 1.5 US gal. (5.7 L); Components A+B: 4.5 US. gal. (17 L) <b>Data</b> AV DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, RE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. 2 years in original unopened container under proper storage conditions. dry between 40°- 90°F (4°- 32°C) Precondition material for at least 24 hours between 65°-			
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proper storage conditions.dry between 40°- 90°F (4°- 32°C)onditioningPrecondition material for at least 24 hours between 65°-			
onditioning Precondition material for at least 24 hours between 65°-			
-			
Precondition material for at least 24 hours between 65°- 75°F (18°- 24°C)			
Red transparent after mixing			
<b>160 - 200 ft</b> <sup>2</sup> / <b>per mixed US gal. (4.9 – 6.4 m</b> <sup>2</sup> / <b>L) at 8 – 10 mils (0.20 – 0.25</b> mm) wet film thickness (w.f.t.). *One coat of Sikalastic <sup>®</sup> MT is required when the concrete substrate moisture is <5% (as measured with Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter)			
*Two coats of Sikalastic <sup>®</sup> MT are required when the concrete substrate moisture falls between $\geq$ 5% and < 6% (as measured with Tramex <sup>®</sup> CME/CMExpert type concrete moisture meter). Total required thickness is 16 - 20 mils.			
Material Temperature         Time           +50°F (10°C)         ~ 50 minutes           +68°F (20°C)         ~ 25 minutes           +86°F (30°C)         ~ 15 minutes			
ecoat Times Before applying second coat of Sikalastic <sup>®</sup> MT allow:			
Ambient & Substrate Temperature Minimum Maximum			
+50°F (10°C) 24 hours 3 days			
+68°F (20°C) 8 hours 2 days +86°F (30°C) 6 hours 1 day			

E	Before apply	ving Sikalastic <sup>®</sup> 710, 720				Minimum
D	laximum	+50°F (10°C)	Amplent	Substrate 1 24 hour	-	3 days
		+68°F (20°C)		8 hours		2 days
		+86°F (30°C)		6 hours	;	1 day
C	ure Times	Ambient & Substrate	Temperature			
		+50°F (10°C) +68°F (20°C)		~ 24 hours ~ 8 hours		
		+86°F (30°C)		~ 6 hours		
F	Properties T	ested at 73°F (23°C) and	1 50 % R.H:		> 400 psi (2.7	MPa)
F	ull-off Stre	ngth ASTM D4541			(100% concre	te failure)
S	hore D Har	dness (7 days) ASTM D	2240		78 - 82	
1	OC Conten	t ASTM D2369			≤ 50 g/L	
F	ermeability	ASTM E96			9.0 g/m² (24 h	nours / +75°F)
v	Vater Absor	ption ASTM D570			0.14 g/h - m²	
					822(SP2/100)	Components A +
	/iscosity (a				Please consu	lt Sika Technical
C	Chemical Re	esistance			Services.	
How to Use						
Surface	Surfac	e must be clean, sound a				
Preparation		ng impregnations, waxes a ssed off to achieve a level				ugh spots, etc. shou
		ete - Should be cleaned		••		ontaminant-free, op
	texture	d surface by blast cleaning	g or equivalent	mechanical n	neans (CSP-3-4	per ICRI guideline
	help er	and vacuum any remainin nsure a tenacious bond be	tween the prim	er and substra	ate.	wing residual dust v
		od - Should be clean and				
		d and supported according stailed, and may need embe			ould be sealed	with Sikaflex 2c or
		- Should be thoroughly clea			rinding or blast	cleaning to near whi
	metal (	(SSPC SPC-3).	-			
Mixing		A Part A and Part B comp and Jiffy Paddle at slow s				
	to scra	pe the solids from the bott	om and sides	of the pail. Po	ur Part B into Pa	art A slowly and wh
		scrape the side of the con and uniform color is obtai				
	air into	the mixture. Do not mix m	ore material th			
Application		e) at the actual field tempe		no rate of 160	200 #2 / 110 ~	a (2.4 + 4.02.4)
Application		ete - Apply primer by 1/8" mils (0.20 – 0.25 mm) we				
		re after 20 minutes. Cover a second primer coat by s				
		mils (0.20 – 0.25 mm) we				
		t primer coat is tack free,				
	be coa	g roller into mixing containe ted and then spread with se	queegee and b	ack roll. Ensu	re that the secor	nd coating is pore-fr
	-	nhole-free and provides un				
		od - Apply primer by 1/8" s s (0.20 – 0.25 mm) wet film				
		ry depending on the poros				
		container. Pour a bead of pread with squeegee and b		form of a ribb	on on the subst	rate to be coated a
	-	<ul> <li>Apply primer by brush or</li> </ul>		o core roller at	the rate of 225	- 275 ft² / US gal (5
		$n^2$ /L) at 6 – 7 mils (0.15 –				
	PR	IOR TO EACH USE OF ANY SIKA	PRODUCT, THE U	JSER MUST ALW	AYS READ AND FO	LOW THE WARNINGS
R	IN	STRUCTIONS ON THE PRODUCT'S HICH ARE AVAILABLE ONLINE AT	MOST CURRENT P	RODUCT DATA SH	IEET, PRODUCT LAB	EL AND SAFETY DATA SH
		800-933-7452. NOTHING CONTA				

DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

	<b>Aggregate</b> –Aggregate is not required for traffic coating applications if Sikalastic MT Primer is recoated within the maximum recoat window. When an extended application window is desired, or when using Sikalastic MT Primer in conjunction with SikaLevel underlayments and patching mortars, oven dried silica sand (20/30) shall be broadcast to refusal at a typical rate of 2 lbs/sf into a second coat of Sikalastic MT Primer immediately upon primer application. Remove excess sand following cure prior to underlayment/patching mortar application.
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Maximum moisture content of concrete substrate by weight when measured with a Tramex CME or CMExpert type concrete moisture meter : 5% with one application of Sikalastic<sup>®</sup> MT primer; 6% with two applications of Sikalastic<sup>®</sup> MT primer; 6% with two applications of Sikalastic<sup>®</sup> MT primer; 6% with two applications of Sikalastic<sup>®</sup> MT primer; 6% with two applications of Sikalastic<sup>®</sup> MT primer; 6% with two applications of Sikalastic<sup>®</sup> MT primer; 10°C); is likely to exhibit these characteristics.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 50° F (10°C); maximum is 85°F (30°C). Frequent monitoring of ambient and substrate temperatures will allow down the cure, and high temperatures will accelerate it.</li> <li>Do not store materials outdoors exposed to sunlight for prolonged periods.</li> <li>Do not thin with solvents.</li> <li>Minimum age of concrete must be 21-28 days, depending on curing and drying conditions. The compressive strength of the concrete substrate should be at least 3500 psi at 28 days and at least 250 psi in tension at the time of application of Sikalastic<sup>®</sup> MT Primer.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface.</li> <li>Do not subject to continuous immersion.</li> <li>On grade, lightweight concrete, asphalt pavement, or insulated split slab applications, or applications. Traffic Systems.</li> <li>Unvented metal pan decks or decks contat</li></ul>





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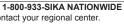
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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



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# Sikalastic<sup>®</sup> Recoat Primer

Two-Component, High Solids, Aromatic Polyurethane Primer

Description	Sikalastic Recoat Primer is a two component, high solids, liquid applied primer. Optional: Sikalastic ACL Accelerator (see separate data sheet).
Where to Use	<ul> <li>Partially completed new urethane coating systems</li> <li>Recover of existing urethane coating systems</li> <li>Repair of existing urethane coating systems</li> </ul>
Advantages	<ul> <li>High Solids</li> <li>Fast Re-Coat Time</li> <li>Low Odor</li> <li>Low Viscosity</li> </ul>
Coverage	300 sf/gal.
Cure Mechanism	Chemical Cure

# Typical Data (Material and curing conditions @ 74°F (22°C) and 40% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	1 year in original, unopened containers.
Storage:	Store dry at 60-95 °F (15-35 °C).
Product Conditioning:	Condition material to 65-85 °F (18-30 °C) before
using.	
Color:	Green Gray
Coverage Rate:	300 sf per gal.
Total Weight Solids (ASTM D-2697):	97.8%
Total Volume Solids (ASTM D-2697):	97.7%
VOC Content (ASTM D-2369-81):	100 g/l
Dry Film Thickness per Coat:	5 +/- 1 mils
Viscosity - Parts A & B Combined:	500 +/- 100 cps
Specific Gravity:	Part A - 1.22
	Part B - 0.98
Sikalastic Recoat Primer without Sikal	
Min. Application Temp.:	40°F, and at least 3°F above the dew point
Typical Pot Life:	45 minutes @ 40°F (4°C), 50% R.H.
	25 minutes @ 75°F (24°C), 50% R.H.
	20 minutes @ 90°F (32°C), 50% R.H.
Min.Time to Recoat:	12 hours @ 40°F (4°C), 50% R.H.
	3 hours @ 75°F (24°C), 50% R.H.
	3 hours @ 90°F (32°C), 50% R.H.
Max.Time to Recoat:	12 hours @ 75°F (24°C), 50% R.H.
Sikalastia Pasast Brimar with Sikalast	in 700 ACL Annalorator
Sikalastic Recoat Primer with Sikalasti Min. Application Temp.:	40°F, and at least 3°F above the dew point
Typical Pot Life:	25 minutes @ 40°F (4°C), 50% R.H.
	15 minutes @ 75°F (24°C), 50% R.H.
	10 minutes @ 90°F (32°C), 50% R.H.
Min.Time to Recoat:	8 hours @ 40°F (4°C), 50% R.H.
	80 minutes @ 75°F (24°C), 50% R.H.
	40 minutes @ 90°F (32°C), 50% R.H.
Max.Time to Recoat:	6 hours @ 75°F (24°C), 50% R.H.
Wax. Time to Recoal.	0 Houis @ /3 Γ (24 C), 30% Κ.Π.



Packaging	10 gal. Kit, Comp. A-5 gal., Comp. B-5 gal.
How to Use Surface Preparation	Existing coating surface must be clean, dry and sound with an open texture. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes, and any other contaminants. All loose and flaking coating, projections, rough spots, etc. should be dressed off to achieve a well-bonded, level surface prior to the application. Mechanically abrade the existing coating as required to obtain an open, textured surface profile.
Mixing	Premix Part A and Part B components using a mechanical mixer (Jiffy) at slow speed to obtain uniform color, making sure to scrape the solids from the bottom and sides of the pail. Pour part B into Part A slowly and while mixing scrape the side of the container, Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). When mixing use care not to entrap air into the mixture.
	Sikalastic Recoat Primer can be applied with or without Sikalastic 700 ACL as an accelerator. In the event that Sikalastic 700 ACL is used, add two quarts Sikalastic 700 ACL into 10 gallons of mixed primer. Mix the combined material thoroughly until a homogenous mixture and uniform color is obtained (typically 3 minutes). When mixing use care not to entrap air into the mixture
Application	Apply at the recommended coverage rate, typically 1 gallon per 300 sf, using a phenolic resin core roller. Coverage rate will depend on surface roughness and porosity. Reference Typical Data section for curing and recoat guidelines.
Removal	Remove liquid primer immediately with dry cloth. Once cured, primer can only be removed by mechanical means.
Over Painting	Sikalastic Recoat Primer without Sikalastic 700 ACL should be recoated within 12 hours once tack free. Sikalastic Recoat Primer with Sikalastic 700 ACL should be recoated within 6 hours once tack free.
Limitations	<ul> <li>To avoid dew point conditions during application relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperature.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 40°F (4°C); maximum is 90 F. Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane coatings. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Do not store materials outdoors exposed to sunlight for prolonged periods.</li> <li>Do not store materials outdoors exposed to sunlight for vapors from entering the building/ structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and for vapors into the building/structure during product application and cure.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Do not proceed if rain is eminent within 8-12 hours of application. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> <li>When applying over existing coatings compatibility and adhesion testing is recommended.</li> <li>Do not subject to continuous immersion.</li> <li>Sikalastic Recoat primer must be kept clean and overcoated within 12 hours, or within 6 hours if Sikalastic ACL accelerator is used. If this overcoat window is exceeded, contact Sika for recommendations.</li> </ul>





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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on The current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

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Product Data Sheet Edition 6.29.2016 Sikalastic 601 BC and Sikalastic 621 TC Roofing and Waterproofing System



# Sikalastic<sup>®</sup> 601 BC (US) / 621 TC (US) Roofing and Waterproofing System

Liquid-applied single component fully reinforced system with fiberglass or polyester reinforcement

ription	single component, moisture-triggered	Sikalastic 601 BC (US) and 621 TC (US) roofing and waterproofing systems combine cold applied, aliphatic single component, moisture-triggered polyurethane resins with fiberglass mat or polyester fleece reinforcement to create a seamless membrane and flashing system. System components are:						
		Sika or Sikalastic Primer - Select primer per substrate material in accordance with Priming Guide Sikalastic 601 BC (US) - Base layer resin used for RoofPro 10 and 15 year systems with Reemat fiberglass reinforcement						
	Sikalastic 621 TC (US) - Top layer resin used for RoofPro 10 and 15 year systems with Ree reinforcement. Resin used for all other systems with both Reemat fiberglass and polyester flee Sikalastic Reemat Premium - Chopped strand fiberglass mat Sika Fleece 120, 140, 170 - Non-woven, needle-punched polyester fleece in various weight							
re to Use	Sikalastic RoofPro systems, includin systems for both new construction a	nd refurbishment			nd Vegetated			
<ul> <li>Ideal for roofs displaying complex details and geometry or when accessibility is limited</li> <li>Effective and cost efficient life cycle extension of existing roofs</li> <li>Highly reflective Sikalastic 621 TC (US) in White (RAL 9016) suitable for cool roofs and solar semblies.</li> <li>Suitable for use for applications such as balconies, terraces, walkways, plazas, and similar applications such as balconies.</li> </ul>								
	exposed to foot traffic when prov	nded with a supplet	iental aggregateu o	i liake surfacility.				
	Typical Data (Material and cur							
	RESULTS MAY DIFFER BASED UPON STA TEMPERATURE, APPLICATION METHODS							
	Shelf Life		ikalastic 621 TC and 9					
			from date of production if stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between 40 -77° F					
	Storage	Store dry at 35	Store dry at 35-77°F (2-25°C) Condition material to 50-77°F (10-25°C) before using Single component, moisture-triggered, aliphatic polyurethane					
	Product Conditioning Chemical Base							
	Density (all values at +23 degrees C)	Density (all values at +23 degrees C)						
	601 BC (US) 621 TC (US)		11.35 lbs/gal (1.36 lg/l) 12.0 lbs/gal (1.44 kg/l)					
	Solids Content	Solids Content						
	601 BC (US) 621 TC (US)		me / 84.3 % by weigh	t				
	Flash Point							
	601 BC (US)         138°F (59°C)           621 TC (US)         144°F (62°C)							
	VOC 601 BC (US) 212 g/L							
	621 TC (US) 183 g/L							
	Service Temperature -22 to 176°F (-30 - 80°C) intermittent 621 TC (US) White (RAL 9016)							
	Solar Reflectance (Initial) 85.1% (ASTM C1549)							
	SRI (Solar Reflectance Index - Initial Thermal Emittance	I) 107 (ASTM E <sup>-</sup> 0.85 (ASTM C						
	Physical Properties – Typical Values	ASTM Test Method	RoofPro 20	RoofPro 20				
	Reinforcement		Reemat Premium	Sika Fleece 140				
	Breaking Strength, psi	D751 Proc. B	1030	900				
	Elongation to Break, %	D751	21	82				
	Tear Strength, Ibf/in	D624	300	200				
	Static Puncture Resistance	D5602	>55 lbf	>55 lbf				



Advantages	<ul> <li>Proven technology with over 25 year track record</li> <li>Single component - no mixing and ready to use</li> <li>Fully reinforced with highly conformable Sika Reemat or Sika Fleece</li> <li>Moisture triggered chemistry that is rapidly weatherproof after application</li> <li>Highly elastic and crack bridging</li> <li>Seamless and fully adhered</li> <li>Vapor permeable</li> <li>UV resistant and non-yellowing</li> <li>Abrasion and chemical resistant</li> <li>Adheres to most common construction materials when suitable primer is used.</li> </ul>
Approvals	<ul> <li>FM Approval Standard 4470 for Class 1 Roof Covers</li> <li>ASTM E-108-00 Spread of Flame meets Class A at a slope of 1 in 12</li> <li>Simulated wind uplift pull testing meets up to Class 1-990</li> <li>Simulated hail damage testing meets rating of SH - Severe Hail</li> </ul>
	Miami-Dade County NOA for Roof Systems over Concrete and Steel Decks
	USGBC LEED rating: Conforms to LEED SS Credit 7.2 for Heat Island Effect - Roof with SRI >/=78
	Energy Star approval for Sikalastic 621 TC (US) White (RAL 9016)
	Meets ASTM D7311-07: Standard Specification for Liquid-Applied, Single-Pack, Moisture-Triggered, Aliphatic
	Polyurethane Roofing Membrane.
Coverage	See Application below
Cure Mechanism	Moisture-triggered
Chemical Resistance	Strong resistance to a wide range of reagents, including paraffin, petrol, fuel oil, white spirit, acid rain, detergents and moderate solutions of acids and alkalis. Some low molecular weight alcohols can soften the material. Contact Technical Service for specific recommendations. Salt spray to ASTM B117 (1000 hours continuous exposure) and prohesion testing to ASTM G85-94: Annex A5 (1000 hours cyclic exposure)
Packaging	5 gal. pails
Colors	601 BC (US)Oxide red621 TC (US)White (RAL 9016), Pearl Gray, Steel Gray, Mushroom, Copper Green; custom colors available with minimum order
How to Use	
Surface Preparation	See Application below
Application	Substrate Evaluation
	Concrete and cementitious substrates New concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compressive strength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). time. Moist or sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere with the bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer tested. Concrete must be suitably finished, preferably by wood float or steel pan. A power float finish is acceptable where the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be uniform and free from defects such as laitance, voids or honeycombing.
	<u>Gypsum and Cement based sheathing</u> Sheathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, damaged, or contaminated boards shall be removed and replaced.
	Brick and stone Mortar joints must be sound and preferably flush pointed.
	Asphalt Asphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must be carefully assessed for moisture and/or air entrapment, grade and surface finish.
	Bituminous felt Ensure that bituminous felt is firmly adhered or mechanically fixed to the substrate. Bituminous felt shall not contain badly degraded areas.
	Bituminous coatings Bituminous coatings shall not have sticky or mobile surfaces, volatile mastic coatings, or old coal tar coatings.
	<u>Metals</u> Metals must be in sound condition.
	DR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN IRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DAT ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DI TMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATIO

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## Wooden substrates

Plywood and timber based roof decks must be in good condition, firmly adhered and mechanically fixed. All plywood should be identified as conforming to PS 1 for construction and industrial plywood by grade, APA (American Plywood Association) trademark, or equivalent. For maximum smoothness, EXT Type APA, Grade A-C should be used, and the "A" side should be positioned to receive the Sikalastic resin.

Plywood decks to receive resin directly shall be at least 1/2 inch thick and attached and supported according to APA guidelines, using only non-rusting screw, spiral or coated nail type fasteners. A good practice would be to recess or counter sink fasteners 1/8 to 1/4 inch and fill with Sikaflex sealant. Suitable edge support to prevent differential deflection between panels shall be provided. Panel edges shall be tongue and groove or supported on solid blocking. Space panels 1/8 to 3/16 inch at panel ends.

## Paints and coatings

Ensure the existing material is sound and firmly adhered.

#### Existing Sikalastic RoofPro System

The existing Sikalastic RoofPro System shall be soundly adhered to the substrate.

#### **Surface Preparation**

# Concrete and cementitious substrates

Cementitious or mineral based substrates must be prepared mechanically using abrasive blast cleaning or scarifying equipment to remove cement laitance and to achieve an open textured surface (CSP 3-5 per ICRI guidelines). Loose friable material and weak concrete must be completely removed and surface defects such as blowholes and voids must be fully exposed. The amount of embedment coat required may increase over rough or highly porous surfaces.

Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out. Consult Sika for product recommendations based on project requirements. High spots must be removed by grinding or similar method.

Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in liquid applied materials. The concrete must be carefully assessed for moisture content, air entrapment, and surface finish prior to any roofing/waterproofing work. Particular requirements for priming must also be considered. Installing the primer and membrane either when the concrete temperature is falling or stable can reduce outgassing. It is generally beneficial, therefore, to apply the primer and embedment coat in the late afternoon or evening.

#### Gypsum and Cement based sheathing

Sheathing boards shall be clean, dry and dust free. Secure loose boards if in sound condition. Damaged or contaminated boards shall be removed and replaced.

#### Brick and stone

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required.

#### **Asphalt**

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. All major cracks should be sealed to allow continuity of the Sikalastic RoofPro system.

#### **Bituminous felt**

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. Treat blisters by star cutting and removing any underlying water. Allow to dry and re-adhere using suitable adhesive.

# Bituminous coatings

Remove any loose or degraded coatings.

#### <u>Metals</u>

Ferrous metals should be thoroughly cleaned by grinding or blast cleaning prior to priming (SSPC-SP3 to near-white metal) .

Non-ferrous metals are prepared by removing any deposits of dust and oxidation and abrading to bright metal. Wire brushing can be used for soft metal such as lead. The surface must be clean and free from grease which, if present, must be removed with a solvent wipe or wash with detergent, rinse and dry.

#### Wooden substrates

Timber and timber based roof decks require additional reinforcement such as the installation of plywood, approved insulation or cover board. Small timber protrusions and suitable decks may be treated directly, provided that the timber is of exterior quality, e.g. plywood. Fill joints flush with Sikaflex sealant.



# Paints/Coatings

Remove any loose or degraded coatings. Ensure the surface is clean and free from grease.

# Sikaplan<sup>®</sup>/Sarnafil<sup>®</sup> membranes

Clean membranes with Sarna Cleaner (PVC membranes) and Sarnafil® T Clean (TPO membranes) prior to application of primer.

# Existing Sikalastic RoofPro Systems

Clean the membrane using a water jet at approximately 140bar (2000 psi) and biodegradeable non-sudsing detergent with clean water rinse. Allow to dry.

## Priming

Refer to Priming Guide to select primer for properly evaluated and prepared substrate. Refer to separate primer Product Data Sheet for application methods, coverage rates, cure times and recoat windows. Always allow primer to cure thoroughly before applying detail or base resin layer.

# Sikalastic RoofPro Priming Guide

Substrate	Remark	CONCRETE PRIMER	DTE EPOXY Primer	Bonding Primer	EP PRIMER/ SEALER	Consult Sika
CONCRETE	(1)					
LIGHTWEIGHT STRUCTURAL CONCRETE	(1)					
CONCRETE, GYPSUM BASED ROOF BOARDS						
BRICK, STONE	(3)					
BITUMINOUS SUBSTRATE						
-asphalt, bituminous felts, bituminous coatings, granulated or smooth SBS & APP cap sheets	(2,3)					
SINGLE PLY ROOFING MEMBRANES						
-HYPALON, TPO, EPDM, PVC	(3)					
ROOF TILES (UNGLAZED)	(3,4)					
FIBERGLASS	(3)					
POLYURETHANE FOAM- sprayed or slab stock						
METALS						
-aluminum, galvanized, cast iron, cop- per, lead, brass, stainless steel, steel, zinc	(3)					
PRE-COATED METAL	(3)					
PAINTS						
- paints & coatings	(3)					
- aluminized solar reflective coatings	(3)					
WOOD - TIMBER & PLYWOOD	(5)					

(1) New cementitious substrates must be Portland base and be cured min. 14 days.

(2) The presence of volatiles may cause discoloration of Sikalastic if not properly primed.

(3) Surface evaluation and field adhesion testing.

(4) Glazed tile consult Sika.

(5) Pressure treated lumber consult Sika

# Detailing

Non-structural cracks up to 1/16 inch- Detail application not necessary. Apply embedment/base resin layer per below.

Non-structural cracks between 1/16 inch and 1/4 inch- Rout and seal with Sikaflex sealant. Apply 40-45 mil resin layer embedded with 3 inch Sika Flexitape Heavy centered over crack. Apply embedment/base resin layer per below.



<u>Cracks and joints between 1/4 inch and 1 inch-</u> Rout and seal with Sikaflex sealant. Apply bond breaker tape sufficient to span width of crack or joint followed by 40-45 mil resin layer embedded with 6 inch Sika Flexitape Heavy centered over crack or joint. Apply embedment/base resin layer by terminating Sika Reemat at edges of crack or joint overlapping Sika Flexitape Heavy a minimum of 2 inch on both sides.

Joints greater than 1 inch- Treat as expansion joint. Consult Sika for recommendations.

<u>Metal seams and plywood/coverboard joints-</u> Apply 40-45 mil resin layer embedded with 3 or 6 inch Sika Flexitape Heavy centered over seam. Apply embedment resin layer per below.

Transitions between dissimilar materials- Apply 40-45 mil resin layer embedded with Sika Flexitape Heavy centered over edge. Apply embedment resin layer per below.

#### Membrane

# Embedment/Base Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply either Sikalastic 601 BC or Sikalastic 621 TC at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should be backrolled prior to embedding Sika Reemat. Place Sika Reemat in wet base resin layer overlapping seams a minimum of 2 inches (place frayed edge over cut edge of roll) and apply wet roller to topside to saturate completely. After approximately 5 minutes the binder will begin to dissolve allowing the fiber strands to conform to irregular surfaces. Do not over work once the fibers have conformed to the substrate. Allow to cure 12 hours at 70 degrees F and 50 % RH or until tack free before top resin layer. Keep clean and dry and apply top resin layer within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

## Top Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic 621 TC at the coverage rate in the RoofPro Systems Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should also be backrolled. In the case of RoofPro 25 allow the first top resin layer to cure 12 hours at 70 degrees F and 50% RH or until tack free before applying second top resin layer. On top of the complete RoofPro system additional resin layers may be applied with aggregate for slip resistance - consult Sika for recommendations. Keep clean and dry and apply additional resin layers within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

Sikalastic RoofPro System Guide							
	RoofPro Metal	RoofPro 10	RoofPro 15	RoofPro 20	RoofPro 25		
Substrates	Qualifying Metals	Concrete or cementiti	ous, metals, wood, single	e-ply or bituminous, spra	ay foam, stone or tile		
Primer		Required -	see Substrate Priming	l Guide			
Detailing	Sika Flexitape H	Sika Flexitape Heavy centered over seams, transitions and properly treated cracks and joints					
Reinforcement	Local with Sika Flexitape	Sika Reemat Standard	d Sika Reemat Premium embedded in base over entire surface				
601 BC (US)*		35 mils wet - 45 sf/gal.	45 mils wet - 35 sf/gal.				
621 TC (US)	20 mils wet - 80 sf/gal.	30 mils wet - 53 sf/gal.	30 mils wet - 53 sf/gal.	45 mils wet - 35 sf/gal.	45 mils wet - 35 sf/gal.		
621 TC (US)	20 mils wet - 80 sf/gal.			30 mils wet - 53 sf/gal.	30 mils wet - 53 sf/gal.		
621 TC (US)					30 mils wet - 53 sf/gal.		
Total Film Thickness	32 mils dry	52 mils dry	59 mils dry	61 mils dry	84 mils dry		
* May be substituted with Sikalastic 621 TC (US)							

#### Wet on Wet Application with Sika Fleece Reinforcement

Mixing not required. To primed substrate apply two-thirds of the Sikalastic 621 TC specified in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Immediately place specified Sika Fleece into wet resin overlapping seams a minimum of 3" along the edge and 6" end-to-end. Apply wet roller to topside with light pressure to saturate fleece from bottom and ensure air pockets are completely removed. Immediately apply all of remaining one-third of Sikalastic 621 TC resin specified in the RoofPro System Guide to ensure even and complete fleece saturation from topside and uniform texture.

Sikalastic RoofPro System Guide with Sika Fleece						
	RoofPro 15	RoofPro 20 RoofPro 25				
Substrates	Concrete or cementitious, metals, wood, single-ply or bituminous, spray foam, stone or tile					
Primer	Required - see Substrate Priming Guide					
Detailing	Sika Flexitape Heavy centered over seams, transitions and properly treated cracks and joints					
Reinforcement	Sika Fleece 120 (US)	Sika Fleece 140 (US)	Sika Fleece 170 (US)			
621 TC (US)	70 mils wet - 23 sf/gal.	80 mils wet - 20 sf/gal.	100 mils wet - 16 sf/gal.			
Total film Thickness	57 mils dry 65 mils dry 81 mils dry					
			EOLLOW THE WARNINGS AND			

# Aggregated or Flake Surfacing

Supplemental aggregate and flake surfacing is required for all applications that will experience direct foot traffic such as balconies, terraces, walkways, and plazas, and is recommended for areas that experience maintenance foot traffic. Supplemental aggregate surfacing is applied in a supplemental resin layer after the Sikalastic membrane has been installed and is not applied into the roofing/waterproofing membrane itself.

# Seed and Back Roll Option

The Seed and Backroll option is primarily intended for use for maintenance traffic-type applications where enhanced slip resistance is required.

Apply Sikalastic 621 TC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet seed with kiln dried, iron free aggregate. Back roll the surface to encapsulate the aggregate in the Sikalastic resin.

# Full Broadcast and Seal Option

The Full Broadcast and Seal option is intended for use for applications where both enhanced slip resistance and physical protection of the roofing membrane is required.

Apply Sikalastic 621 TC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with kiln dried, iron free aggregate. Remove excess aggregate after cure. Seal with an additional coat of Sikalastic resin.

# **Decorative Quartz and Decorative Flake Options**

The Decorative Quartz and Decorative Flake options are intended for use for applications where enhanced slip resistance, physical protection of the roofing membrane, and a decorative element is required.

Apply Sikalastic 621 TC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with colored quartz aggregate or synthetic flakes. Remove excess aggregate/flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

Decorative flakes can also be seeded at less than full broadcast quantities. Remove excess aggregate/ flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

# Aggregate Selection

Use clean, rounded or semi-angular, oven dried quartz sand with a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. The following size gradations are recommended:

- 16-30 or 20-40 mesh for pedestrian traffic systems
- Sika DecoQuartz Blends or equivalent for Decorative Quartz systems

# **Flake Selection**

Use virgin vinyl flakes, supplied in pre-packaged bags and free from impurities. The following is recommended:

Sika DecoFlake Blends or equivalent for Decorative Flake systems

Tooling & Finishing	See Above
Removal	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.
Over Painting	See Above
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 36°F (2°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane resins. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter meter.</li> <li>Minimum age of concrete must be 28 days depending on curing and drying conditions.</li> <li>Do not thin with solvents.</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D 4263 (Polyethylene sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding prob-</li> </ul>
	<ul> <li>I on substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If ap-</li> </ul>
INST SHE PAR TO F	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND IRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA ET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE- ITMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR- IT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

plied during rising temperature pinholing or blistering may occur.

- Use sunglasses with UV filter when applying highly reflective Sikalastic 621 TC White (RAL 9016).
- Do not use for indoor applications.
- Precautions should be taken to prevent odors and/or vapors from entering the building/structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and/or vapors into the building/structure during product application and cure.
- Not recommended for direct exposure to heavy or frequent foot traffic without a supplemental aggregated or flake surfacing application.
- Do not apply cementitious products, such as tile mortar directly onto Sikalastic 601 BC (US) or 621 TC (US). See Sikalastic 624 WP Product Data Sheet.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- When applying over existing coatings or membranes compatibility and adhesion testing and subsequent approval by Technical Services is required.
- Opening to traffic prior to cure may result in loss of aggregate or permanent staining and subsequent premature failure.
- On grade concrete decks should not be covered with Sikalastic RoofPro membrane systems.
- Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete deck overlays should not be covered with Sikalastic RoofPro systems without additional deck evaluation and subsequent approval by Technical Services.
- Do not subject to continuous immersion, i.e., fountains, ponds, pools, or interior of tanks.
- Not recommended for use over ceramic tile.

IPRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE PARTMENT AT 800,933,7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION ITO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE

KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera

Visit our website at usa.sika.com

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 hone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

RESPONSIBLE CARE







# Sikalastic<sup>®</sup> 624 WP Waterproofing System Liquid applied alkaline-resistant single component fully reinforced

system with fiberglass or polyester reinforcement

Description	Sikalastic 624 WP waterproofing systems moisture-triggered polyurethane resin with less membrane and flashing system. Typi overburden), but Sikalastic 624 WP is UV exposure waterproofing applications as w	fiberglass mat or po cal applications inclu resistant without prot	lyester fleece re de a separate w ection board and	inforcement to cr earing course (or	eate a seam /erlayment c	
	Sika or Sikalastic Primer - Select primer p Sikalastic 624 WP - Resin used for all syst Sikalastic Reemat Premium - Chopped st Sika Fleece 120, 140, 170 - Non-woven, r	ems with both Reema and fiberglass mat	t fiberglass and	polyester fleece re		
Where to Use	<ul> <li>Sikalastic waterproofing systems, including Sikalastic Plaza Deck/PMA and Vegetated systems for both new construction and refurbishment</li> <li>Split-slab waterproofing - between slabs</li> <li>Vegetated deck waterproofing</li> <li>Plaza decks with concrete pavers, and asphalt or concrete paving stones in a sand bed</li> <li>Waterproofing under tile in a mortar bed</li> <li>Applications involving cementitious and asphalt pavement overlays</li> <li>Waterproofing around/beneath mechanical equipment</li> </ul>					
Advantages	<ul> <li>Proven technology with over 25 year tra</li> <li>Single component - no mixing and read</li> <li>Fully reinforced with highly conformable</li> <li>Integrated flashings utilizing same resir</li> <li>Ideal for complex details and geometry</li> <li>Moisture triggered chemistry that is rap</li> <li>Highly elastic and crack bridging</li> <li>Seamless and fully adhered</li> <li>Vapor permeable</li> <li>UV resistant and non-yellowing</li> <li>Abrasion and chemical resistant</li> <li>Alkali resistant formulation</li> <li>Adheres to most common construction</li> </ul>	ick record y to use Sika Reemat or Sik and reinforcements or when accessibility dly weatherproof afte	r is limited er application	ed.		
Approvals	Meets ASTM C836 Standard Specification proofing Membrane for Use with Separate	for High Solids Con			neric Water-	
	Storage     Storage       Product Conditioning     Conditioning       Color     624 M       Chemical Base     Singl       Density (all values at +23° C)     10.8       Solids Content     70.9       Flash Point     107°       VOC     209 g       Service Temperature     -22 tc       Solar Reflectance (Initial)     86.8°       SRI (Solar Reflectance Index - Initial)     109 (	ATIONS DEPENDING UP( E CONDITIONS AND CUR this in original, unopene dry at 35-77°F (2-25°C ition material to 50-77°F VP: White, Pearl Gray; e component, moisture- bs/gal (1.3 kg/l) % by volume / 78.9 % b F (42°C) /L 176°F (-30 to 80°C) inf 6 (ASTM C1549) (White) ASTM C1371) (White)	ING CONDITIONS. ad and undamaged ). (10-25°C) before custom colors ava triggered, aliphatic y weight termittent e)	sealed containers. using for ease of a ilable with minimun polyurethane	pplication.	
	Reinforced Membrane Physical Properties - Typic Values	ASTM Test Method	WP 20	WP 20		
	Reinforcement	-	Reemat Pre- mium	Sika Fleece 140		
	Breaking Strength, psi	D751 Proc. B	2450	1110	1	
	Elongation to Break, %	D751	10	78	1	
	Tear Strength, Ibf/in	D624	430	300	1	
	Static Puncture Resistance	D5602	>55 lbf	>55 lbf	1	
	Note: Date for other WP assemblies available upo			00.01	1	
	Note. Date for other WP assemblies available upo	intequest			J	
ka®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, T INSTRUCTIONS ON THE PRODUCT'S MOST CUR SHEET WHICH ARE AVAILABLE ONLINE AT HTTF PARTMENT AT 800.933.7452 NOTHING CONTAINE TO READ AND FOLLOW THE WARNINGS AND INS DENT BODUCT LABEL	HE USER MUST ALW RENT PRODUCT DAT. ://USA.SIKA.COM/ OR D IN ANY SIKA MATER TRUCTIONS FOR EA	A SHEET, PRODU BY CALLING SII IALS RELIEVES 1 CH SIKA PRODU(	JCT LABEL AND S KA'S TECHNICAL THE USER OF THE CT AS SET FORTH	SAFETY DA SERVICE E OBLIGATIO	

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gal. pails toisture-triggered trong resistance to a wide range of reagents, including paraffin, petrol, fuel oil, white spirit, acid rain, deter ents and moderate solutions of acids and alkalis. Some low molecular weight alcohols can soften the matu al. Contact Technical Service for specific recomendations. alt spray to ASTM B117 (1000 hours continuous exposure) and prohesion testing to ASTM G85-94: Annex 5 (1000 hours cyclic exposure) ee Application Below ubstrate Evaluation concrete and cementitious substrates lew concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compress trength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). time. Mo r sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere w the bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer test iconcrete must be suitably finished, preferably by wood float or steel pan. A power float finish is acceptable why the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be unifor and free from defects such as laitance, voids or honeycombing. Hypsum and Cement based sheathing heathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, daged, or contaminated boards shall be removed and replaced. trick and stone tortar joints must be sound and preferably flush pointed. sphalt sphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must arefully assessed for moisture and/or air entrapment, grade and surface finish.
Trong resistance to a wide range of reagents, including paraffin, petrol, fuel oil, white spirit, acid rain, deter ents and moderate solutions of acids and alkalis. Some low molecular weight alcohols can soften the mate al. Contact Technical Service for specific recomendations. alt spray to ASTM B117 (1000 hours continuous exposure) and prohesion testing to ASTM G85-94: Annex 5 (1000 hours cyclic exposure) ee Application Below ubstrate Evaluation concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compress trength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). time. Mo r sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere v to bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer test concrete must be suitably finished, preferably by wood float or steel pan. Apower float finish is acceptable wh the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be unifor and free from defects such as laitance, voids or honeycombing. Typsum and Cement based sheathing heathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, da ged, or contaminated boards shall be removed and replaced. trick and stone fortar joints must be sound and preferably flush pointed. tophalt sphalt sphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must
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nsure that bituminous felt is firmly adhered or mechanically fixed to the substrate. Bituminous felt shall ontain badly degraded areas.
ituminous coatings
ituminous coatings shall not have sticky or mobile surfaces, volatile mastic coatings, or old coal tar coatin
letals
letals must be in sound condition.
Vooden substrates
lywood and timber based decks must be in good condition, firmly adhered and mechanically fixed. All plyw hould be identified as conforming to PS 1 for construction and industrial plywood by grade, APA (Ameri lywood Association) trademark, or equivalent. For maximum smoothness, EXT Type APA, Grade A-C sho e used, and the "A" side should be positioned to receive the Sikalastic resin.
lywood decks to receive resin directly shall be at least 1/2 inch thick and attached and supported accordin PA guidelines, using only non-rusting screw, spiral or coated nail type fasteners. A good practice would b ecess or counter sink fasteners 1/8 to 1/4 inch and fill with Sikaflex sealant. Suitable edge support to preve ifferential deflection between panels shall be provided. Panel edges shall be tongue and groove or suppon n solid blocking. Space panels 1/8 to 3/16 inch at panel ends.
aints and coatings
nsure the existing material is sound and firmly adhered.
xisting Sikalastic system
he existing Sikalastic system shall be soundly adhered to the substrate.
urface Preparation
oncrete and cementitious substrates
ementitious or mineral based substrates must be prepared mechanically using abrasive blast cleaning carifying equipment to remove cement laitance and to achieve an open textured surface (CSP 3-5 per l uidelines). Loose friable material and weak concrete must be completely removed and surface defects suc lowholes and voids must be fully exposed. The amount of embedment coat required may increase over ro r highly porous surfaces.

SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-

RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out. Consult Sika for product recommendations based on project requirements. High spots must be removed by grinding or similar method.

Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in liquid applied materials. The concrete must be carefully assessed for moisture content, air entrapment, and surface finish prior to any waterproofing work. Particular requirements for priming must also be considered. Installing the primer and membrane either when the concrete temperature is falling or stable can reduce outgassing. It is generally beneficial, therefore, to apply the embedment coat in the late afternoon or evening.

# **Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free. Secure loose boards if in sound condition. Damaged or contaminated boards shall be removed and replaced.

# Brick and stone

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required.

# Asphalt

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. All major cracks should be sealed to allow continuity of the Sikalastic system.

# Bituminous felt

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. Treat blisters by star cutting and removing any underlying water. Allow to dry and re-adhere using suitable adhesive.

# Bituminous coatings

Remove any loose or degraded coatings.

# <u>Metals</u>

Ferrous metals should be thoroughly cleaned by grinding or blast cleaning prior to priming (SSPC-SP3 to nearwhite metal.)

Non-ferrous metals are prepared by removing any deposits of dust and oxidation and abrading to bright metal. Wire brushing can be used for soft metal such as lead. The surface must be clean and free from grease which, if present, must be removed with a solvent wipe or wash with detergent, rinse and dry.

# Wooden substrates

Timber and timber based decks require additional reinforcement such as the installation of plywood, approved insulation or cover board. Small timber protrusions and suitable decks may be treated directly, provided that the timber is of exterior quality, e.g., exterior grade plywood, etc. Fill joints flush with Sikaflex sealant.

# Paints/Coatings

Remove any loose or degraded coatings. Ensure the surface is clean and free from grease.

# Sikaplan<sup>®</sup>/Sarnafil<sup>®</sup> membranes

Clean membranes with Sarna Cleaner (PVC membranes) and Sarnafil® T Clean (TPO membranes) prior to application of primer.

# **Existing Sikalastic Systems**

Clean the membrane using a water jet at approximately 140bar (2000 psi) and biodegradeable non-sudsing detergent with clean water rinse. Allow to dry.

# Application

# <u>Priming</u>

Refer to Priming Guide to select primer for properly evaluated and prepared substrate. Refer to separate primer Product Data Sheet for for application methods, coverage rates, cure times and recoat windows. Always allow primer to cure thoroughly before applying detail or base resin layer.

Substrate	Remark	Con- crete Primer	DTE Epoxy Primer	Bonding Primer	EP Primer/ Sealer	Consult Sika
CONCRETE	(1)					
LIGHTWEIGHT CONCRETE	(1)					
BRICK, STONE	(3)					
BITUMINOUS SUBSTRATE						
-asphalt, bitumininous felts, bituminous coatings, granulated or smooth SBS & APP cap sheets	(2,3)					



ROOF TILES (UNGLAZED)	(3,4)			
METALS				
-aluminum, galvanized, cast iron, copper, lead, brass, stainless steel, steel, zinc	(3)		<b></b>	
PRE-COATED METAL	(3)			
PAINTS				
-paints & coatings	(3)			
-aluminized solar reflective coatings	(3)			
WOOD- TIMBER & PLYWOOD	(3)			

(1) New cementitious substrates must be Portland base and be cured min. 28 days.

(2) The presence of volatiles may cause discoloration of Sikalastic if not properly primed.

(3) Surface evaluation and filed adhesion testing

(4) Glazed tile consult Sika

(5) Pressure treated lumber consult Sika

# **Detailing**

Non-structural cracks up to 1/16 inch - Detail application not necessary. Apply embedment/base resin layer per below.

**Non-structural cracks between 1/16 inch and 1/4 inch -** Rout and seal with Sikaflex sealant. Apply 40-45 mil resin layer embedded with 3 inch Sika Flexitape Heavy centered over crack. Apply embedment/base resin layer per below.

**Cracks and joints between 1/4 inch and 1 inch -** Rout and seal with Sikaflex sealant. Apply bond breaker tape sufficient to span width of crack or joint followed by 40-45 mil resin layer embedded with 6 inch Sika Flexitape Heavy centered over crack or joint. Apply embedment/base resin layer by terminating Sika Reemat at edges of crack or joint overlapping Sika Flexitape Heavy a minimum of 2 inch on both sides.

Joints greater than 1 inch - Treat as expansion joint. Consult Sika for recommendations.

**Metal seams and plywood/coverboard joints-** Apply 40-45 mil resin layer embedded with 3 or 6 inch Sika Flexitape Heavy centered over seam. Apply embedment resin layer per below.

**Transitions between dissimilar materials -** Apply 40-45 mil resin layer embedded with Sika Flexitape Heavy centered over edge. Apply embedment resin layer per below.

# Embedment/Base Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic 624 WP per WP System Guide at 45 mils with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should be backrolled prior to embedding Sika Reemat. Place Sika Reemat in wet base resin layer overlapping seams a minimum of 2 inches (place frayed edge over cut edge of roll) and apply wet roller to topside to saturate completely. After approximately 5 minutes the binder will begin to dissolve allowing the fiber strands to conform to irregular surfaces. Do not over work once the fibers have conformed to the substrate. Allow to cure 12 hours at 70°F and 50 % RH or until tack free before top resin layer. Keep clean and dry and apply top resin layer within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

# Top Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic 624 WP at the coverage rate in the AR System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should also be backrolled. In the case of RoofPro 25 allow the first top resin layer to cure 12 hours at 70°F and 50% RH or until tack free before applying second top resin layer. On top of the complete RoofPro system additional resin layers may be applied with aggregate for slip resistance - consult Sika for recommendations. Keep clean and dry and apply additional resin layers within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

S	Sikalastic RoofPro WP System Guide with Sika Reemat						
	RoofPro 15 WP RoofPro 20 WP RoofPro 25 W						
Substrate	Concrete or Cer	Concrete or Cementitious, metals, wood, single-ply pr bituminous stone					
Primer		Required - see Substrate Primi	ng Guide				
Detailing	Sika Flexitape Heavy centered over seams, transitions and properly treated cracks and joints						
Reinforcement	Sika Reemat Pre	emium embedded in base resin	layer over entire surface				
Sikalastic 624 WP Base Layer	45 mils wet - 35 sf/gal.	45 mils wet - 35 sf/gal.	45 mils wet - 35 sf/gal				
Sikalastic 624 WP Top Layer	30 mils wet - 53 sf/gal.	al. 40 mils wet - 40 sf/gal. 30 mils wet - 53 sf/gal.					
Sikalastic 624 WP Top Layer	ilastic 624 WP Top Layer 30 mils wet - 53 sf/g		30 mils wet - 53 sf/gal.				
Total Film Thickness	53 mils dry	60 mils dry	75 mils dry				



## Wet on Wet Application with Sika Fleece Reinforcement

Mixing not required. To primed substrate apply two-thirds of the Sikalastic 624 WP specified in the WP System Guide with a 1/2 inch nap phenolic resin core roller. Immediately place specified Sika Fleece into wet resin overlapping seams a minimum of 3" along the edge and 6" end-to-end. Apply wet roller to topside with light pressure to saturate fleece from bottom and ensure air pockets are completely removed. Immediately apply all of remaining one-third of Sikalastic 624 WP resin specified in the WP System Guide to ensure even and complete fleece saturation from topside and uniform texture.

Sikalastic RoofPro WP System Guide with Sika Fleece						
	RoofPro 15 WP RoofPro 20 WP RoofPro 25 WP					
Substrate	Concrete or Cen	Concrete or Cementitious, metals, wood, single-ply pr bituminous stone				
Primer	Required - see Substrate Priming Guide					
Detailing	Sika Flexitape Heavy centered over seams, transitions and properly treated cracks and joints					
Reinforcement	Sika Fleece 120 (US)	Sika Fleece 140 (US)	Sika Fleece 170 (US)			
Sikalastic 624 WP	70 mils wet - 23 sf/gal.	85 mils wet - 19 sf/gal.	105 mils wet - 15 sf/gal			
Total Film Thickness	50 mils dry 60 mils dry 75 mils dry					

# **Overburden Application**

Sikalastic 624 WP membrane may be used as the waterproofing layer under a wide range of overburden materials. Depending on the overburden type, different surfacing, drainage, and protection layers may be required.

#### **Protected Membrane Assemblies**

Install Sika 420 Drain Mat over the Sikalastic 624 WP membrane prior to the installation of the extruded polystyrene insulation layer. No aggregated membrane surfacing is required.

# **Concrete Pavers with Pedestal Supports**

Install Sika 420 Drain Mat over the Sikalastic 624 WP membrane to provide additional protection of the membrane under the pedestal supports.

# Tile Adhered in a Cementitious Thin-Set Adhesive

A full aggregate broadcast surfacing is required to provide an adhesion key for the tile adhesive. Apply a supplemental 15 wet mils of Sikalastic 624 WP resin, followed by a full broadcast of 16-30 or 12-20 kiln-dried sand to refusal, typically 40-50 lbs./100 sf. Remove all loose sand once resin has cured. Do not seal the aggregated surface.

# Tile in a Cementitious Setting Bed

Install Sika 720 Drain Mat over the Sikalastic 624 WP membrane prior to installation of the cementitious setting bed, which is typically 1-1/2"-3" in thickness, and which may be sloped to create positive drainage. Secure the Sika 720 Drain Mat to the Sikalastic 624 WP membrane as required to prevent shifting during setting bed installation by spot-adhering with Sikaflex 11 FC. Bi-level drains should be installed to provide drainage capability at the membrane level as well as drainage of the finished surface.

# Concrete/Asphalt Pavers in a Sand Setting Bed

Install Sika 420 Drain Mat over the Sikalastic 624 WP membrane prior to installation of the sand setting bed, which is typically either graded silica sand or a mix of sand and asphalt. Secure the Sika 420 Drain Mat to the Sikalastic 624 WP membrane as required to prevent shifting during setting bed installation by spot-adhering with Sikaflex 11 FC. Bi-level drains should be installed to provide drainage capability at the membrane level as well as drainage of the finished surface.

# Vegetation and Growing Media/Soil

The selection of a vegetated overburden assembly is typically project specific and specified by a qualified design professional. At a minimum, install Sika GRS Drain Mat over the Sikalastic 624 WP membrane prior to application of all other overburden components. Secure the Sika GRS Drain Mat to the Sikalastic 624 WP membrane as required to prevent shifting during vegetative overburden assembly components by spot-adhering with Sikaflex 11 FC. Bi-level drains should be installed to provide drainage capability at the membrane level as well as drainage at grade level.

# **Concrete Pavement**

Install Sika 1000 Drain Mat over the Sikalastic 624 WP membrane prior to application of the fresh concrete. Secure the Sika 1000 Drain Mat to the Sikalastic 624 WP membrane as required to prevent shifting during concrete placement by spot-adhering with Sikaflex 11 FC. Bi-level drains should be installed to provide drainage capability at the membrane level as well as drainage of the finished surface.

# Asphalt Pavement

Install Sika 1000 Drain Mat over the Sikalastic 624 WP membrane, followed by the installation of a ¼" thick asphalt protection board. Overlap the protection board at all end and side laps by 2" min. Secure the Sika 1000 Drain Mat and asphalt protection board as required to prevent shifting during asphalt pavement placement by spot-adhering with Sikaflex 11 FC. Bi-level drains should be installed to provide drainage capability at the membrane level as well as drainage of the finished surface.



Tooling and Finishing	See Above
Removal	Remove liquid resin immediately with dry cloth. Once cured, resin can be removed by mechanical means.
Over Painting	See Above
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 36°F (2°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane resins. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter meter.</li> <li>Minimum age of concrete must be 28 days depending on curing and drying conditions.</li> <li>Do not thin with solvents.</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D 4263 (Polyethylene sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a forsted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>On ont use for indoor applications without adequate ventilation during application.</li> <li>Precautions should be taken to prevent dors and/or vapors from entering the building/structure, including but not limited to turing off alsealing in intake vents or other means of ingress for dors and/or vapors into the building/structure during product application and cure.</li> <li>Not recommended for direct exposure to heavy traffic; ped</li></ul>

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Depart-ment at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537





Product Data Sheet Edition 6.29.2016 Identification no. Sikalastic®-641 Roofing System



# Sikalastic<sup>®</sup>-641 Roofing System Liquid-applied single component fully reinforced system with

fiberglass or polyester reinforcement

Description	Sikalastic-641 roofing systems com							
	resins with fiberglass mat or polye	ester fleece reinforcer	nent to create a se	amless membrane	e and flashing system			
	System components are: Sika or Sikalastic Primer - Select pr	imor por cubstrato m	storial in accordance	a with Driming Cu	.:do			
	reinforcement	Sikalastic-641 - Sag and run-resistant resin used for all systems with both Reemat fiberglass and polyester fleed						
	Sikalastic Reemat Premium - Chop	ped strand fiberglass	mat					
	Sika Fleece 120, 140, 170 - Non-we			n various weights				
re to Use	<ul> <li>Sikalastic RoofPro 10, 15, 20 a</li> </ul>				Direct, Plaza Deck/			
	PMA, and Vegetated systems	for both new construe	ction and refurbish	ment				
	Ideal for roofs displaying com			sibility is limited				
	<ul> <li>Effective and cost efficient life</li> </ul>	cycle extension of ex	isting roofs					
	<ul> <li>Highly reflective Sikalastic-641</li> </ul>	in White suitable for o	cool roofs and solar	roof assemblies.				
	Suitable for use for application		•					
	exposed to foot traffic when p		emental aggregated	d or flake surfacinន្	5.			
ntages	Proven technology with over 2							
	Single component - no mixing							
	Fully reinforced with highly co							
	<ul> <li>Moisture triggered chemistry</li> </ul>	that is rapidly weathe	erproof aπer applic	ation				
	<ul> <li>Low odor formulation</li> <li>Highly elastic and crack bridgi</li> </ul>	ng						
	<ul> <li>Seamless and fully adhered</li> </ul>	iig						
	<ul><li>Vapor permeable</li></ul>							
	<ul> <li>UV resistant and non-yellowin</li> </ul>	ισ						
	<ul> <li>Abrasion and chemical resista</li> </ul>							
	Adheres to most common cor		hen suitable prime	er is used.				
rovals	FM Approval Standard 4470 for the second s							
	<ul> <li>Meets ASTM D7311-07: Standard Specification for Liquid-Applied, Single-Pack, Moisture-Triggered, Aliphatic</li> </ul>							
	Polyurethane Roofing Membr	ane.						
erage	See Application Below							
aging	5 gal. pails							
Vlechanism	Moisture triggered							
ical Resistance	Strong resistance to a wide range of reagents, including paraffin, gasoline, fuel oil, white spirit, acid rain, deter-							
	gents and moderate solutions of acids and alkalis. Some low molecular weight alcohols can soften the material.							
	Contact Technical Service for spec	ific recommendations						
	Turinel Data (Material and au	in	5 and 50% D (1)					
	Typical Data (Material and cur RESULTS MAY DIFFER BASED UPON STATISTICAL	ARIATIONS DEPENDING UPON M	F AND 50% K.H.J IXING METHODS AND EQUIP	MENT. TEMPERATURE.				
	APPLICATION METHODS, TEST METHODS, ACTUA	L SITE CONDITIONS AND CURING	CONDITIONS.					
	Shelf Life Storage Conditions		in original, unopened an at 35-77°F (2-25°C).	id undamaged sealed co	ntainers			
	Product Conditioning			5°C) before using for eas	se of application.			
	Product Conditioning         Condition material to 50-77°F (10-25°C) before using for ease of application.           Colors         White, Pearl Gray, Steel Gray, Mushroom, Copper Green; custom colors							
	available with minimum order							
	Chemical Base Density (all values at +23 degrees C)	Single com	iponent, moisture-trigger	ed, alipnatic polyuretha	ne			
	11.9 lbs/gal (1.43 kg/l)							
	Solids Content 89.0 % by volume /92 % by weight							
	Flash Point         199°F (93°C)           VOC         100 g/L							
	voc	100 8/ 2						
	Service Temperature		°F (-30 to 80°C) intermitte					
	Solar Reflectance (Initial)		FM C1549)(Pearl Gray); 85 E1980)(Pearl Gray); 107 (/		ite)			
	SRI (Solar Reflectance Index - Initial) Thermal Emittance		/ C1371)(Pearl Gray); 0.8					
		1	1	1 1				
	Physical Properties – Typical Values	ASTM Test Method	RoofPro 20	RoofPro 20				
	Reinforcement		Reemat Premium	Sika Fleece 140				
	Breaking Strength, psi	D751 Proc. B	1030	900				
	Elongation to Break, %	D751	21	82				
	Tear Strength, Ibf/in	D624	300	200				
	Static Puncture Resistance	D5602	>55 lbf	>55 lbf				
<b>A</b>	Note: Data for other RoofPro assemblies available upon request							
	Note: Data for other RootPro assemble	s available apoil request						
	R TO EACH USE OF ANY SIKA PROD RUCTIONS ON THE PRODUCT'S MOS	DUCT, THE USER MU						



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# How to Use

Surface Preparation

Application

See Application below

# Substrate Evaluation

#### Concrete and cementitious substrates

New concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compressive strength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). time. Moist or sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere with the bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer tested. Concrete must be suitably finished, preferably by wood float or steel pan. A power float finish is acceptable where the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be uniform and free from defects such as laitance, voids or honeycombing.

# **Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, damaged, or contaminated boards shall be removed and replaced.

#### Brick and stone

Mortar joints must be sound and preferably flush pointed.

# Asphalt

Asphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must be carefully assessed for moisture and/or air entrapment, grade and surface finish.

#### **Bituminous felt**

Ensure that bituminous felt is firmly adhered or mechanically fixed to the substrate. Bituminous felt shall not contain badly degraded areas.

**Bituminous coatings** 

Bituminous coatings shall not have sticky or mobile surfaces, volatile mastic coatings, or old coal tar coatings.

#### **Metals**

Metals must be in sound condition.

## Wooden substrates

Plywood and timber based roof decks must be in good condition, firmly adhered and mechanically fixed. All plywood should be identified as conforming to PS 1 for construction and industrial plywood by grade, APA (American Plywood Association) trademark, or equivalent. For maximum smoothness, EXT Type APA, Grade A-C should be used, and the "A" side should be positioned to receive the Sikalastic resin.

Plywood decks to receive resin directly shall be at least 1/2 inch thick and attached and supported according to APA guidelines, using only non-rusting screw, spiral or coated nail type fasteners. A good practice would be to recess or counter sink fasteners 1/8 to 1/4 inch and fill with Sikaflex sealant. Suitable edge support to prevent differential deflection between panels shall be provided. Panel edges shall be tongue and groove or supported on solid blocking. Space panels 1/8 to 3/16 inch at panel ends.

#### Paints and coatings

Ensure the existing material is sound and firmly adhered.

# Existing Sikalastic RoofPro System

The existing Sikalastic RoofPro System shall be soundly adhered to the substrate.

#### Surface Preparation

## Concrete and cementitious substrates

Cementitious or mineral based substrates must be prepared mechanically using abrasive blast cleaning or scarifying equipment to remove cement laitance and to achieve an open textured surface (CSP 3-5 per ICRI guidelines). Loose friable material and weak concrete must be completely removed and surface defects such as blowholes and voids must be fully exposed. The amount of embedment coat required may increase over rough or highly porous surfaces.

Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out. Consult Sika for product recommendations based on project requirements. High spots must be removed by grinding or similar method.

Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in liquid applied materials. The concrete must be carefully assessed for moisture content, air entrapment, and surface finish prior to any roofing work. Particular requirements for priming must also be considered. Installing the primer and membrane either when the concrete temperature is falling or stable can reduce outgassing. It is generally beneficial, therefore, to apply the primer and embedment coat in the late afternoon or evening.

#### **Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free. Secure loose boards if in sound condition. Damaged or contaminated boards shall be removed and replaced.

#### Brick and stone

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required.



#### <u>Asphalt</u>

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. All major cracks should be sealed to allow continuity of the Sikalastic RoofPro system.

#### Bituminous felt

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. Treat blisters by star cutting and removing any underlying water. Allow to dry and re-adhere using suitable adhesive.

#### **Bituminous coatings**

Remove any loose or degraded coatings.

# <u>Metals</u>

Ferrous metals should be thoroughly cleaned by grinding or blast cleaning prior to priming (SSPC-SP3 to near-white metal) .

Non-ferrous metals are prepared by removing any deposits of dust and oxidation and abrading to bright metal. Wire brushing can be used for soft metal such as lead. The surface must be clean and free from grease which, if present, must be removed with a solvent wipe or wash with detergent, rinse and dry.

#### Wooden substrates

Timber and timber based roof decks require additional reinforcement such as the installation of plywood, approved insulation or cover board. Small timber protrusions and suitable decks may be treated directly, provided that the timber is of exterior quality, e.g. plywood. Fill joints flush with Sikaflex sealant.

#### Paints/Coatings

Remove any loose or degraded coatings. Ensure the surface is clean and free from grease.

#### Sikaplan®/Sarnafil® membranes

Clean membranes with Sarna Cleaner (PVC membranes) and Sarnafil® T Clean (TPO membranes) prior to application of primer.

#### Existing Sikalastic RoofPro Systems

Clean the membrane using a water jet at approximately 140bar (2000 psi) and biodegradeable non-sudsing detergent with clean water rinse. Allow to dry.

#### Application

#### Priming

Refer to Priming Guide to select primer for properly evaluated and prepared substrate. Refer to separate primer Product Data Sheet for application methods, coverage rates, cure times and recoat windows. Always allow primer to cure thoroughly before applying detail or base resin layer.

# Sikalastic RoofPro Priming Guide

Substrate	Remark	CONCRETE PRIMER	DTE EPOXY Primer	EP PRIMER/ SEALER	Consult Sika
CONCRETE	(1)				
LIGHTWEIGHT STRUCTURAL CONCRETE	(1)				
CEMENT, GYPSUM BASED ROOF BOARDS					
BRICK, STONE	(3)				
BITUMINOUS SUBSTRATE					
-asphalt, bituminous felts, bituminous coat- ings, granulated or smooth SBS & APP cap sheets	(2,3)				
SINGLE PLY ROOFING MEMBRANES					
-HYPALON, TPO, EPDM, PVC	(3)				
ROOF TILES (UNGLAZED)	(3,4)				
FIBERGLASS	(3)				
POLYURETHANE FOAM- sprayed or slab stock					
METALS					
-aluminum, galvanized, cast iron, copper, lead, brass, stainless steel, steel, zinc	(3)				
PRE-COATED METAL	(3)				
PAINTS					





- paints & coatings	(3)		
- aluminized solar reflective coatings	(3)		
WOOD - TIMBER & PLYWOOD	(5)		

(1) New cementitious substrates must be Portland base and be cured min. 14 days.

(2) The presence of volatiles may cause discoloration of Sikalastic if not properly primed.

(3) Surface evaluation and field adhesion testing.

(4) Glazed tile consult Sika.

(5) Pressure treated lumber consult Sika

# Detailing

Non-structural cracks up to 1/16 inch - Detail application not necessary. Apply embedment/base resin layer per below.

Non-structural cracks between 1/16 inch and 1/4 inch - Rout and seal with Sikaflex sealant. Apply 40-45 mil resin layer embedded with 3 inch Sika Flexitape Heavy centered over crack. Apply embedment/base resin layer per below.

**Cracks and joints between 1/4 inch and 1 inch** - Rout and seal with Sikaflex sealant. Apply bond breaker tape sufficient to span width of crack or joint followed by 40-45 mil resin layer embedded with 6 inch Sika Flexitape Heavy centered over crack or joint. Apply embedment/base resin layer by terminating Sika Reemat/Fleece at edges of crack or joint overlapping Sika Flexitape Heavy a minimum of 2 inches on both sides.

Joints greater than 1 inch - Treat as expansion joint. Consult Sika for recommendations.

**Metal seams and plywood/coverboard joints-** Apply 40-45 mil resin layer embedded with 3 or 6 inch Sika Flexitape Heavy centered over seam. Apply embedment/ base resin layer per below.

Transitions between dissimilar materials - Apply 40-45 mil resin layer embedded with Sika Flexitape Heavy centered over edge. Apply embedment/ base resin layer per below.

#### Embedment/Base Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic-641 at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should be backrolled prior to embedding Sika Reemat. Place Sika Reemat in wet base resin layer overlapping seams a minimum of 2 inches (place frayed edge over cut edge of roll) and apply wet roller to topside to saturate completely. After approximately 5 minutes the binder will begin to dissolve allowing the fiber strands to conform to irregular surfaces. Do not over work once the fibers have conformed to the substrate. Allow to cure 12 hours at 70 degrees F and 50 % RH or until tack free before top resin layer. Keep clean and dry and apply top resin layer within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

#### Top Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic-641 at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should also be backrolled. In the case of RoofPro 25 allow the first top resin layer to cure 12 hours at 70 degrees F and 50% RH or until tack free before applying second top resin layer. On top of the complete RoofPro system additional resin layers may be applied with aggregate for slip resistance - consult Sika for recommendations. Keep clean and dry and apply additional resin layers within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

Sikalastic RoofPro-641 System Guide with Sika Reemat						
	RoofPro 10 RoofPro 15 RoofPro 20 RoofPro 25					
Substrates	Concrete o	or cementitious, metals, w	oods, single-ply or bitumir	nous, stone		
Primer		Required - see Substrate Priming Guide				
Detailing	Sika Flexitape Heavy	Sika Flexitape Heavy centered over seams, transistions and properly treated cracks and joints				
Reinforcement	Sika Reemat Standard Sika Reemat Premium embedded in base resin layer over entire surface					
Sikalastic-641 Base Layer	30 mils wet - 53 sf/gal.	30 mils wet - 53 sf/gal. 50 mils wet - 32 sf/gal. 50 mils wet - 32 sf/gal. 50 mils wet - 32 sf/gal.				
Sikalastic-641 Top Layer	30 mils wet - 53 sf/gal.	30 mils wet - 53 sf/gal. 20 mils wet - 80 sf/gal. 30 mils wet - 53 sf/gal. 23 mils wet - 69 sf,				
Sikalastic-641 Top Layer	23 mils wet - 69 sf/ga					
Total Film Thickness	53 mils dry	62 mils dry	71 mils dry	85 mils dry		
Note: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, sur-				on temperature, sur-		

face roughness and porosity, aggregate selection and embedment, and application technique.

#### Wet on Wet Application with Sika Fleece Reinforcement

Mixing not required. To primed substrate apply two-thirds of the Sikalastic-641 specified in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Immediately place specified Sika Fleece into wet resin overlapping seams a minimum of 3" along the edge and 6" end-to-end. Apply wet roller to topside with light pressure to saturate fleece from bottom and ensure air pockets are completely removed. Immediately apply all of remaining one-third of Sikalastic 641 resin specified in the RoofPro System Guide to ensure even and complete fleece saturation from topside and uniform texture.



Sikalastic RoofPro 641 System Guide with Fleece							
	RoofPro 15	RoofPro 20 RoofPro 25					
Substrates	Concrete or cemer	Concrete or cementitious, metals, woods, single-ply or bituminous, stone					
Primer	R	Required - see Substrate Priming Guide					
Detailing	Sika Flexitape Heavy centere	Sika Flexitape Heavy centered over seams, transistions and properly treated cracks and joints					
Reinforcement	Sika Fleece 120 (US)	Sika Fleece 120 (US) Sika Fleece 140 (US) Sika Fleece 170 (US)					
Sikalastic 641	70 mils wet - 25 sf/gal. 80 mils wet - 20 sf/gal. 95 mils wet- 16 sf/gal.						
Total Film Thickness	62 mils dry	62 mils dry 71 mils dry 84 mils dry					

Note: Coverage rates provided are optimal and are not guaranteed - coverage rates will vary depending on temperature, surface roughness and porosity, aggregate selection and embedment, and application technique.

#### Aggregated or Flake Surfacing

Supplemental aggregate and flake surfacing is required for all applications that will experience direct foot traffic such as balconies, terraces, walkways, and plazas, and is recommended for areas that experience maintenance foot traffic. Supplemental aggregate surfacing is applied in a supplemental resin layer after the Sikalastic membrane has been installed and is not applied into the roofing/waterproofing membrane itself.

#### Seed and Back Roll Option

The Seed and Backroll option is primarily intended for use for maintenance traffic-type applications where enhanced slip resistance is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet seed with kiln dried, iron free aggregate. Back roll the surface to encapsulate the aggregate in the Sikalastic resin.

#### Full Broadcast and Seal Option

The Full Broadcast and Seal option is intended for use for applications where both enhanced slip resistance and physical protection of the roofing membrane is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with kiln dried, iron free aggregate. Remove excess aggregate after cure. Seal with an additional coat of Sikalastic resin.

#### **Decorative Quartz and Decorative Flake Options**

The Decorative Quartz and Decorative Flake options are intended for use for applications where enhanced slip resistance, physical protection of the roofing membrane, and a decorative element is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with colored quartz aggregate or synthetic flakes. Remove excess aggregate/flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

Decorative flakes can also be seeded at less than full broadcast quantities. Remove excess aggregate/flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

#### Aggregate Selection

Use clean, rounded or semi-angular, oven dried quartz sand with a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. The following size gradations are recommended:

- 16-30 or 20-40 mesh for pedestrian traffic systems
- Sika DecoQuartz Blends or equivalent for Decorative Quartz systems

#### **Flake Selection**

Use virgin vinyl flakes, supplied in pre-packaged bags and free from impurities. The following is recommended:

Tooling & Finishing	See Above
Removal	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.
Over Painting	See Above.
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 36 degrees F (2°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane resins. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter meter.</li> </ul>
	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA

- Minimum age of concrete must be 28 days depending on curing and drying conditions.
- Do not thin with solvents.
- Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.
- Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D 4263 (Polyethylene sheet method).
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.
- On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing or blistering may occur.
- Use sunglasses with UV filter when applying highly reflective Sikalastic-641 White.
- Do not use for indoor applications unless sufficient air flow and ventilation are provided to prevent odors and/or vapors from leaving the immediate work area.
- Precautions should be taken to prevent odors and/or vapors from entering the building/structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and/or vapors into the building/structure during product application and cure.
- Not recommended for direct exposure to heavy or frequent foot traffic.
- Do not apply cementitious products, such as tile mortar directly onto Sikalastic-641. See Sikalastic 624 WP Product Data Sheet.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- When applying over existing coatings or membranes compatibility and adhesion testing and subsequent ap proval by Technical Services is required.
- Opening to traffic prior to cure may result in loss of aggregate or permanent staining and subsequent premature failure.
- On grade concrete decks should not be covered with Sikalastic RoofPro membrane systems.
- Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete deck overlays should not be covered with Sikalastic RoofPro systems without additional deck evaluation and subsequent approval by Technical Services.
- Do not subject to continuous immersion, i.e., fountains, ponds, pools, or interior of tanks.
- Not recommended for use over ceramic tile.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE-PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR-RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

REEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Fax: 52 442 2250537

C.P. 76920 Phone: 52 442 2385800

Carretera Libre Celaya Km. 8.5

Visit our website at usa.sika.com

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225 Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792 1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.



**Product Data Sheet** Edition 6.29.2016 Identification no. Sikalastic 641 Lo-VOC Roofing System



# Sikalastic® 641 Lo-VOC Roofing System

Liquid applied single component fully reinforced Lo-VOC, low-odor system with fiberglass or polyester reinforcement

escription	Sikalastic 641 Lo-VOC roofing syste urethane resins with fiberglass mat				
	system. System components are:	tor polyester neece			
	Sika or Sikalastic Primer - Select primer per substrate material in accordance with Priming Guide				
	Sikalastic 641 Lo-VOC - Resin used	for all systems with	polyester fleece rein	forcement	
	Sika Reemat Premium - Chopped si				
	Sika Fleece 120, 140, 170 - Non-wo				
here to Use	<ul> <li>Sikalastic RoofPro 10, 15, 20 ar</li> </ul>		-		irect, Plaza Deck/
	PMA, and Vegetated systems f				
	Ideal for roofs displaying comp			sibility is limited	
	<ul> <li>Effective and cost efficient life</li> <li>Highly reflective Silvelectie 641</li> </ul>	,		and reafs and cala	roof accomplian
	<ul> <li>Highly reflective Sikalastic 641 I</li> <li>Suitable for use for application</li> </ul>	•	,		
	exposed to foot traffic when p			•	
vantages	<ul> <li>Proven technology with over 2</li> </ul>			a of flake suffacing	•
	<ul> <li>Single component - no mixing</li> </ul>				
	Fully reinforced with highly con		nat or Sika Fleece		
	<ul> <li>Moisture triggered chemistry t</li> </ul>			ation	
	Low odor formulation				
	<ul> <li>Highly elastic and crack bridgir</li> </ul>	ng			
	Seamless and fully adhered				
	Vapor permeable				
	UV resistant and non-yellowing Abarasian and abarasian assistant	0			
	<ul> <li>Abrasion and chemical resistar</li> <li>Adheres to most common con</li> </ul>		uhan cuitabla ari	ricusod	
provals	<ul> <li>Adheres to most common con</li> <li>FM Approval Standard 4470 fo</li> </ul>			i is useu.	
h104013	<ul> <li>Meets ASTM D7311-07: Standard</li> </ul>			Je-Pack, Moisture	Triggered Alinhat
	Polyurethane Roofing Membra		Elquid Applica, Sing		inggered, Alphat
		inc.			
verage	See Application Below				
-	See Application Below				
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# How to Use

Application

Surface Preparation

See Application below

# Substrate Evaluation

# Concrete and cementitious substrates

New concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compressive strength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). time. Moist or sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere with the bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer tested. Concrete must be suitably finished, preferably by wood float or steel pan. A power float finish is acceptable where the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be uniform and free from defects such as laitance, voids or honeycombing.

# **Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, damaged, or contaminated boards shall be removed and replaced.

#### Brick and stone

Mortar joints must be sound and preferably flush pointed.

# **Asphalt**

Asphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must be carefully assessed for moisture and/or air entrapment, grade and surface finish.

#### **Bituminous felt**

Ensure that bituminous felt is firmly adhered or mechanically fixed to the substrate. Bituminous felt shall not contain badly degraded areas.

#### **Bituminous coatings**

Bituminous coatings shall not have sticky or mobile surfaces, volatile mastic coatings, or old coal tar coatings.

#### <u>Metals</u>

Metals must be in sound condition.

# Wooden substrates

Plywood and timber based roof decks must be in good condition, firmly adhered and mechanically fixed. All plywood should be identified as conforming to PS 1 for construction and industrial plywood by grade, APA (American Plywood Association) trademark, or equivalent. For maximum smoothness, EXT Type APA, Grade A-C should be used, and the "A" side should be positioned to receive the Sikalastic resin.

Plywood decks to receive resin directly shall be at least 1/2 inch thick and attached and supported according to APA guidelines, using only non-rusting screw, spiral or coated nail type fasteners. A good practice would be to recess or counter sink fasteners 1/8 to 1/4 inch and fill with Sikaflex sealant. Suitable edge support to prevent differential deflection between panels shall be provided. Panel edges shall be tongue and groove or supported on solid blocking. Space panels 1/8 to 3/16 inch at panel ends.

#### Paints and coatings

Ensure the existing material is sound and firmly adhered.

# Existing Sikalastic RoofPro System

The existing Sikalastic RoofPro System shall be soundly adhered to the substrate.

#### Surface Preparation

#### Concrete and cementitious substrates

Cementitious or mineral based substrates must be prepared mechanically using abrasive blast cleaning or scarifying equipment to remove cement laitance and to achieve an open textured surface (CSP 3-5 per ICRI guidelines). Loose friable material and weak concrete must be completely removed and surface defects such as blowholes and voids must be fully exposed. The amount of embedment coat required may increase over rough or highly porous surfaces.

Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out. Consult Sika for product recommendations based on project requirements. High spots must be removed by grinding or similar method.

Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in liquid applied materials. The concrete must be carefully assessed for moisture content, air entrapment, and surface finish prior to any roofing work. Particular requirements for priming must also be considered. Installing the primer and membrane either when the concrete temperature is falling or stable can reduce outgassing. It is generally beneficial, therefore, to apply the primer and embedment coat in the late afternoon or evening.

#### **Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free. Secure loose boards if in sound condition. Damaged or contaminated boards shall be removed and replaced.



# Brick and stone

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required.

#### <u>Asphalt</u>

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. All major cracks should be sealed to allow continuity of the Sikalastic RoofPro system.

#### **Bituminous felt**

Power wash and use biodegradeable non-sudsing detergent with clean water rinse as required. Treat blisters by star cutting and removing any underlying water. Allow to dry and re-adhere using suitable adhesive.

#### Bituminous coatings

Remove any loose or degraded coatings.

#### <u>Metals</u>

Ferrous metals should be thoroughly cleaned by grinding or blast cleaning prior to priming (SSPC-SP3 to near-white metal) .

Non-ferrous metals are prepared by removing any deposits of dust and oxidation and abrading to bright metal. Wire brushing can be used for soft metal such as lead. The surface must be clean and free from grease which, if present, must be removed with a solvent wipe or wash with detergent, rinse and dry.

#### Wooden substrates

Timber and timber based roof decks require additional reinforcement such as the installation of plywood, approved insulation or cover board. Small timber protrusions and suitable decks may be treated directly, provided that the timber is of exterior quality, e.g. plywood. Fill joints flush with Sikaflex sealant.

#### Paints/Coatings

Remove any loose or degraded coatings. Ensure the surface is clean and free from grease.

#### Sikaplan®/Sarnafil® membranes

Clean membranes with Sarna Cleaner (PVC membranes) and Sarnafil® T Clean (TPO membranes) prior to application of primer.

#### Existing Sikalastic RoofPro Systems

Clean the membrane using a water jet at approximately 140bar (2000 psi) and biodegradeable non-sudsing detergent with clean water rinse. Allow to dry.

#### Application

# Priming

Refer to Priming Guide to select primer for properly evaluated and prepared substrate. Refer to separate primer Product Data Sheet for application methods, coverage rates, cure times and recoat windows. Always allow primer to cure thoroughly before applying detail or base resin layer.

# Sikalastic RoofPro Priming Guide

Substrate	Remark	CONCRETE PRIMER	DTE EPOXY Primer	EP PRIMER/ SEALER	Consult Sika
CONCRETE	(1)				
LIGHTWEIGHT STRUCTURAL CONCRETE	(1)				
CEMENT, GYPSUM BASED ROOF BOARDS					
BRICK, STONE	(3)				
BITUMINOUS SUBSTRATE					
-asphalt, bituminous felts, bituminous coat- ings, granulated or smooth SBS & APP cap sheets	(2,3)				
SINGLE PLY ROOFING MEMBRANES					
-HYPALON, TPO, EPDM, PVC	(3)				
ROOF TILES (UNGLAZED)	(3,4)				
FIBERGLASS	(3)				
POLYURETHANE FOAM- sprayed or slab stock					
METALS					
-aluminum, galvanized, cast iron, copper, lead, brass, stainless steel, steel, zinc	(3)				



PRE-COATED METAL	(3)		
PAINTS			
- paints & coatings	(3)		
- aluminized solar reflective coatings	(3)		
WOOD - TIMBER & PLYWOOD	(5)		

(1) New cementitious substrates must be Portland base and be cured min. 14 days.
 (2) The presence of volatiles may cause discoloration of Sikalastic if not properly primed.
 (3) Surface evaluation and field adhesion testing.
 (4) Glazed tile consult Sika.
 (5) Pressure treated lumber consult Sika

## Detailing

Non-structural cracks up to 1/16 inch - Detail application not necessary. Apply embedment/base resin layer per below.

Non-structural cracks between 1/16 inch and 1/4 inch - Rout and seal with Sikaflex sealant. Apply 40-45 mil resin layer embedded with 3 inch Sika Flexitape Heavy centered over crack. Apply embedment/base resin layer per below.

**Cracks and joints between 1/4 inch and 1 inch** - Rout and seal with Sikaflex sealant. Apply bond breaker tape sufficient to span width of crack or joint followed by 40-45 mil resin layer embedded with 6 inch Sika Flexitape Heavy centered over crack or joint. Apply embedment/base resin layer by terminating Sika Reemat or Sika Fleece at edges of crack or joint overlapping Sika Flexitape Heavy a minimum of 2 inches on both sides.

Joints greater than 1 inch - Treat as expansion joint. Consult Sika for recommendations.

Metal seams and plywood/coverboard joints - Apply 40-45 mil resin layer embedded with 3 or 6 inch Sika Flexitape Heavy centered over seam. Apply embedment resin layer per below.

Transitions between dissimilar materials - Apply 40-45 mil resin layer embedded with Sika Flexitape Heavy centered over edge. Apply embedment resin layer per below.

#### Embedment/Base Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic 641 Lo-VOC per RoofPro System Guide at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should be backrolled prior to embedding Sika Reemat. Place Sika Reemat in wet base resin layer overlapping seams a minimum of 2 inches (place frayed edge over cut edge of roll) and apply wet roller to topside to saturate completely. After approximately 5 minutes the binder will begin to dissolve allowing the fiber strands to conform to irregular surfaces. Do not over work once the fibers have conformed to the substrate.Allow to cure 12 hours at 70 degrees F and 50 % RH or until tack free before top resin layer. Keep clean and dry and apply top resin layer within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

#### Top Resin Layer with Sika Reemat Reinforcement

Mixing not required. Apply Sikalastic 641 Lo-VOC at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should also be backrolled. In the case of RoofPro 25 allow the first top resin layer to cure 12 hours at 70 degrees F and 50% RH or until tack free before applying second top resin layer. On top of the complete RoofPro system additional resin layers may be applied with aggregate for slip resistance - consult Sika for recommendations. Keep clean and dry and apply additional resin layers within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

Sikalastic RoofPro 641 Lo-VOC System Guide with Sika Reemat						
	RoofPro 10 RooftPro 15 RoofPro 20 RoofPro 2					
Substrates	Concrete o	Concrete or cementitious, metals, woods, single-ply or bituminous, stone				
Primer		Required - see Substrate Priming Guide				
Detailing	Sika Flexitape Heavy centered over seams, transistions and properly treated cracks and joints					
Reinforcement	Sika Reemat Standard	Sika Reemat Standard Sika Reemat Premium embedded in base resin layer over entire surface				
Sikalastic 641 Lo-VOC Base Layer	30 mils wet - 53 sf/gal.	50 mils wet - 32 sf/gal. 50 mils wet- 32 sf/gal. 50 mils wet - 32 sf				
Sikalastic 641 Lo-VOC Top Layer	30 mils wet - 53 sf/gal.	20 mils wet - 80 sf/gal.	30 mils wet - 53 sf/gal.	23 mils wet - 69 sf/gal.		
Sikalastic 641 Lo-VOC Top Layer				23 mils wet - 69 sf/gal.		
Total Film Thickness	53mils dry	62 mils dry	71 mils dry	85 mils dry		
NOTE: Coverage rates provided are opti	mal - coverage rates will vary o	lenending on temperature, sur	face roughness porosity and	application technique		

OTE: Coverage rates provided are optimal - coverage rates will vary depending on temperature, surface roughness, porosity, and application technique

#### Wet on Wet Application with Sika Fleece Reinforcement

Mixing not required. To primed substrate apply two-thirds of the Sikalastic 641 Lo-VOC specified in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Immediately place specified Sika Fleece into wet resin overlapping seams a minimum of 3" along the edge and 6" end-to-end. Apply wet roller to topside with light pressure to saturate fleece from bottom and ensure air pockets are completely removed. Immediately apply all of remaining one-third of Sikalastic 641 Lo-VOC resin specified in the RoofPro System Guide to ensure even and complete fleece saturation from topside and uniform texture.



Sikalastic RoofPro 641 Lo-VOC System Guide with Sika Fleece						
	RoofPro 15	RooftPro 20	RoofPro 25			
Substrates	Concrete or cementitious, metals, woods, single-ply or bituminous, stone					
Primer	Required - see Substrate Priming Guide					
Detailing	Sika Flexitape Heavy centered over seams, transistions and properly treated cracks and joints					
Reinforcement	Sika Fleece 120 (US) Sika Fleece 140 (US) Sika Fleece 170 (US)					
Sikalastic 641 Lo-VOC	70 mils wet - 25 sf/gal.	80 mils wet - 20 sf/gal.	95 mils wet- 16 sf/gal.			
Total Film Thickness	62 mils dry	71 mils dry	84 mils dry			

# Aggregated or Flake Surfacing

Supplemental aggregate and flake surfacing is required for all applications that will experience direct foot traffic such as balconies, terraces, walkways, and plazas, and is recommended for areas that experience maintenance foot traffic. Supplemental aggregate surfacing is applied in a supplemental resin layer after the Sikalastic membrane has been installed and is not applied into the roofing/waterproofing membrane itself.

#### Seed and Back Roll Option

The Seed and Backroll option is primarily intended for use for maintenance traffic-type applications where enhanced slip resistance is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet seed with kiln dried, iron free aggregate. Back roll the surface to encapsulate the aggregate in the Sikalastic resin.

# Full Broadcast and Seal Option

The Full Broadcast and Seal option is intended for use for applications where both enhanced slip resistance and physical protection of the roofing membrane is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with kiln dried, iron free aggregate. Remove excess aggregate after cure. Seal with an additional coat of Sikalastic resin.

# **Decorative Quartz and Decorative Flake Options**

The Decorative Quartz and Decorative Flake options are intended for use for applications where enhanced slip resistance, physical protection of the roofing membrane, and a decorative element is required.

Apply Sikalastic 641 Lo-VOC resin at 15 mils wet film thickness to the installed, cured membrane system. While the supplemental resin application is still wet broadcast to rejection (full broadcast, beach) with colored quartz aggregate or synthetic flakes. Remove excess aggregate/flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

Decorative flakes can also be seeded at less than full broadcast quantities. Remove excess aggregate/flakes after cure. Seal with a coat of Sikalastic 748 PA at 15 mils wet film thickness.

#### Aggregate Selection

Use clean, rounded or semi-angular, oven dried quartz sand with a minimum hardness of 6.5 per the Moh's scale. It should be supplied in pre-packaged bags and free of metallic or other impurities. The following size gradations are recommended:

- 16-30 or 20-40 mesh for pedestrian traffic systems
- Sika DecoQuartz Blends or equivalent for Decorative Quartz systems

#### Flake Selection

Use virgin vinyl flakes, supplied in pre-packaged bags and free from impurities. The following is recommended:

■ Sika DecoFlake Blends or equivalent for Decorative Flake systems

Tooling & Finishing	See Above
Removal	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.
Over Painting	See Above.
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 36 degrees F (2°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane resins. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter meter.</li> </ul>
INS"	OR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND TRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA

- Minimum age of concrete must be 28 days depending on curing and drying conditions.
- Do not thin with solvents.
- Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect material with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.
- Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D 4263 (Polyethylene sheet method).
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.
- On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing or blistering may occur.
- Use sunglasses with UV filter when applying highly reflective Sikalastic 641 Lo-VOC White (RAL 9016).
- Do not use for indoor applications unless sufficient air flow and ventilation are provided to prevent odors and/or vapors from leaving the immediate work area.
- Precautions should be taken to prevent odors and/or vapors from entering the building/structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and/or vapors into the building/structure during product application and cure.
- Not recommended for direct exposure to heavy or frequent foot traffic.
- Do not apply cementitious products, such as tile mortar directly onto Sikalastic 641 Lo-VOC. See Sikalastic 624 WP Product Data Sheet.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- When applying over existing coatings or membranes compatibility and adhesion testing and subsequent ap proval by Technical Services is required.
- Opening to traffic prior to cure may result in loss of aggregate or permanent staining and subsequent premature failure.
- On grade concrete decks should not be covered with Sikalastic RoofPro membrane systems.
- Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete deck overlays should not be covered with Sikalastic RoofPro systems without additional deck evaluation and subsequent approval by Technical Services.
- Do not subject to continuous immersion, i.e., fountains, ponds, pools, or interior of tanks.
- Not recommended for use over ceramic tile.

PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DE PARTMENT AT 800.933.7452 NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS FOR EACH SIKA PRODUCT AS SET FORTH IN THE CUR RENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

KEEP CONTAINER TIGHTLY CLOSED, KEEP OUT OF REACH OF CHILDREN, NOT FOR INTERNAL CONSUMPTION, FOR INDUSTRIAL USE ONLY, FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior toproduct use

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. SALE OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5

Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Visit our website at usa.sika.com Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

1-800-933-SIKA NATIONWIDE





# Sikalastic<sup>®</sup>-600 Accelerator

B	
Description	Sikalastic <sup>®</sup> -600 Accelerator is a single component, low viscosity, accelerating agent that enhances the moisture-trig- gered curing characteristics of Sikalastic <sup>®</sup> 600-series saturating resins for roofing and waterproofing applications.
Where to Use	Suitable for use with all Sikalastic <sup>®</sup> 600-series saturating resins
Advantages	<ul> <li>Reduces cure time of single component Sikalastic<sup>®</sup> 600-series saturating resins</li> <li>Allows more rapid return to service</li> <li>Avoids project delays due to lower application temperatures</li> </ul>
Packaging	4 oz bottles (6 bottles per carton)
Coverage	1 4-oz. bottle per 5 gal. pail of resin
Cure Mechanism	Accelerates moisture-triggered cure
Application	
Mixing	Thoroughly mix Sikalastic <sup>®</sup> -600 Accelerator into Sikalastic resin using a low-speed (400-600 rpm) drill with mechani- cal mixer (Jiffy) at slow slow speed until a homogenous mixture and uniform color is obtained (typically 1 minute). Use care not to allow the entrapment of air into the mixture.
Removal	Remove liquid accelerator immediately with dry cloth. Once cured, accelerator can only be removed by mechanical means.
Limitations	<ul> <li>Precautions must be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor odor ingress during resin application and cure.</li> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> </ul>

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AN EQUIPMENT TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

2 years in original, unopened containers.
Store dry at 40°-95°F (4°-35°C)
Condition material to 65-85 °F (18-30 °C) before using.
Clear
45 minutes
1:160 (0.625%)
100 +/- 50 cps
0.87
0 g/L.

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Sika Mexicana S.A. de C.V

Corregidora, Queretaro

Phone: 52 442 2385800

Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera

Visit our website at usa.sika.com

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# Sikalastic<sup>®</sup> Clearglaze (Decothane<sup>®</sup> Clearglaze) Water-based metal primer

#### Description

Sikalastic Clearglaze is a clear aliphatic, polycarbonate polyurethane coating which forms an effective barrier to water penetration and the ingress of atmospheric chemicals. Its transparent finish renders it suitable for applications where it is desirable to retain the appearance of the underlying substrate. It is particularly suitable for protecting porous stone, decorative aggregate panels and brick work against water penetration and subsequent freeze/thaw damage. In addition, it provides an effective barrier to carbon dioxide diffusion, making it ideal for protecting reinforced concrete against carbonation.

Sikalastic Clearglaze has a high solids formulation which uses moisture to trigger the curing process but, unlike conventional moisture cured systems, will not foam when excess moisture is present. Consequently, it will continue to cure normally, even in wet conditions and therefore helps to keep contract time to a minimum. The cured membrane enhances natural substrate colors producing a "wet look" finish which will not discolor with age or prolonged UV exposure.

Sikalastic Clearglaze is also suitable for use as a waterproof, anti-shatter coating over glass and roof lights. Combining toughness with excellent adhesion, the coating will prevent glass fragments from splintering in the event of an impact or explosion.

### TECHNICAL DATA

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODSAND AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, ACTUAL SITE CONDITIONS, AND CURING CONDITIONS.

Water vapor permeability BS. 3177 (0-75%RH) 9.02 g./m<sup>2</sup>/day at 24 mils or 1308 psi 0.768 Perms

Impact resistance BS.3900: Part E3. Withstands 5mm or .20 inch indentation without damage to film.

glass shatter resistance BS.6206: Class B (unreinforced) at 11.9 mils DFT

Accelerated weathering QUV ASM G53.77 - 5000 hours No deterioration; clarity retained.

Service temperature -122°F to 176°F

## **Chemical resistance**

Resistant to standard 10% solutions of mineral acids, most alkalis, acid rain and detergents. Some oils and solvents may soften the surface. Salt spray to BS.3900 Part 4 and ASTMB117 – 500 hours. No rusting, blistering or delamination.

## Anti-carbonation

Equivalent carbonation barrier to 55.36 meters or 176 feet of air at 24 mils DFT. Effective barrier = 50 meters or 159 feet.

# Approximate solids content

64.9% by weight 59.5% by volume

Specific gravit

1.20

vo C content 360 g/L

#### Drying times

At approximately 68°F/50% R.H., touch dry at 6 to 7 hours; through cure at a minimum of 8 hours. At approximately 36°F through cure at 24 hours.

# minimum application temperatures

36°F providing that this is 5°F above dew point. When applying Sikalastic Clearglaze by spray equipment, the material must be kept above 50°F.

#### maximum substrate moisture content

28% wood moisture equivalent, as measured by a Protimeter.

# Storage

All coatings should be kept dry and protected from frost and excessive heat. Previously opened pails should be used as soon as possible- within two or three days at most – and lids should always be replaced securely when the product is not being applied. Do not expose material to extreme temperature differentials or store exposed to sun.

# Storage temperatures

Store in dry, frost free conditions. Sikalastic Clearglaze should be stored above 35°F and below 86°F.

# Pack size

5 liters

# Shelf life

12 months.

# Approximate dry film thicknes

12 mils (for general use) 24 mils (for anti-carbonization/anti-shatter applications).

# Tensile strength

25 N/mm<sup>2</sup> or 362 psi (unreinforced)

# **Tensile elongation** 250% (unreinforced)

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Tear strength 18 N/mm<sup>2</sup> or 2610 psi.

# Adhesion (to glass)

Elcometer pull off tests >3 N/mm<sup>2</sup> or 435 psi

f ire resistance (BS. 476 Part 6 and 7) Class "O" rating on concrete surfaces.

Color Clear

Sikalastic Clearglaze Site Work and Application

#### Asbestos cement and asbestos-free equivalents

Always ensure strict compliance with Health and Safety requirements when working with asbestos-containing materials. The coating may be applied direct provided that the surface is dry. Extra care must be taken when cleaning since any shading of the surface will show through the coating.

# bricks, blocks and stone

Clay and cement bricks may be coated directly after preparation. Stonework which is clean and free from dirt and other contaminants may be treated directly.

# **Cementitious materials**

Concrete and screeds etc must be a minimum of 14 days old before treatment. Please consult our technical services department before applying to highly porous substrates. Adhesion tests should be carried out before over coating repair mortars.

# g lass

Ensure surfaces are clean and degreased before application. Apply to plain and reinforced glass, leaded windows, glazing strips and roof lights, unless total optical clarity must be obtained. Sikalastic Clearglaze may be lapped onto painted frames but it is not recommended for fully coating external painted surfaces since the paint may discolor and/or flake, resulting in delamination.

## metals

Apply direct to most metals. Please seek advice from Sika's Technical Services Department before coating ferrous metals.

## Plastics

Usual preparation procedures should be observed. Remove any oxidized layers and use localized reinforcement over joints. Any reinforcement incorporated within the membrane will be visible.

# Slates, tiles etc.

Sloping slate or tile roofs may be coated directly to prevent water absorption while maintaining the original appearance of the substrate. Inspect tiles to ensure that they are firmly adhered. Degrease glazed tiles, clean and allow to dry before applying Sikalastic Clearglaze. Do not use for treating bitumen coated tiles or shingles, as staining will result.

# **Coverage Rates**

The average rate for Sikalastic Clearglaze will depend on the intended function of the coating. Please consult our Technical Services Department for details about specific application.

System*	Coverage	Approx Wf T/mils
Unreinforced- General Weatherproofing	80 ft²/gal	20 mils
Unreinforced- Anti-Car- bonation	40 ft²/gal	40 mils
Reinforced Waterproofing System (2 coats)	40 ft²/gal	40 mils

When using a partially reinforced system, the following extra quantities are required for embedment prior to over coating as above.

Reinforcement Type**	Coverage	Approx Wf T/mils	At width (in)
Sika Flexitape Light	53 ft²/gal	30 mils	2"
Sika Flexitape Heavy	32 ft²/gal	50 mils	3"

\* Plus wastage/embedment allowance.

\*\* Sika Reemat Premium reinforcement is normally used with Sikalastic Clearglaze. When using a fully reinforced system, apply an embedment coat at 40 mils WFT, 40 ft<sup>2</sup>/gallon and embed the glass fiber mesh using light pressure from a roller. Allow to dry and apply a second coat at 40 mils WFT, 40 ft<sup>2</sup>/gallon. NOTE: One coat applications – inspect cured film thoroughly for voids or thin areas. Overcoat any affected sections.

#### Preparation

Ensure surface is clean and sound prior to application of Sikalastic Clearglaze. Any areas contaminated with moss or lichen must be treated with Liquid Plastics' Biocleanse to prevent re-development.

# Application

Once the relevant system has been selected, please refer to the above for details of coverage rates. Rough, porous, absorbent or undulating surfaces will inevitably increase the quantity of coating required. Surface preparation for a clear coating must be thorough, particularly in relation to the removal of all organic growth. Always allow primer and any previous coat to dry/cure thoroughly before applying the following coat. Coatings will generally require curing overnight, although under optimal conditions (at higher temperatures and higher relative humidity) work may often recommence sooner. Do not thin or brush out like conventional coatings. When using brushes, the first coat should ideally be applied in one direction only, where possible, the second coat should be applied at right angles to the first.

## Equipment

# Roller

Use on flat or undulating surfaces but not on rough surfaces. Lay using light pressure in two coats to bring up to required coverage rate using a medium pile sheepskin roller, do not over work. In excess of 40ft<sup>2</sup>/gallon total applications, three coats may be needed to avoid slump.

## brush

Apply in two coats. Apply second coat at right angles to first coat whenever possible. Use a soft nylon or bristle brush. Application limits per coat are the same as for roller applications,

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# Clean up

Before curing, flush/wash equipment with MEK, cleaning solvent, xylol or cellulose thinners. Avoid any solvents containing alcohols.

DO NOT thin material unless specifically allowed by LP technical personnel.

## **Routine Care and maintenance** g eneral

In normal use, Sikalastic systems require no routine maintenance other than periodic inspections to check for damage by accidental impact or by building modifications. During the course of such inspections, sharp objects such as screws, stones, broken glass and other material should be removed from the surface in order to minimize the chances of accidental damage by subsequent foot traffic.

## Repairs

In the event of localized damage, or to reinstate a completely seamless barrier following structural modifications, repairs can be made quickly and easily by applying more of the appropriate coating to the affected areas. If treating small punctures, the surrounding membrane should be cleaned, primed if necessary and repaired by the application of additional material (usually by brush or roller). If treating new joints etc. embed either Sika Reemat GFM or Sika Flexitape into the wet coating and allow to cure before applying a second coat. In small cases, care should be taken to restore the dry film thickness of the original membrane.

## **Health and Safety**

Please refer to the MSDS prior to use.

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Fracc. Industrial Balvanera

Corregidora, Queretaro C.P. 76920

Phone: 52 442 2385800

Fax: 52 442 2250537

Visit our website at usa.sika.com

Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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# Sika® Reemat Standard and Premium

Randomly oriented glass fiber reinforcement for Sikalastic<sup>®</sup> RoofPro systems

Surface treated, randomly oriented glass fiber reinforcement to enhance the strength and durability of Sikalastic <sup>®</sup> RoofPro 601 BC, 621 TC, 624 WP, 641, and 641 Lo-VOC roofing and waterproofing membranes.
<ul> <li>Ideal for roofing and waterproofing applications displaying complex details and geometry or when accessibility is limited.</li> <li>Suitable for applications where visibility of reinforcement overlaps is an aesthetic concern.</li> </ul>
<ul> <li>Provides maximum conformability to uneven substrates.</li> <li>Creates strong reinforced roofing and waterproofing membranes with enhanced tensile strength.</li> <li>Increases puncture and tear resistance.</li> </ul>
Standard: 51" roll: 2,788 ft <sup>2</sup> per roll (not including overlaps) Premium: 51" roll: 1,254 ft <sup>2</sup> per roll (not including overlaps) Premium: 12" roll: 295 ft <sup>2</sup> per roll (not including overlaps)
Not intended to be directly subjected to chemical exposure without being fully saturated with liquid resin.
Standard: 51"w x 656' l individually bagged rolls Premium: 51"w x 295' l individually bagged rolls Premium: 12"w x 295' l individually bagged rolls
-

# Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDI-TIONS AND CURING CONDITIONS.

Shelf Life:	Indefinite		
Storage Conditions:	Store flat and wrinkle-free i undamaged sealed packag	<b>U</b> 1	and
Product Conditioning:	Recommended to condition before using to match liquid		(10°-25°C)
Color	Off-White		
	Standard	Premium	
Weight (g/m²):	225 +/- 25	225 +/- 25	
Weight (oz/yd²):	6.6 +/- 0.7	6.6 +/- 0.7	
Roll Width:	51"	51"	12"
Roll Length:	656 ft.	295 ft.	295 ft.
Total Gross Area:	2.788 ft <sup>2</sup>	1.254 ft <sup>2</sup>	295 ft <sup>2</sup>



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Substrate surfaces, including flashing substrates, shall be primed, clean and dry, in accordance with separate System Data Sheet.
Apply the specified base layer resin quantity to primed substrate surface with a 1/2" nap phenolic resin core roller. Immediately place Sika <sup>®</sup> Reemat into wet resin, overlapping reinforcement 2" along the sides and at the roll ends. Apply wet roller to topside with light pressure to completely saturate the Reemat and to allow the Reemat to conform to substrate irregularities and flashing conditions. Apply additional resin as required to top of the Reemat to aid in conformity.
Remove glass mat saturated with liquid resin from substrate immediately, and wipe substrate with dry cloth. Once cured, reinforced membrane can only be removed by mechanical means.
<ul> <li>Avoid creating wrinkles and creases during storage, as they will tend to be visible in finished membrane after application.</li> <li>Store rolls on end, and not on their side.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> </ul>

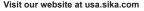
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# Sika® Fleece 120 (US), 140 (US), and 170 (US) Polyester fleece reinforcement for Sikalastic RoofPro systems

Description	Non-woven, needle-punched polyester fleece reinforcement to enhance the strength and durability of Sikalastic RoofPro 621 TC and 624 AR roofing and waterproofing membranes
Where to Use	<ul> <li>Ideal for roofing and waterproofing applications displaying complex details and geometry or when accessibility is limited</li> <li>Suitable for applications where visibility of reinforcement overlaps is not an aesthetic concern</li> <li>Ideal for applications where a one-day system installation is required</li> </ul>
Advantages	<ul> <li>Permits wet on wet application of Sikalastic 621 TC (US) and Sikalastic 624 AR resins</li> <li>Creates strong reinforced roofing and waterproofing membranes with enhanced elongation properties</li> <li>Fleece thickness dictates membrane thickness</li> <li>Reduces pinholing due to outgassing</li> <li>Increases puncture and tear resistance</li> </ul>
Coverage	600 sf per roll (not including overlaps)
Chemical Resistance	Not intended to be directly subjected to chemical exposure without being fully saturated with liquid resin
Packaging	48" w x 150' l individually bagged rolls

# Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	Indefinite		
Storage Conditions:	Store flat and wrink	le-free in original, un packaging in dry cor	•
Product Conditioning:	Recommended to co before using to mat	ondition material to 50 ch liquid resin.	-77°F (10-25°C)
	Sika Fleece 120	Sika Fleece 140	Sika Fleece 170
Weight (g/m2):	120 +/- 15	140 +/- 17	170 +/- 20
Weight (oz/yd2)	3.5 +/- 0.4	4.0 +/- 0.5	5.0 +/- 0.6
Thickness (ASTM D-5729):	50 mils +/- 10%	60 mils +/- 10%	80 mils +/- 10%
Tensile Strength MD (ASTM D-5034):	45 lbs. min.	50 lbs. min.	55 lbs. min.
Tensile Strength CMD (ASTM D-5034)	: 55 lbs. min.	70 lbs. min.	75 lbs. min.
Elon gation MD (ASTM D-5034):	30 +/- 10%	42 +/- 10%	34 +/- 10%
Elongation CMD (ASTM D-5034):	28 +/- 10%	34 +/- 10%	32 +/- 10%
Roll Width:	48"	48"	48"
Roll Length:	150 ft.	150 ft.	150 ft.
Total Gross Area:	600 sf	600 sf	600 sf



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	Substrate surfaces, including flashing substrates, shall be primed, clean and dry, in accordanc with separate System Data Sheet.
Application	Precut Sika Fleece and dry-fit to horizontal field and vertical flashing conditions. Temporari remove fleece. Apply approximately 2/3 of the specified resin quantity to primed substrat surface with a 1/2" nap phenolic resin core roller. Immediately fit and place Sika Fleece int wet resin, overlapping reinforcement 3" along the sides and 6" at the roll ends. Apply we roller to topside with light pressure to saturate from bottom and to ensure that air pockets ar completely removed. Immediately apply the remaining 1/3 of the specified resin quantity an apply wet roller to topside with light pressure to fully saturate the membrane and achiev an even texture and appearance.
Removal	Remove fleece saturated with liquid resin from substrate immediately, and wipe substrate with dry cloth. Once cured, reinforced membrane can only be removed by mechanical means.
Limitations	<ul> <li>Avoid creating wrinkles and creases during storage, as they will tend to be visible in finished membrane after application.</li> <li>Store rolls on their side and not on end.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occuduring application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems</li> </ul>
CAUTION	Sika Fleece-120
	Not a hazardous substance or mixture. This product does not contain any chemicals know to the State of California to cause cancer, birth, or any other reproductive defects.
	Wash skin thoroughly after handling. Use personal protective equipment as required. I INHALED: Move to fresh air. IF ON SKIN: Wash with plenty of soap and water. IF IN EYES Rinse cautiously with water for several minutes. Remove contact lenses, if present and eas to do. Continue rinsing. IF SWALLOWED: rinse mouth. Do NOT induce vomiting. If eye irritation persists: Get medical advice/attention. If skin irritation or rash occurs: Get medical advice attention. IF exposed or concerned: Get medical advice/attention. Take off contaminate clothing and wash before reuse.
	Sika Fleece-140
	Not a hazardous substance or mixture. This product does not contain any chemicals know to the State of California to cause cancer, birth, or any other reproductive defects.
	Wash skin thoroughly after handling. Use personal protective equipment as required. I INHALED: Move to fresh air. IF ON SKIN: Wash with plenty of soap and water. IF IN EYES Rinse cautiously with water for several minutes. Remove contact lenses, if present and eas to do. Continue rinsing. IF SWALLOWED: rinse mouth. Do NOT induce vomiting. If eye irritation persists: Get medical advice/attention. If skin irritation or rash occurs: Get medical advice attention. IF exposed or concerned: Get medical advice/attention. Take off contaminate clothing and wash before reuse.

DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

## Sika Fleece-170

Not a hazardous substance or mixture. This product does not contain any chemicals known to the State of California to cause cancer, birth, or any other reproductive defects.

Wash skin thoroughly after handling. Use personal protective equipment as required. IF INHALED: Move to fresh air. IF ON SKIN: Wash with plenty of soap and water. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. IF SWALLOWED: rinse mouth. Do NOT induce vomiting. If eye irrita-tion persists: Get medical advice/attention. If skin irritation or rash occurs: Get medical advice/attention. IF exposed or concerned: Get medical advice/attention. Take off contaminated clothing and wash before reuse.

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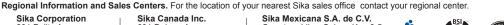
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**Product Data Sheet** Edition 5.20.2014 Sika® Flexitape Heavy

Sika<sup>®</sup> Flexitape Heavy Woven Nylon Reinforcing and Detailing Mesh

Description	Polyamide knitted reinforcement for use with Sikalastic RoofPro and Sikagard wall coating systems.
Where to Use	<ul> <li>Moving and nonmoving cracks</li> <li>Cold joints</li> <li>Joints between dissimilar materials</li> <li>Wall/deck intersections</li> <li>Flashing reinforcement</li> </ul>
Advantages	<ul> <li>Stretches within membrane to accommodate thermal and structural movement</li> <li>Imparts additional strength and durability</li> <li>Conforms to substrate contours and flashing conditions</li> </ul>
Coverage	164 lin. ft.
Chemical Resistance	Not intended to be directly subjected to chemical exposure without being fully saturated with liquid resin
Packaging:	3" or 6" w x 164' l rolls

# Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	Indefinite
Storage Conditions:	Store flat in original, unopened and undamaged sealed packaging in dry conditions.
Product Conditioning:	Recommended to condition material to 50-77°F (10- 25°C) before using to match liquid resin.
Color	Off-white
Roll Width:	3" or 6"
Roll Length:	164 ft.
Total Gross Area:	164 lin.ft.



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Surface	
Surface Preparation	Substrate surfaces, including flashing substrates, shall be primed, clean and dry, in accordance with separate System Data Sheet.
Application	Non-moving j oints and Cracks
	Apply liquid resin to primed substrate. Embed Flexitape into liquid resin without stretching gentle brush or roller pressure. Apply additional liquid resin to fully encapsulate the Flexitape.
	Moving j oints and Cracks
	Apply 1-2" wide release tape over moving joint/crack. Apply liquid resin to primed substrate Embed Flexitape into liquid resin without stretching, centered over joint/crack, by gentle brust or roller pressure. Apply additional liquid resin to fully encapsulate the Flexitape. Flexitape sho extend 1-1/2" minimum beyond both sides of the release tape.
Removal	Remove Flexitape saturated with liquid resin from substrate immediately, and wipe substrate wild dry cloth. Once cured, reinforced membrane can only be removed by mechanical means.
Limitations	<ul> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and surface</li> </ul>
	<ul> <li>during application and cure.</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> </ul>
CAUTION	Not a hazardous substance or mixture. This product does not contain any chemicals known the State of California to cause cancer, birth, or any other reproductive defects.
	persists: Get medical advice/attention. If skin irritation or rash occurs: Get medical advice attention. IF exposed or concerned: Get medical advice/attention. Take off contaminated clothing
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Fic ac be Pr Da m fo SI th rist W W Pl R R R R R R V	persists: Get medical advice/attention. If skin irritation or rash occurs: Get medical advice attention. IF exposed or concerned: Get medical advice/attention. Take off contaminated clothin and wash before reuse.
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**Product Data Sheet** Edition 2.4.2016 Identification no. Sika® Joint Tape SA

# Sika® Joint Tape SA

Self-adhering polymeric rubberized tape with woven polyester facer

Description		rubberized tape with plastic release liner on underside and woven polyester face he strength and durability of Sikalastic roofing and waterproofing membranes Iges.
Where to Use	<ul> <li>Fleece facer allows p</li> <li>Stretches with men</li> <li>Imparts additional s</li> </ul>	imer required for most applications positive resin/coating bond nbrane to accomodate thermal and structural movement strength and durability ate contours and flashing conditions
Advantages	<ul><li>Reinforcement of jo</li><li>Reinforcement of jo</li></ul>	ints between insulation and cover boards ints between plywood deck panels ints and seams in metal roofing al flanges to structural deck
Coverage	50 lin. ft.	
Cure Mechanism	n N/A	
Chemical Resist	ance Not intended to be direct resin.	ctly subjected to chemical exposure without being fully coated with liquid
Packaging	3" or 6" w x 50' l rolls. C	arton contains 8 3" wide rolls and 4 6" wide rolls, 100 sf total.
	RESULTS MAY DIFFER BAS MIXING METHODS AND EQU TEST METHODS, ACTUAL S Shelf Life	d curing conditions @ 75°F (24°C) and 50% RH) ED UPON STATISTICAL VARIATIONS DEPENDING UPON UIPMENT, TEMPERATURE, APPLICATION METHODS, ITE CONDITIONS AND CURING CONDITIONS. 2 Years
	RESULTS MAY DIFFER BAS MIXING METHODS AND EQU TEST METHODS, ACTUAL S Shelf Life Storage Conditions Product Conditioning Color Roll Width Roll Length Total Thickness	ED UPON STATISTICAL VARIATIONS DEPENDING UPON UPPMENT, TEMPERATURE, APPLICATION METHODS, ITE CONDITIONS AND CURING CONDITIONS. 2 Years Store flat in original, unopened and undamaged sealed packaging in dry conditions. Do not expose to direct sunlight or other heat sources. Recommended to condition material to 50-77 °F (10-25 °C) before using. Off-white fleece top surface, black bottom surface 3" or 6" 50 ft. 30 mils
	RESULTS MAY DIFFER BAS MIXING METHODS AND EQU TEST METHODS, ACTUAL S Shelf Life Storage Conditions Product Conditioning Color Roll Width Roll Length	ED UPON STATISTICAL VARIATIONS DEPENDING UPON UPPMENT, TEMPERATURE, APPLICATION METHODS, ITE CONDITIONS AND CURING CONDITIONS. 2 Years Store flat in original, unopened and undamaged sealed packaging in dry conditions. Do not expose to direct sunlight or other heat sources. Recommended to condition material to 50-77 °F (10-25 °C) before using. Off-white fleece top surface, black bottom surface 3" or 6" 50 ft.
How To Use Surface Prepara	RESULTS MAY DIFFER BASE MIXING METHODS AND EQU TEST METHODS, ACTUAL SI Shelf Life Storage Conditions Product Conditioning Color Roll Width Roll Length Total Thickness Flash Point Substrate surfaces, inc debris, and oils. Solver acetone is recommend	<ul> <li>ED UPON STATISTICAL VARIATIONS DEPENDING UPON UPPMENT, TEMPERATURE, APPLICATION METHODS, ITE CONDITIONS AND CURING CONDITIONS.</li> <li>2 Years Store flat in original, unopened and undamaged sealed packaging in dry conditions. Do not expose to direct sunlight or other heat sources. Recommended to condition material to 50-77 °F (10-25 °C) before using. Off-white fleece top surface, black bottom surface 3" or 6" 50 ft. 30 mils 110°F (43°C)</li> <li>Iuding flashing substrates, shall be clean and dry, free of dirt, dust, loose rust not wiping metal flanges or contaminated surfaces with denatured alcohol o ed.</li> </ul>
	RESULTS MAY DIFFER BAS MIXING METHODS AND EQU TEST METHODS, ACTUAL SI Shelf Life Storage Conditions Product Conditioning Color Roll Width Roll Length Total Thickness Flash Point Substrate surfaces, inc debris, and oils. Solver acetone is recommend Priming is typically not plications (20°F - 40°F)	<ul> <li>ED UPON STATISTICAL VARIATIONS DEPENDING UPON UPPMENT, TEMPERATURE, APPLICATION METHODS, ITE CONDITIONS AND CURING CONDITIONS.</li> <li>2 Years Store flat in original, unopened and undamaged sealed packaging in dry conditions. Do not expose to direct sunlight or other heat sources. Recommended to condition material to 50-77 °F (10-25 °C) before using. Off-white fleece top surface, black bottom surface 3" or 6" 50 ft. 30 mils 110°F (43°C)</li> <li>Iuding flashing substrates, shall be clean and dry, free of dirt, dust, loose rust nt wiping metal flanges or contaminated surfaces with denatured alcohol o</li> </ul>

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Application	<b>Non-moving Joints:</b> Apply Sika Joint Tape SA to prepared substrate. Remove 4 - 6" of release liner from underside of Sika Joint Tape SA. Position Sika Joint Tape SA centered over joint extending 1-1/2" minimum over each side of the joint, and press into place. Continue to remove release liner and press Sika Joint Tape SA onto substrate surface. Apply additional pressure to applied Sika Joint Tape SA to activate bonding process. Use a steel roofer's roller for best results. The firmer the pressure applied, the faster and stronger the bond.
	Moving Joints: Apply 1-2" wide release tape over moving joint/crack. Apply Sika Joint Tape SA to prepared substrate. Remove 4 - 6" of release liner from underside of Sika Joint Tape SA. Position Sika Joint Tape SA centered over joint extending 1-1/2" minimum over each side of the joint beyond the release tape, and press into place. Continue to remove release liner and press Sika Joint Tape SA onto substrate surface. Apply additional pressure to applied Sika Joint Tape SA to activate bonding process. Use a steel roofer's roller for best results. The firmer the pressure applied, the faster and stronger the bond.
	<b>Touch-Up:</b> Lance, cut or pierce air bubbles and force out the air, then press the Sika Joint Tape SA back in place. Cut open tented sections of tape, press the Sika Joint Tape SA back in place, and apply an ad- ditional layer of Sika Joint Tape SA over the cut, extending 1-1/2" minimum over the cut in all directions. Cut away bunched-up sections of tape, press the Sika Joint Tape SA back in place, and apply an additional layer of Sika Joint Tape SA over the cut, extending 1-1/2" minimum over the cut in all directions. Use a steel roofer's roller on all remedial/repair applications.
Over Painting	Sikalastic resins and coatings may be applied immediately following Sika Joint Tape SA application, and should be applied within 72 hours to a clean and dry tape surface. Priming of the Sika Joint Tape SA fleece surface is not required but also does not affect tape performance. Sika Joint Tape SA is UV- resistant but is not intended for direct exposure.
Removal	If possible, remove Sika Joint Tape SA from substrate immediately. Once pressure has been applied to initiate bond, Sika Joint Tape SA can only be removed by mechanical means.
Limitations	<ul> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various Sika product solutions). Surface irregularities may reflect though the cured system.</li> </ul>
	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> </ul>
	<ul> <li>Minimum ambient and substrate temperature during application and curing of material is 20°F (-6°C); maximum is 95°F (35°C).</li> </ul>
	<ul> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> <li>Do not apply to a porous or damp surface where moisture vapor transmission will occur during application and cure.</li> </ul>
	<ul> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather as there is the potential for bonding problems.</li> </ul>

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SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINCE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS. OF SIKA PRODUCTS ARE SUBJECT SIKA'S TERMS AND CONDITIONS OF SALE AVAILABLE AT HTTP://USA.SIKA.COM/ OR BY CALLING 201-933-8800.

Sika Mexicana S.A. de C.V.

Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5

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F250

**Product Data Sheet** Edition 2.4.2016 Identification no. Sika® Joint Tape SA Primer

# Sika® Joint Tape SA Primer

Single component primer for use with Sika Joint Tape SA

Description	Sika Joint Tape SA Primer is a single component synthetic polymer-based primer for use with Sika Joint Tape SA to enhance adhesion to dusty/oxidized/porous surfaces, and to facilitate cold weather application in temperatures of 20 °F (-6 °C) to 40 °F (5 °C).	
Where to Use	<ul> <li>Dusty/oxidized EPDM and TPO single ply membranes</li> <li>Substrate surfaces contaminated with asphalt residue</li> <li>Porous masonry and concrete surfaces</li> <li>Wood substrate surfaces</li> <li>All applications with ambient and substrate temperatures below 40 °F (5 °C)</li> </ul>	
Advantages	<ul> <li>Sika Joint Tape SA Primer improves adhesion of Sika Joint Tape SA to substrate surfaces that are difficult to clean, oxidized, or too porous to provide adequate surface area for bonding</li> <li>Sika Joint Tape SA Primer enhances adhesion by preconditioning cold substrate surfaces</li> <li>Quick cure allows same-day Sika Joint Tape SA application</li> </ul>	
Coverage	200-250 sf/gallon, depending on substrate	
Cure Mechanism	Evaporative cure	
Chemical Resistance	Not intended for direct exposure	
Packaging	1 gallon cans	

# Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	12 months in original, unopened and undamaged sealed containers.
Storage Conditions	Store dry at 41-86 °F (5-30 °C).
Product Conditioning	N/A
Wet Film Thickness	4 mils typical
Viscosity	135 - 152 cps
VOCs (ASTM D-2369-81)	Exempt solvent
Flash Point	110°F (43°C)

# How To Use

Surface Preparation	Clean substrate thoroughly by solvent wiping with denatured alcohol or acetone to remove dirt, debris, oil, and other contaminants. Allow surface to dry thoroughly for a minimum of 15 minutes at 75°F and 50% relative humidity. Surface must be clean and dry.
Mixing	Premix Sika Joint Tape SA Primer to obtain an even consistency. Stir Sika Joint Tape SA Primer frequently as application progresses.
Application	Apply a thin layer of Sika Joint Tape SA Primer with a natural bristle brush or phenolic resin core roller, ensuring 100% coverage of the surface area to be adhered to, but without puddling. Allow the primer to dry tack free. Reseal container tightly immediately after use.



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	Allow primer to cure completely tack free prior to applying Sika Joint Tape SA. Curing time is depended on temperature and relative humidity, and can range from 10 minutes to 1 hour or longer, depending temperature. Ideally, Sika Joint Tape SA will be applied within 2 hours of primer application. Maximus primer exposure is 12 hours.
Removal	See Label
Equipment Cleanup	See Label
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point tempera tures.</li> </ul>
	<ul> <li>Minimum ambient and substrate temperature during application and curing of material is 20°F (-6°C); maximum is 95°F (35°C).</li> </ul>
	<ul> <li>Do not store materials outdoors directly exposed to sunlight and moisture. Cover and protect materials with breathable type covers such as canvas tarpaulins to allow venting and protection from weather and moisture. Observe temperature storage and conditioning requirements.</li> </ul>
	<ul> <li>Existing substrate surface must be dry prior to application. Do not apply to a frosted, wet or dan surface. Allow sufficient time for the existing substrate to dry after rain or inclement weather, a there is the potential for bonding problems.</li> </ul>
	Do not use Sika Joint Tape SA Primer on PVC roofs as reactivation of some plasticizers may occur
	<ul> <li>Sika Joint Tape SA Primer is not UV-stable; apply Sika Joint Tape SA as soon as primer is cured ar tack-free.</li> </ul>
	<ul> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/structur including but not limited to turning off and sealing air intake vents and through-wall air condtio ers, and other means of vapor/odor ingress during application and cure.</li> </ul>
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Product Data Sheet Edition 5.20.2014 Sika® Concrete Primer

Sika<sup>®</sup> Concrete Primer

Density:

Flash Point:

VOCs (ASTM D-2369-81)

Service Temperature:

Rapid curing, high solids, solvent based primer

Description	consisting of: a solvent-based polyure	ponent, rapid curing, high solids, solvent-based primer, hane resin (Part A), and a hardener (Part B). It is designed o reduce the incidence of outgassing. In its wet mixed in color.
Where to Use	Suitable for use on most sound substrate surfaces where both a penetrative and surface-lying effect is required.	
Advantages	<ul> <li>Significantly reduces the likelihood of blistering and pinholing</li> <li>Very fast curing formulation</li> <li>Combines rapid cure time with a long pot life</li> <li>Compatible with most concrete, masonry, and stone substrate materials</li> </ul>	
Coverage	225 to 375 sf/gal, depending on substrate profile and porosity 225 sf/gal on prepared, dry concrete and masonry (CSP3 surface preparation) <b>Note:</b> On porous/open substrates, apply as two coats, each at a maximum spread rate of 270 sf/gal.	
Cure Mechanism	n Chemical cure	
Chemical Resistance	Not intended for direct exposure	
Packaging:	4.5 L. kit (3.5 L Part A, 1.0 L.Part B); 23 L (2 x 11.5 L) kit (2 x 9.0 L Part A, 2 x 2.5 L Part B)	
	Typical Data (Material and curing	conditions @ 73°F (23°C) and 50% R.H.)
	RESULTS MAY DIFFER BASED UPON STATISTICAL VAP APPLICATION METHODS, TEST METHODS, ACTUAL SI	NATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, TE CONDITIONS AND CURING CONDITIONS.
	Shelf Life:	12 months in original, unopened and undamaged sealed containers.
	Storage Conditions:	Store dry at 41-77°F (5-25°C).
	Product Conditioning:	Condition material to 50-77°F (10-25°C) before using for ease of application.
	Pot Life:	45 minutes
	Total Weight Solids (ASTM D-2697):	72%

1.02 kg.l

280 g/l

Part A: 104°F (40°C) Part B: 163°F (73 °C)

-22 to 176°F (-30 to 80°C) intermittent



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How to Use Surface	All substrate surfaces shall be clean, dry and sound. Acceptable substrates include: sound	
Preparation	concrete, masonry and stone, gypsum and cement-based cover boards. Reference separat System Data Sheet for specific surface preparation requirements. Mixing Premix Part A with low speed drill and paddle (Jiffy-type). Pour entire contents of Part B into Part A and mix togethe until a homogenous mixture and uniform color is achieved (typically 3 minutes) using care t prevent entrapment of air.	
Mixing	Mix ratio is 3.55:1 (A:B) by volume and 4.56:1 (A:B) by weight. Add Part B into Part A and mi with mechanical mixer (Jiffy) at low speed. Avoid adding air into the primer during mixing. Whe fully mixed, the primer should be free from streaks and be a uniform amber color. Do not brea down kits into smaller quantities.	
Application	will saturate the substrate and leave a slight film on the substrate top surface. Apply ever without puddling.	
Removal		
Over Painting	Allow primer to cure completely prior to applying membrane resin. Full cure: 30 minutes at 68°F Ideally, membrane resin will be applied within 24 hours of primer application. Maximum primer exposure is 48 hours. Primer exposed longer than 48 hours, and primer exposed to water during curing and exhibiting a chalky appearance, must be reprimed. Deteriorated primer must be mechanically removed before primer reapplication.	
Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C).</li> <li>Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter Meter.</li> <li>Minimum age of concrete must be 21-28 days depending on curing and drying conditions.</li> <li>Do not thin with solvents.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).</li> <li>Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.</li> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/ structure, including but not limited to turning off and sealing air intake vents and through wall air conditioners, and other means of vapor/odor ingress during application and cure.</li> <li>Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> <li>When applying over existing coatings or membranes compatibility and adhesion testing, and subsequent approval by Technical Services is required.</li> <li>On grade concrete decks should</li></ul>	
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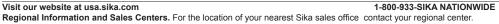


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**Product Data Sheet** Edition 7.28.2016 Sikalastic® DTE Primer



# APPROVED

# Sikalastic<sup>®</sup> DTE Primer Damp Tolerant Epoxy Primer

Description	Sikalastic <sup>®</sup> DTE Primer consists of two components: an epoxy resin (Part A), and an activator (Part B). In its wet mixed state, it is amber in color.
Where to Use	Suitable for use on most sound concrete and masonry substrate surfaces where both a penetrative sealing and surface-lying effect is required.
Advantage	<ul><li>Low odor, low VOC formulation.</li><li>Seals concrete and masonry surfaces, reducing outgassing.</li></ul>
Coverage	200 ft²/gal on prepared, dry concrete, depending on substrate profile and porosity. 100 ft²/gal when mixed with 10 lbs. 20-40 mesh kiln-dried sand as a 30 mil slurry coat. Note: Rough, porous, or absorbent surfaces will require additional primer and will reduce yield.
Cure Mechanism	Chemical Cure.
Chemical Resistance	Not intended for direct exposure.
Packaging	1 gal. kit (0.62 gal. Part A, 0.38 gal. Part B).

#### Typical Data (Material and curing conditions @ 75°F (24°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	12 months in original, unopened and undamaged sealed containers.
Storage Conditions:	Store dry at 40°-95°F (2°-35°C).
Product Conditioning:	Condition material to 50°-77°F (10°-25°C) before using for ease of application.
Pot Life:	45 minutes
Total Volume Solids (ASTM D-2697)	100%
VOCs (ASTM D-2369-81)	16 g/l
Flash Point	130°F (54°C)
Service Temperature	-22° to 176°F (-30° to 80°C) intermittent.

### How to Use **Surface Preparation** All substrate surfaces shall be clean, dry and sound. Acceptable substrates include: sound concrete and masonry. Reference separate System Data Sheet for specific surface preparation requirements. Mixing Mix ratio is 1.6:1 (A:B) by volume. Add Part B into Part A and mix with mechanical mixer (Jiffy) at low speed. Avoid adding air into the primer during mixing. When fully mixed, the primer should be free from streaks and of a uniform amber color. Do not break down kits into smaller quantities. For leveling/sealing slurry, add 10 lbs. 20-40 mesh kiln-dried sand to mixed primer and mix with mechanical mixer (Jiffy) until a uniform consistency is achieved. Application Apply by brush or phenolic resin core roller at the recommended rate. Correct amount of primer will saturate the substrate and leave a slight film on the substrate top surface. Apply evenly without puddling. Apply slurry with flat-bladed squeegee or trowel. Removal Remove wet primer with MEK, xylene, or oxygenated solvents. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use. **Over Painting** Allow primer to cure completely prior to applying membrane resin. Full cure: 8 hours at 68°F. Ideally, membrane resin will be applied within 24 hours of primer application. Maximum primer exposure is 3 days. Primer exposed longer than 3 days, and primer exposed to water during curing and exhibiting a chalky appearance, must be reprimed. Deteriorated primer must be mechanically removed before primer reapplication. PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND



### Limitations

- To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.
- Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C).
- Do not apply on substrates with moisture content greater than 5% by weight, measured by Tramex<sup>®</sup> Concrete Moisture Encounter Meter.
- Minimum age of concrete must be 21-28 days depending on curing and drying conditions.
- Do not thin with solvents.
- Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.
- Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.
- On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.
- Precautions should be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of vapor/odor ingress during application and cure.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika) representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- When applying over existing coatings or membranes compatibility and adhesion testing, subsequent approval by Technical Services is required.
- On grade concrete decks should not be covered with Sikalastic<sup>®</sup> membrane systems.
- Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete overlays should not be covered with Sikalastic® membrane systems without additional deck evaluation and subsequent approval by Technical Services.
- Not recommended for metal substrates.

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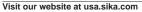
Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800 Fax: 52 442 2250537

C.P. 76920

Carretera Libre Celaya Km. 8.5



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**RESPONSIBLE CARI** 



Product Data Sheet Edition 6.23.2016 Sikalastic<sup>®</sup> EP Primer/Sealer





# Sikalastic<sup>®</sup> EP Primer/Sealer

Two component universal primer

Description	Sikalastic <sup>®</sup> Epoxy Primer consists of two components: an epoxy resin (Part A), and an activator (Part B). In its wet mixed state, it is red in color.
Where to Use	Suitable for use on most sound substrate surfaces where both a penetrative and surface-lying effect is required.
Advantage	<ul><li>Low odor, low VOC formulation.</li><li>Compatible with most common substrate and flashing materials.</li></ul>
Coverage	<ul> <li>250 ft²/gal on non-absorbent smooth substrates.</li> <li>200 ft²/gal on prepared, dry concrete.</li> <li>100 ft²/gal on mineral surfaced modified bitumen.</li> <li>Note: Rough, porous, or absorbent surfaces will require additional primer and will reduce yield.</li> </ul>
Cure Mechanism	Chemical Cure.
Chemical Resistance	Not intended for direct exposure.
Packaging	1 gal. kit (0.75 gal. Part A, 0.25 gal. Part B).

Typical Data (Material and curing conditions @ 75°F (24°C) and 50% R.H.) RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	12 months in original, unopened and undamaged sealed containers.
Storage Conditions:	Store dry at 40°-95°F (2°-35°C).
Product Conditioning:	Condition material to 50°-77°F (10°-25°C) before using for ease of application.
Pot Life:	1 hour
Total Volume Solids (ASTM D-2697)	92%
VOCs (ASTM D-2369-81)	72.05 g/l
Flash Point	130°F (54°C)
Service Temperature	-22° to 176°F (-30° to 80°C) intermittent.

How to Use Surface Preparation	All substrate surfaces shall be clean, dry and sound. Acceptable substrates include: sound concrete and ma- sonry, wood and plywood, modified bitumen membrane, mineralized asphaltic cap sheet, asphalt and asphalt mastic, ferrous metals, galvanized, lead, copper, aluminum, brass, and stainless steel. Reference separate System Data Sheet for specific surface preparation requirements.
Mixing	Mix ratio is 3:1 (A:B) by weight and volume. Add Part B into Part A and mix with stir stick or mechanical mixer (Jiffy) at low speed. Avoid adding air into the primer during mixing. When fully mixed, the primer should be free from streaks and of a uniform red color. Do not break down kits into smaller quantities.
Application	Apply by brush or phenolic resin core roller at the recommended rate. Correct amount of primer will saturate the substrate and leave a slight film on the substrate top surface. Apply evenly without puddling.
Removal	Remove wet primer with MEK, xylene, or oxygenated solvents. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use.
Over Painting	Allow primer to cure completely prior to applying membrane resin. Full cure: 9 hours at 68°F. Ideally, membrane resin will be applied within 24 hours of primer application. Maximum primer exposure is 72 hours. Primer exposed longer than 72 hours, and primer exposed to water during curing and exhibiting a chalky appearance, must be reprimed. Deteriorated primer must be mechanically removed before primer reapplication.



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- To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.
- Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C).
- Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex<sup>®</sup> Concrete Moisture Encounter Meter.
- Minimum age of concrete must be 21-28 days depending on curing and drying conditions.
- Do not thin with solvents.
- Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.
- Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D-4263 (Polyethylene Sheet method).
- Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.
- On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing may occur.
- Precautions should be taken to prevent vapors and/or odors from entering the building/structure, including but not limited to turning off and sealing air intake vents and through-wall air conditioners, and other means of ingress during application and cure.
- Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.
- When applying over existing coatings or membranes compatibility and adhesion testing, subsequent approval by Technical Services is required.
- On grade concrete decks should not be covered with Sikalastic<sup>®</sup> membrane systems.
- Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete overlays should not be covered with Sikalastic® membrane systems without deck evaluation and subsequent approval by Technical Services.

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

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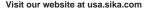
Fracc. Industrial Balvanera

Corregidora, Queretaro

Phone: 52 442 2385800

.P. 76920

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**RESPONSIBLE CARI** 



Product Data Sheet Edition 5.20.2014 Sika® Reactivation Primer

# Sika<sup>®</sup> Reactivation Primer

Polyurethane-based primer for use with Sikalastic 600 Series liquid applied membranes

Description	Sikalastic Reactivation Primer is a single component, polyurethane based primer for the reactivation of existing Sikalastic membranes prior to overcoating, repairing, or modifying. In its wet state, it is clear.	
Where to Use	Suitable for use on Sikalastic 600 Series liquid applied membranes for localized repairs, roofing modifications, continuation of work, etc.	
Advantages	Provides excellent adhesion of new Sikalastic liquid applied membrane to existing Sikalastic membrane. Quick cure allows same-day membrane application in most instances.	
Coverage	250 sf/gal.	
Cure Mechanism	Evaporative cure	
Chemical Resistance	Not intended for direct exposure	
Packaging	2 gal. pail	

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.) Results MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE,

APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	6 months in original, unopened and undamaged sealed containers.
Product Storage:	Store dry at 41-86°F (5-30°C).
Product Conditioning:	Condition material to 50-77°F (10-25°C) before using for ease of application.
Pot Life:	Indefinite
Total Volume Solids (ASTM D-2697):	64%
Density:	1.03 kg/l
VOCs (ASTM D-2369-81):	385 g/l
Flash Point:	108°F (42°C)
Service Temperature:	-22 to 176°F (-30 to 80°C) intermittent



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	How to Use Surface Preparation	Clean existing membrane thoroughly by power washing. Remove all chalking, dirt and any other physical or chemical contaminants prior to priming. Mechanical scrubbing and the use of a biocide-detergent may be required. Rinse all contaminants and detergent residue off of the membrane surface and allow to dry thoroughly.
	Mixing	Mixing is not required
	Application	Apply by brush or phenolic resin core roller at the recommended rate. Correct amount of primer will leave a slight film on the membrane top surface. Apply evenly without puddling.
	Removal	Remove wet primer with MEK, xylene or oxygenated solvents and a clean cloth. Once cured, primer can only be removed by mechanical means. Strictly follow solvent manufacturer's warnings and instructions for use.
	Over Painting	Allow primer to cure completely tack free prior to applying membrane resin. 4 hours at 68°F 6 hours at 37°F Ideally, membrane resin will be applied within 24 hours of primer application. Maximum primer exposure is 48 hours. Primer exposed longer than 48 hours, and primer exposed to water during curing and exhibiting a chalky appearance, must be reprimed. Deteriorated primer must be mechanically removed before primer reapplication.
Construction	Limitations	<ul> <li>To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>Minimum ambient and substrate temperature during application and curing of material is 41°F (5°C); maximum is 86°F (30°C).</li> <li>Do not thin with additional solvents.</li> <li>Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>Existing membrane must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the membrane to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>Sikalastic Recoat Primer is not UV-stable; recoat with Sikalastic resin within 48 hours.</li> <li>Precautions should be taken to prevent vapors and/or odors from entering the building/ structure, including but not limited to turning off and sealing air intake vents and throughwall air conditioners, and other means of vapor/odor ingress during application and cure.</li> </ul>
		PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.
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# **G** - Building Envelope

Sikagard 530	G10
Sikagard 535	G20
Sika Membran 540	G30
SikaMultiSeal Plus	G40
Sikagard 510	usa.sika.com
SikaMultiSeal 515	usa.sika.com



**BUILDING TRUST** 



**Product Data Sheet** Edition 12.6.2013 Sikagard 530



**Sikagard<sup>®</sup> 530** Liquid Applied Acrylic Vapor Permeable Air Barrier

Description	Sikagard 530 Liquid Applied Acrylic Vapor Permeable Air Barrier is a low VOC, sin- gle-component liquid applied, elastomeric membrane designed to provide a vapor permeable air and water barrier when applied to above-grade wall assemblies. It is acrylic-based and cures to a tough monolithic rubber-like membrane that resists air leakage and water penetration when applied to plywood and gypsum sheathing, concrete and concrete masonry units.		
Where to Use	To be used in conjunction with SikaMultiSeal® 515 Self-Adhered Transition Seam Tape and Sikaflex® 11fc Liquid Seam Sealant. Acceptable substrates are above grade exterior wall substrates including precast concrete, cast-in place concrete, concrete block, primed steel, aluminum mill finish, anodized aluminum, galvanized metal, gypsum board and wood. Sikagard 530 Liquid Applied Acrylic Vapor Permeable Air Barrier is appropriate for use at the wall to roof connection in conjunction with Sarnafil Roofing Systems. Consult with Sika Technical Services for details and Warranty Requirements.		
Advantages	<ul> <li>Easy to install, cost effective spray equipment.</li> <li>Passes ASTM E 2357.</li> <li>UV Stable for 6 month exposite</li> </ul>	brane for above grade wall applications. brush, roller or spray application using common sure. ws wall assemblies to dry out.	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> </ul>	standards to control air movement. teristics as appropriate for compliance with NFPA	
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	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condenses)</li> <li>RESULTS MAY DIFFER BASED UPON STATISTICE EQUIPMENT, TEMPERATURE, APPLICATION METHING CONDITIONS.</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND         THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)         < 0.04 cfm/sf @ 1.56 psf (pass ABAA)         11.5 perms         Pass         Pass         Pass         Pass	
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	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)         < 0.04 cfm/sf @ 1.56 psf (pass ABAA)         11.5 perms         Pass         Pass         Pass         Pass         124%         300 psi	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condensity of the conden</li></ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)         < 0.04 cfm/sf @ 1.56 psf (pass ABAA)         11.5 perms         Pass         Pass         Pass         124%         300 psi         Sets to Touch: 4 – 6 hours	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> <li>Dry Time:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)         < 0.04 cfm/sf @ 1.56 psf (pass ABAA)         < 0.04 cfm/sf @ 1.56 psf (pass ABAA)         11.5 perms         Pass         Pass         Pass         Pass         Store to Touch: 4 – 6 hours         Recoat: 24 hours	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Storage:</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> <li>Dry Time:</li> <li>Exposure:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> <li>Dry Time:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condered and content of the second structure)</li> <li>RESULTS MAY DIFFER BASED UPON STATISTIC/ EQUIPMENT, TEMPERATURE, APPLICATION METAING CONDITIONS.</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 968:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> <li>Dry Time:</li> <li>Exposure:</li> <li>Surface Burning Characteristics ASTM E 84</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)	
	<ul> <li>Meets industry performance</li> <li>Low surface burning charact 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Typical Data (Material and curing condent 285</li> <li>Storage:</li> <li>Storage:</li> <li>Shelf Life:</li> <li>Properties:</li> <li>Air Permeance ASTM E2178:</li> <li>System Air Leakage ASTM 2357:</li> <li>WVP ASTM E 96B:</li> <li>Crack Bridging/Freeze-Thaw ICC-ES AC212:</li> <li>Water Resistance AATCC 127:</li> <li>Fastener Sealability ASTM D1970:</li> <li>Initial Elongation:</li> <li>Initial Tensile Strength:</li> <li>Dry Time:</li> <li>Exposure:</li> </ul>	standards to control air movement.         teristics as appropriate for compliance with NFPA         ditions @ 74°F (22°C) and 40% R.H.)         AL VARIATIONS DEPENDING UPON MIXING METHODS AND THODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CUR-         Store in original containers. Store at temperatures above 40°F (4°C), do not allow product to freeze.         Minimum 1 year in unopened containers.         < 0.004 cfm/sf @ 1.57 psf (pass ABAA)	

SIKA PRODUCT, THE USER MUST ALWAYS READ AND OF ANY INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.



		64 %
	Solids by Weight: Solids by Volume:	52% +/- 2%
	Vehicle Base:	Acrylic
	Solvent:	Water
	Clean up:	Warm soapy water
	Apply at a rate of 2.5 galland	a par 100 ft2 (10 of par gallon) to aphieur a uniform wat
Coverage	film thickness of 40 mils.	s per 100 ft <sup>2</sup> (40 sf per gallon) to achieve a uniform wet
Packaging	5 gallon pails, 55 gallon drur	ns
How to Use		
Surface Preparatio	grease, oil, contaminants or adhesion of the liquid applied Surfaces should be sound, for concrete should be cured for Applied Acrylic Vapor Perme precast concrete, cast-in pla mill finish, anodized aluminu between panels of exterior g shall be treated with a 1/16 i application of Sikaflex 11fc L grade gypsum or plywood w of SikaMultiSeal 515 Self-Ac applied to a substrate prime a 10mil thick application of S	an, dry and free of frost, dirt, dust, loose concrete, other foreign matter that may adversely affect the d vapor permeable air and water barrier membrane. ree of voids, gaps, breaks and spalled areas. New r a minimum of 7 days before Sikagard 530 Liquid able Air Barrier is applied. Acceptable substrates are ce concrete, concrete block, primed steel, aluminum m, galvanized metal, gypsum board and wood. Joints rade gypsum and plywood up to 1/4 inch (6 mm) wide nch (3 mm) deep x 3/4 inch (19 mm) wide cap bead iquid Seam Sealant. Joints between panels of exterior ider than 1/4 inch (6 mm) shall be sealed with a strip lhered Transition Seam Tape aligned over the joint and d with Sikagard 510 Transition Seam Tape Primer or Sikagard 530 (refer to SikaMultiSeal 515 Product Data recommendations). Strike masonry mortar joints full
	Cracks in masonry and conc a cap bead application of Sil and concrete up to 1/8 inch liquid air barrier membrane a	crete up to 1/4 inch (6 mm) wide shall be sealed with kaflex 11fc Liquid Seam Sealant. Cracks in masonry (3 mm) wide may be filled with a trowel application of and allowed to cure overnight prior to field application brane to surface. Cracks wider than 1/4 inch should be
	door frames and openings, e Self-Adhered Transition Sea substrate. Provide minimum adjacent surface. Apply Sika 530 applied at 40 mils thickn tiSeal 515. Mechanical faste sheathing boards prior to me	similar materials at beams, columns, window and etc., should be sealed with a strip of SikaMultiSeal 515 m Tape aligned over the joint and applied to a primed of 2 1/2 inches (63 mm) of membrane bearing on each flex 11fc Liquid Seam Sealant or coating of Sikagard less over the edge along the perimeter of SikaMul- ners used to secure sheathing boards or penetrate embrane application shall be set flush with sheathing d backing. Thinning of the liquid membrane is not per-
Mixing	Stir liquid membrane thoroug	ghly prior to application.
Application	brush, roller or spray. Applica single or dual-coat application brane in a continuous, monol of permeable air and water ba mil thickness and avoid creat ings and mechanical penetra	Acrylic Vapor Permeable Air Barrier may be applied by tion by conventional air assisted spray equipment in a n is the preferred method. Apply liquid air barrier mem- ithic application pattern to achieve a uniform coating arrier membrane. Monitor applications to measure wet ing sags or runs. Pretreat outside corners, wall open- tions with SikaMultiSeal 515 Self-Adhered Transition parrier membrane to fully cover transition membrane
ka®	INSTRUCTIONS ON THE PRODUCT'S MOS WHICH ARE AVAILABLE ONLINE AT HTTF AT 800-933-7452. NOTHING CONTAINED AND FOLLOW THE WARNINGS AND INST	DUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AND T CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET P://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO READ RUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUCT STY DATA SHEET PRIOR TO PRODUCT USE.

	Tie-in to structural beams, columns, floor slabs and intermittent floors, parapet curbs, foundation walls, roofing systems and at the interface of dissimilar materials with SikaMultiSeal 515 Self-Adhered Transition Seam Tape and or approved flash- ing membrane. Mark areas off and ensure that the appropriate volume has been applied over each area. During spraying, the product should be applied in horizontal strokes, then vertical strokes in a cross-hatch method to ensure even application. Spray applications must be immediately back-rolled. Protect wall areas covered with Sikagard 530 Liquid Applied Acrylic Vapor Perme- able Air Barrier from damage due to construction activities, high wind conditions, and extended exposure to inclement weather. Review condition of Sikagard 530 Liquid Applied Acrylic Vapor Permeable Air Barrier prior to installation of cladding. Ai Repair, or remove and replace damaged sections with new membrane. Recommend to cap and protect exposed back-up walls against wet weather conditions during and after application of membrane, including wall openings and construction activity above completed water-resistive vapor permeable air barrier installations.
Limitations	Apply at temperatures over 40°F (4°C). Do not apply when rain is forecast within the next 12 hours. Limit exposure to no greater than 6 months.
Caution	<b>CAUTION: IRRITANT.</b> Contains Propyleneglycol (CAS: 57-55-6), titanium dioxide (CAS: 13463-67-7) and glass, oxide, chemicals (CAS:65997-17-3). May cause eye/ skin/respiratory irritation. May cause gastrointestinal disturbance if swallowed.
First Aid	<b>Eyes</b> – Hold eyelids apart and flush thoroughly with water for 15 minutes. <b>Skin</b> – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. <b>Inhalation</b> – Remove to fresh air. <b>Ingestion</b> – Do not induce vomiting. Dilute with water. Contact physician. <b>In all cases contact a physician immediately if</b> <b>symptoms persist</b> .
Handling and Storage	Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.
Cleanup	Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, sweep up spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with ap- plicable local, state, and federal regulations.

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Sika Corporation 201 Polito Avenue Lyndhurst, NJ 07071 Phone: 800-933-7452 Fax: 201-933-6225

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Sika Canada Inc. 601 Delmar Avenue Pointe Claire Quebec H9R 4A9 Phone: 514-697-2610 Fax: 514-694-2792

Sika Mexicana S.A. de C.V. Carretera Libre Celaya Km. 8.5 Fracc. Industrial Balvanera Corregidora, Queretaro C.P. 76920 Phone: 52 442 2385800 Fax: 52 442 2250537



Product Data Sheet Edition 7.25.2014 Sikagard 535

# **Sikagard® 535** Liquid Applied Acrylic Vapor Permeable Air Barrier

Description	Sikagard 535 Liquid Applied Acrylic Vapor Permeable Air Barrier is a low VOC, single-component liquid applied, elastomeric membrane designed to provide a vapor permeable air and water barrier when applied to above-grade wall assemblies. It is acrylic-based and cures to a tough monolithic rubber-like membrane that resists air leakage and water penetration when applied to plywood and gypsum sheathing, concrete and concrete masonry units.		
Where to Use	To be used in conjunction with SikaMultiSeal® 515 Self-Adhered Transition Seam Tape and Sikaflex® 11FC. Acceptable substrates are above grade exterior wall substrates including precast concrete, cast-in place concrete, concrete block, primed steel, alu- minum mill finish, anodized aluminum, galvanized metal, gypsum board and wood.		
Advantages	<ul> <li>Easy to install, cost effective spray equipment.</li> <li>UV Stable for 6 month exp</li> <li>Water vapor permeance a</li> <li>Excellent adhesion to com</li> <li>Meets industry performance</li> </ul>	<ul> <li>Low odor, low VOC.</li> <li>Seamless, elastomeric membrane for above grade wall applications.</li> <li>Easy to install, cost effective brush, roller or spray application using common spray equipment.</li> <li>UV Stable for 6 month exposure.</li> <li>Water vapor permeance allows wall assemblies to dry out.</li> <li>Excellent adhesion to common construction surfaces.</li> <li>Meets industry performance standards to control aimovement.</li> <li>Low surface burning characteristics as appropriate for compliance with NFPA</li> </ul>	
Coverage	Apply at a rate of 100 sf per gal	llon to achieve a uniform wet film thickness of 16 mils.	
Packaging	Apply at a rate of 100 sf per gallon to achieve a uniform wet film thickness of 16 mils.		
		nditions @ 73°F (23°C) and 50% R.H.) ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,	
	Typical Data (Material and curing co. RESULTS MAY DIFFER BASED UPON STATISTICAL V/ TEMPERATURE, APPLICATION METHODS, TEST ME Storage: Shelf Life: Air Permeance ASTM E2178 (CFM/ft2): WVP ASTM E 96B:	nditions @ 73°F (23°C) and 50% R.H.) ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Store in original containers. Store dry at 40°F - 90°F (4°C - 35°C), do not allow product to freeze. 2 years in unopened containers. 0.0001 12 perms	
	Typical Data (Material and curing co. RESULTS MAY DIFFER BASED UPON STATISTICAL V/ TEMPERATURE, APPLICATION METHODS, TEST ME Storage: Shelf Life: Air Permeance ASTM E2178 (CFM/ft2):	nditions @ 73°F (23°C) and 50% R.H.) ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, THODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS. Store in original containers. Store dry at 40°F - 90°F (4°C - 35°C), do not allow product to freeze. 2 years in unopened containers. 0.0001	
	Typical Data (Material and curing co RESULTS MAY DIFFER BASED UPON STATISTICAL V/ TEMPERATURE, APPLICATION METHODS, TEST ME Storage: Shelf Life: Air Permeance ASTM E2178 (CFM/ft2): WVP ASTM E 96B: Water Resistance AATCC 127: Fastener Sealability D1970: Elongation at break ASTM D412: Tensile Strength ASTM D412: Dry Time: Exposure: Surface Burning Characteristics ASTM E 84	Anditions @ 73°F (23°C) and 50% R.H.)         ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,         THODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Store in original containers. Store dry at 40°F - 90°F (4°C - 35°C),         do not allow product to freeze.         2 years in unopened containers.         0.0001         12 perms         Pass         100%         175 psi         Sets to Touch: 6 - 12 hours         Recoat: 6 - 12 hours         6 months         Flame Spread: 5         Smoke Development Index: 5         Class Rating: A	
	Typical Data (Material and curing co. RESULTS MAY DIFFER BASED UPON STATISTICAL V/ TEMPERATURE, APPLICATION METHODS, TEST ME Storage: Shelf Life: Air Permeance ASTM E2178 (CFM/ft2): WVP ASTM E 96B: Water Resistance AATCC 127: Fastener Sealability D1970: Elongation at break ASTM D412: Tensile Strength ASTM D412: Dry Time: Exposure:	Anditions @ 73°F (23°C) and 50% R.H.)         ARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT,         THODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.         Store in original containers. Store dry at 40°F - 90°F (4°C - 35°C),         do not allow product to freeze.         2 years in unopened containers.         0.0001         12 perms         Pass         100%         175 psi         Sets to Touch: 6 - 12 hours         Recoat: 6 - 12 hours         6 months         Flame Spread: 5         Smoke Development Index: 5	

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How to Use	
Surface Preparation	Surfaces must be sound, clean, dry and free of frost, dirt, dust, loose concrete, grease oil, contaminants or other foreign matter that may adversely affect the adhesion of the liquid applied vapor permeable air and water barrier membrane. Surfaces should be sound, free of voids, gaps, breaks and spalled areas. New concrete should be cured for a minimum of 14 days before Sikagard 535 Liquid Applied Acrylic Vapor Permeable A Barrier is applied. Acceptable substrates are precast concrete, cast-in place concrete concrete block, primed steel, aluminum mill finish, anodized aluminum, galvanized metal, gypsum board and wood. Joints between panels of exterior grade gypsum ar plywood up to 1/4 inch (6 mm) wide shall be treated with a 1/16 inch (3 mm) deep 3/4 inch (19 mm) wide cap bead application of Sikaflex 11FC. Joints between pane of exterior grade gypsum or plywood wider than 1/4 inch (6 mm) shall be sealed wit a strip of SikaMultiSeal 515 Self-Adhered Transition Seam Tape aligned over the join and applied to a substrate primed with Sikagard 510 Transition Seam Tape Prime Apply sufficient pressure to self-adhered transition seam tape to ensure adhesion for substrate. Strike masonry mortar joints full flush. Cracks in masonry and concret up to 1/4 inch (6 mm) wide shall be sealed with a cap bead application of Sikafle 11FC. Cracks in masonry and concrete up to 1/8 inch (3 mm) wide may be filled wit a trowel application of liquid air barrier mem- brane and allowed to cure overnig prior to field application of the liquid air barrier membrane to surface. Cracks wide than 1/4 inch should be repointed.
	Transition joints between dissimilar materials at beams, columns, window and do frames, etc., should be sealed with a strip of SikaMultiSeal 515 Self-Adhered Transition Seam Tape aligned over the joint and applied to a substrate primed with Sikaga 510 Transition Seam Tape Primer. Apply sufficient pressure to self- adhered transition seam tape to ensure adhesion to substrate. Provide minimum of 2 1/2 inches (6 mm) of membrane bearing on each adjacent surface. Mechanical fasteners used secure sheathing boards or penetrate sheathing boards prior to membrane applic tion shall be set flush with sheathing board and fastened into solid backing. Thinnir of the liquid membrane is not permitted.
Mixing	Stir liquid membrane thoroughly prior to application.
Application	Sikagard 535 Liquid Applied Acrylic Vapor Permeable Air Barrier may be applied to brush, roller or spray. Application by conventional air assisted spray equipment in single or dual-coat application is the preferred method. Apply liquid air barrier mer brane in a continuous, monolithic application pattern to achieve a uniform coating permeable air and water barrier membrane. Monitor applications to measure wet no thickness and avoid creating sags or runs. Pretreat outside corners, wall open- ing and mechanical penetrations with SikaMultiSeal 515 Self-Adhered Transition Sea Tape. Apply liquid air barrier membrane to fully cover transition membrane applic tions.
	Tie-in to structural beams, columns, floor slabs and intermittent floors, parapet curb foundation walls, roofing systems and at the interface of dissimilar materials wi SikaMultiSeal 515 Self-Adhered Transition Seam Tape and or approved flash- ir membrane.
	Mark areas off and ensure that the appropriate volume has been applied over ead area. During spraying, the product should be applied in horizontal strokes, then ver cal strokes in a cross-hatch method to ensure even application. Spray applica- tior must be immediately back-rolled. Protect wall areas covered with Sikagard 535 Liqu Applied Acrylic Vapor Perme- able Air Barrier from damage due to construction a tivities, high wind conditions, and extended exposure to inclement weather. Revie condition of Sikagard 535
	Liquid Applied Acrylic Vapor Permeable Air Barrier prior to installation of claddin Repair, or remove and replace damaged sections with new membrane. Recom- mer to cap and protect exposed back-up walls against wet weather conditions during ar after application of membrane, including wall openings and construction activity above completed water-resistive vapor permeable air barrier installations.
ka ®	PRIOR TO EACH USE OF ANY SIKA PRODUCT, THE USER MUST ALWAYS READ AND FOLLOW THE WARNINGS AN INSTRUCTIONS ON THE PRODUCT'S MOST CURRENT PRODUCT DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHE WHICH ARE AVAILABLE ONLINE AT HTTP://USA.SIKA.COM/ OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMEN AT 800-933-7452. NOTHING CONTAINED IN ANY SIKA MATERIALS RELIEVES THE USER OF THE OBLIGATION TO REA AND FOLLOW THE WARNINGS AND INSTRUCTION FOR EACH SIKA PRODUCT AS SET FORTH IN THE CURRENT PRODUC DATA SHEET, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

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Limitations	<ul> <li>Minimum age of SikaTop or MonoTop prior to application is three days, de- pending on curing and drying conditions (moisture content must be below 5%)</li> </ul>
	Sikagard 535 should not be applied at relative humidity greater than 90%, or if rain is forecast within the specified rain resistance period
	When over-coating existing coatings, compatibility and adhesion testing is recommended
	Do not store Sikagard 535 in direct sunlight for prolonged periods
	Strong winds can cause shrinkage if material is applied at lower temperatures
	Not recommended for roofing

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Product Data Sheet Edition 09.10.2015 SikaMembran<sup>®</sup>-540

# SikaMembran<sup>®</sup>-540 Self-Adhesive Air / Vapor Barrier

Description	SikaMembran-540 is a self-adhering sheet membrane consisting of an engineered block-copolymer adhesive on a durable, conformable polypropylene film. The membrane is designed to be adhered to a variety of substrates and is available in rolls of various widths which may be used for full wall applications or as a penetration/flashing membrane used with other Sika air barrier systems.		
Where to Use	SikaMembran-540 is designed to be used in above-grade wall assemblies including concrete, concrete masonry units (CMU), plywood, OSB and exterior gypsum sheathing. Other applications include transition tape application for door, window and other openings and to connect the air barrier to the door, window or other penetration.		
Advantages	<ul><li>Compatible with Sikagard lique</li><li>Tough film that resists puncture</li></ul>	<ul> <li>Fully bonded</li> <li>Waterproof and airtight</li> <li>Excellent adhesion to a variety of substrates</li> <li>Compatible with Sikagard liquid air barriers</li> <li>Tough film that resists punctures and tears</li> <li>Conforms to irregular surfaces</li> </ul>	
Packaging	36" width by 75 ft. roll, 1 roll per box 18" width by 75 ft. roll, 2 rolls per box 12" width by 75 ft. roll, 3 rolls per box 6" width by 75 ft. roll, 6 rolls per box 4" width by 75 ft. roll, 9 rolls per box		
	Typical Data (Material and curing condit	tions @ $74^{\circ}E(22^{\circ}C)$ and $40\% BH$	
		VARIATIONS DEPENDING UPON MIXING METHODS	
	Storage:	Store pallets under cover at temperatures between 40°F and 100°F	
	Shelf Life:	1 year in original packaging at recommended storage conditions	
	Application Temperature Range:	min. 40°F and rising	
	Service Temperature Range:	min20 °F max. 150 °F	
	Maximum Exposure to UV:	Cover within 60 days	
	Thickness:	8 mils	
	Air Permeance (ASTM E 2178)	pass(<0.001 cfm)	
	Resistance to Puncture (ASTM E 154)	>40 lb <sub>f</sub>	
	Tensile Strength (ASTM D 882)	20lb,/in. (break factor) (Tensile Strength 2,000 psi)	
	Elongation (ASTM D 882)	400%	
	Water Resistance (AATCC 127)	pass	
	Peel Strength (ASTM D 903)	Concrete = 5.5 lb <sub>r</sub> /in. Fiberglass Sheathing = 6.0 lb <sub>r</sub> /in.	
	Lap Adhesion (ASTM D 3330)	Concrete = 2.0 lb <sub>/</sub> /in. Fiberglass Sheathing = 2.5 lb <sub>/</sub> /in.	
	Lap Adhesion (ASTM D 1876)	7.0 lb/in.	
	Low Temperature Flexibility (ASTM D 1970)	pass	
	Self Sealability (ASTM D 1970)	pass	
	Pull Adhesion (ASTM D 4541)	Fiberglass Sheathing = 16 lb <sub>/</sub> in.	
	Tear Initiation and Propagation (ASTM D 4073)	20lb <sub>f</sub>	
	Crack Bridging (ASTM 1305)	pass	
	Water Vapor Permeance (ASTM E 96) Me	ethod A(desiccant) = 0.09 perms Method B(water) = 0.13 perms	



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How to Use	
Surface Preparation	Acceptable substrates include concrete, concrete masonry units, primed steel, aluminum, mill finish, anodized aluminum, galvanized metal, exterior gypsum board and wood. Primer may be required for CMU or if adhesion is inadequate on substrates due to surface conditions beyond the control of the installer. Sika Latex R may be used for priming if required. Surfaces must be sound, clean, dry and free of frost, dirt, dust, loose concrete, grease
	oil, contaminants or other foreign matter that may adversely affect the adhesion of the membrane. Surfaces should be free of voids, gaps, breaks and spalls. New concrete should cure a minimum of 7 days, masonry mortar joints should be full and flush holes or cracks greater than ¼" should be filled in with an appropriate mortar if static or with a suitable sealant or filler if required to move. Gypsum, plywood and OSE sheathing boards shall be properly fastened, flush at the joints with gaps according to building codes and sheathing board manufacturer.
	Moisture content should be checked using a Tramex <sup>®</sup> moisture meter with a 4% maximum allowable measurement.
Application	Horizontal applications should start at the bottom and proceed upward, offset verti- cal seams 12". Vertical applications should start at the top and unroll the membrane down the wall, offset horizontal seams 12". Lap at all seams should be 2". Sequence the installation, including detailing at wall openings such as windows and doors, to provide a continuous install with shingled laps.
	Cut membrane to a manageable length and position for alignment. Remove protective film and press firmly into place avoiding wrinkles and air pockets. Go over recently installed sheet with a hand roller in order to ensure continuous and intimate contact with the substrate.
	For masonry ties and anchors use the 18" wide sheet. Run the upper edge of the membrane along the underside of the tie or anchor. Working up the wall, install the next sheet in a similar manner. The 18" membrane will overlap the membrane below by 2" and will require a slot or cut at each tie or anchor at the bottom of the sheet in order to be fully laid in place. Seal the penetration using Sikaflex 11fc.
	Seal leading edges susceptible to moisture ingress such as non water leading edges and edges resulting from partially completed walls at the end of a day, with Sikaflex 11fc.
	Coordinate installation with the roofing trade to ensure continuity between the root and air barrier systems.
	Protect membrane from damage and do not cover until inspected according to the project requirements. Make repairs to the membrane using SikaMembran-540. Extend beyond the damage by at least 3". Seal the edges of the patch with Sikaflex 11fc.
	Adhesion tests should be carried out before the project install commences and should be checked periodically at least once per day on each substrate type throughout the project installation to verify proper adhesion and application.
Limitations	<ul> <li>SikaMembran-540 is a vapor barrier. Design professional shall determine appropriate use in project wall assemblies.</li> </ul>
	Maximum permitted exposure is 60 days.
	Do not install on roofs.



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# Sika<sup>®</sup> MultiSeal Plus

High Tack Ethylene Propylene Copolymer Self-Adhering Tape and Flashing Sheet with UV Resistant TPO Top Film Membrane

**Technical Product Data (typical values)** \*Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

Chemical base		Ethylene Propylene Copolymer
Mastic Color		Gray
UV Resistant TPO Top-Film Membrane Colors		White, Gray
Total Thickness		37 mil (nominal) (TPO Top-Film Membrane Thickness = 5 mil)
Total solids (ASTM C 771)		100 %
Penetration (ASTM D 217) (mastic only) +/- 2°F/ 300 gr.	cone at 77°F	84 to 110 (8.4 to 11.0 mm)
Flexibility (ASTM C 765)		No cracking or loss of adhesion at - 22°F (-30°C) when bent around 3/8" mandrel (9.5mm)
Elongation <sup>1</sup> (ASTM D-412)		700 % minimum
Membrane Tensile Strength (ASTM D412)		3800 psi
Vehicle bleed out (ASTM C 772)	158°F (70°C) for 21 days	No exudation of vehicle on Whatman No.40 filter paper.
Tensile adhesive strength <sup>1</sup> (ASTM C 907)		13 psi (typical failure mode 100% cohesive)
Measured Flow (ASTM D5147)	Pass	
Low Temperature Flexibility -22°F (30°C) (CGSB 37-GI	Pass	
Moisture Absorption (ASTM D903)		Pass (1g absorption)
Application Temperature	Standard Applications Thru-Wall Applications	40°F to 90°F (4°C to 32°C) 25°F to 90°F (-4°C to 32°C)
Adhesion to Concrete (ASTM D903)		6 lbf/in
Adhesion to DensGlass <sup>®</sup> Gold (ASTM D903)		6 lbf/in
Weatherability (ASTM G 53) (1000 h exposure)		Excellent condition; no loss of adhesion flexibility or softness, no loss of rubbery characteristics.
Service temperature	permanent	-22°F to 180°F (-30°C to 82°C)
Shelf life (storage below 80°F (27°C))		18 months

<sup>1)</sup> 77°F (25°C)

# Description

Sika<sup>®</sup> MultiSeal Plus Ethylene Propylene Copolymer Tape and Flashing Sheet is a high performance, industrial grade selfadhered tape & flashing sheet. Sika<sup>®</sup> MultiSeal Plus consists of a non-release UV resistant TPO top film membrane laminated to at high tack, non-drying and non-hardening reinforced rubber compound with inert inorganic, non-asbestos fillers. It is specially designed for use as a waterproof barrier and thru-wall flashing membrane.

Sika MultiSeal<sup>®</sup> has superior weathering characteristics and retains adhesion and elasticity for prolonged periods. Sika<sup>®</sup> MultiSeal Plus is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the Responsible Care Program.

# **Product Benefits**

- Very tacky adhesion
- Good green strength
- Adheres to a variety of substrates
- Low VOC's
- Almost odorless
- Can be laminated to a variety of
- Substrates for diverse applications
   Wide temperature service range
- Tough, durable tear-resistant, UV resistance, flexible membrane
- Priming is not required on concrete or Densglass<sup>®</sup> Gold





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# Areas of Application

Sika<sup>®</sup> MultiSeal Plus Tape & Flashing Sheet is specifically formulated to seal joints and provide a waterproof barrier when applied prepared substrates. over Acceptable substrates include EPDM, TPO, metals, Kynar steel, and substrates typically found on trailers, RV's, trucks, metal buildings, storage tanks, HVAC cabinets and duct work. Sika  $^{\!\!\mathrm{R}}$  This product is not recommended for sealing PVC sheeting. MultiSeal Plus Tape & Flashing Sheet is also intended to be used as a thru-wall flashing membrane in cavity wall construction when used in conjunction with Sikagard 530 and other Sika Liquid Applied Vapor Permeable Air Barrier Systems. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed by the end user to ensure adhesion, function, durability, and material compatibility. Applications involving water immersion may require special substrate pre-treatment. See the Limitation section.

# **Chemical Resistance**

Excellent resistance to water, ozonated water, water vapor and alcohols. Fair to weak resistance for acids and bases. Poor resistance to organic solvents. The above information is offered for general guidance only. Advice on specific applications will be given on request.

# **Method of Application**

## Repair Tape

Specific advise on use as a repair tape only is available from the Technical Service Department of Sika Industry at tsmh@sika.us.com.

# Thru-Wall Application

Acceptable substrates are precast concrete, cast-in place concrete,



Sika<sup>®</sup> MultiSeal Plus Tape & Flashing Sheet is designed for permanent exposure and may be installed direct to concrete or Densglass Gold without the aid of primers other or surface conditioners. Alternatively, Sikagard<sup>®</sup> 510 or Sikagard<sup>®</sup> 530 may be used for priming. Applications to wood require the use of Sikagard<sup>®</sup> 510 or Sikgard<sup>®</sup> 530 as a primer. Material should be conditioned at room temperature for ease of application. Cut the desired length of Sika<sup>®</sup> MultiSeal Plus Tape & Flashing Sheet, remove release paper, position into place and apply positive pressure using a roller. Use care to avoid blisters or wrinkles. Overlap all joints by 2 inches. Keep Sika<sup>®</sup> MultiSeal Plus Tape & Flashing Sheet back about 1/2 inch from outside face of wall or veneer. At all laps, seams, penetrations, and along top edges of membrane apply a continuous bead of Sikaflex®-11 FC sealant as termination seal. Form end dams as required with same sealant. Apply under dry conditions when air and surface temperatures are above 25 degrees F. Top or leading edge of Sika® MultiSeal Plus Tape & Flashing Sheet should be sealed with a Sikaflex Sealant to limit rainwater from migrating behind the membrane.

Further information available at: www.sikausa.com

Sika Corporation Industry Division 30800 Stephenson Highway Madison Heights, MI 48071 USA Tel. 248 577 0020 Fax 248 577 0810 For further advice on use as a thruwall flashing, contact Sika Technical Services at 1-800-933-SIKA(7452)

# Limitation

Substrate must be clean, dry and free of frost and all contaminants Verify priming requirements before the start of each project.

Applications involving water immersion may require special priming of substrates.

#### Removal

Sika<sup>®</sup> MultiSeal Plus may be removed from tools and equipment with mineral spirit or another suitable solvent. STRICTLY FOLLOW SOLVENT MANUFACTURER'S WARNINGS AND INSTRUCTIONS FOR USE. Following use wash hands with soap and water. Do not use solvents on hands!

# CAUTION: IRRITANT.

Slight Irritant: No respiratory effects known, however may be slightly irritating to the skin and can be a mechanical irritant if contacted with eye. Can cause discomfort if ingested.

# HMIS

Health	1
Flammability	1
Reactivity	0
Personal Protection	В

## **First Aid Measures**

Wash with soap and water if skin irritation develops. Guard against further contact. Rinse eyes with water to remove material.

## **Further Information**

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Sika®

data. It is highly recommended to read the actual Safety Data Sheet before using the product.

- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- KEEP CONTAINER TIGHTLY CLOSED

Copies of the following publications are available on our website www.sikausa.com:

- Safety Data Sheets
- Product Data Sheet

#### In case of emergency call: Chemtrec: 800-424-9300 International: 703-527-3887

#### **Packaging Information**

Rolls	Multiple sizes
Thru-Wall Packaging	Rolls of 12.5" x 50', 2 rolls per carton, color - white (#410595) Other sizes are available, certain restrictions may apply

#### Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

#### **Clean Up**

Scrape up and put into suitable container. Dispose of in accordance with Federal, State and Local environmental regulations.

#### Limited Material Warranty

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of

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# **H** - Special Additives and Accessories

Rugasol-S SikaFilm SikaLatex SikaLatex R Sikament 100 SC

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## I - Tables and Warranty

Coverage Tables Tables & Estimating Data for Epoxy Mortars Conversions and Conversion Tables Sika Construction Products Warranty



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## **COVERAGE TABLES**

## Coverages for Joint Sealing (Linear feet per specified packaging)

10.1 oz Cartridge: Yield in Linear feet							
	Depth (in.)						
		1/4"	3/8"	1/2"			
	1/4"	24.3					
_	3/8"	16.2	10.8				
	1/2"	12.1	8.1	6.1			
Width	3/4"	8.1	5.4	4.0			
	1"			3.0			
	1.25"			2.4			
	1.5"			2.0			

29 oz Cartridge: Yield in Linear feet					
Depth (in.)					
		1/4"	3/8"	1/2"	
	1/4"	69.8			
	3/8"	46.5	31.0		
	1/2"	34.9	23.3	17.4	
Width	3/4"	3/4" 23.3		11.6	
	1"			8.7	
	1.25"			7.0	
	1.5"			5.8	

20 oz Sausage: Yield in Linear feet						
Depth (in.)						
		1/4"	3/8"	1/2"		
	1/4"	48.1				
	3/8"	32.1	21.4			
	1/2"	24.1	16.0	12.0		
Width	3/4"	16.0	10.7	8.0		
	> 1"			6.0		
	1.25"			4.8		
	1.5"			4.0		

1 gallon: Yield in Linear feet							
	Depth (in.)						
		1/4"	3/8"	1/2"			
	1/4"	307.9					
F	3/8"	205.3	136.8				
	1/2"	153.9	102.6	77.0			
Width	3/4"	3/4" 102.6		51.3			
>	1"			38.5			
	1.25"			30.8			
	1.5"			25.7			

#### (Theoretical) Coverages for Coating or Membranes

Thickness of coating	Coverage per U.S. Gallon
applied (1000 mils = 1 in.)	100% Solids System
1⁄4 in. = 250.000 mils	6.4 sq. ft.
<sup>3</sup> / <sub>16</sub> in. = 187.500 mils	8.5 sq. ft.
¹⁄₃ in. = 125.000 mils	12.8 sq. ft.
100.000 mils	16.0 sq. ft.
¹⁄₁₅ in. = 62.500 mils	25.7 sq. ft.
50.000 mils	32.1 sq. ft.
<sup>1</sup> / <sub>32</sub> in. = 31.250 mils	51.3 sq. ft.
20.000 mils	80.2 sq. ft.
¹/₅₄ in. = 15.625 mils	102.7 sq. ft.
10.000 mils	160.4 sq. ft.
5.000 mils	320.8 sq. ft.
1.000 mils	1604.2 sq. ft.

**Note:** If a coating contains a solvent which will evaporate, the thickness of the coating will be reduced by the same percentage as the solvent loss.

# **TABLES & ESTIMATING DATA FOR EPOXY MORTARS**

#### Epoxy Mortar Yield per Gallon of Epoxy Binder

Epoxy Binder, gal.	Aggregate, gal.*	Mortar, gal.			
1	1	1.6			
1	2	2.2			
1	3	2.8			
1	4	3.4			
1	5 4.0				
*Flint shot approximately 12-14 lb./gal. With other aggregates, figures will vary with mesh size and amount of entrained air.					

#### Coverage per Gallon of Epoxy Mortar

(Epoxy Binder + Sand)

Epoxy Mortar, gal.	Thickness, in.	Coverage, sq. ft.
1	1/16	25.7
1	1/8	12.8
1	3/16	8.6
1	1/4	6.4
1	3/8	4.3
1	1/2	3.2

## 

#### CEMENT

#### **TEMPERATURE**

WATER					
U.S. Gallons	Pounds				
1	8.35				
2	16.69				
3	25.04				
4	33.38				
5	41.73				
6	50.07				
7	58.42				
8	66.76				
9	75.11				
10	83.45				
11	91.80				
12	100.14				
13	108.49				
14	116.83				
15	125.18				
16	133.52				
17	141.87				
18	150.21				
19	158.56				
20	166.90				
21	175.25				
22	183.59				
23	191.94				
24	200.28				
25	208.63				
26	216.97				
27	225.32				
28	233.66				
29	242.01				
30	250.35				
31	258.70				
32	267.04				
33	275.39				
34	283.73				
35	292.08				
36	300.42				
37	308.77				
38	317.11				
39	325.46				
40	333.80				
41	342.15				
42	350.49				
43	358.84				
44	367.18				
45	375.53				

Bags	Pounds
.25	23.5
0.50	47
0.75	70.5
1.00	94
1.25	117.5
1.50	141
1.75	164.5
2.00	188
2.25	211.5
2.50	235
2.75	258.5
3.00	282
3.25	305.5
3.50	329
3.75	352.5
4.00	376
4.25	399.5
4.50	423
4.75	446.5
5.00	470
5.25	493.5
5.50	517
5.75	540.5
6.00	564
6.25	587.5
6.50	611
6.75	634.5
7.00	658
7.25	681.5
7.50	705
7.75	728.5
8.00	752

Fahrenheit	Celsius
0	-17.8
5	-15.0
10	-12.2
15	-9.4
20	-6.7
25	-3.9
30	-1.1
32	0
35	1.7
40	4.4
45	7.2
50	10.0
55	12.8
60	15.6
65	18.3
70	21.1
75	23.9
80	26.7
85	29.4
90	32.2
95	35.0
100	37.8
105	40.6
110	43.3
115	46.1
120	48.9
125	51.7
130	54.4
135	57.2
140	60.0
145	62.8
150	65.6
155	68.3
160	71.1
165	73.9
170	76.7
175	79.4
180	82.2
185	85.0
190	87.8
195	90.6
200	93.3
205	96.1
210	98.9
212	100.0

## **Concrete Mix Design**

Material	US Customary		Multiply by		SI (Metric)		Multiply by		US Customary
Sand, Stone, Cement	lb./yd³	х	0.5933	=	kg/m³	х	1.686	=	lb./yd³
Water	gal./yd³	Х	4.951	=	kg/m³	Х	0.2020	=	gal./yd³
Admixture	fl.oz./100 lbs. cement	х	65.2	=	ml/100 kg cement	х	0.0153	=	fl.oz./100 lbs. cement
Admixture	fl.oz./yd³	х	0.03868	=	L/m³	х	25.85	=	fl.oz./yd³

#### **Concrete Properties**

Material	US Customary		Multiply by		SI (Metric)		Multiply by		US Customary
Slump	in.	х	2.54	=	ст	х	0.394	=	in.
Temperature	°F	х	(°F-32) ÷1.8	=	°C	х	(°Cx1.8)+32	=	°F
Unit Weight	pcf	х	16.02	=	kg/m³	x	0.0624	=	pcf
Compressive Strength	psi	х	0.006895	=	MPa (N/mm <sup>2</sup> )	х	145.0	=	psi
Flexural Strength	psi	х	0.006895 =		MPa (N/mm²)	х	145.0	=	psi
Air Content	%				%				%

## **Conversion factors**

Where accuracy is important conversion factors should be rounded off to four significant figures. This provides sufficient accuracy for regular concrete practices such as mix design, batching etc. If greater accuracy is required, please refer to ASTM C-380.

#### Linear Conversions (Approximate)

US Measure		Multiply by		SI (Metric)		Multiply by		US Customary
inches	х	25.4	=	Mm	х	0.039	=	in.
inches	х	2.5	=	ст	х	0.39	=	in.
feet	х	30.5	=	ст	х	3.28	=	ft.
yards	х	0.91	=	m	х	1.09	=	yds.
miles	х	1.61	=	km	х	0.62	=	miles

#### Area Conversions (Approximate)

US Measure		Multiply by		SI (Metric)		Multiply by		US Customary
in²	х	6.5	=	cm²	х	0.16	=	in²
ft²	х	0.092	=	m²	х		=	
yd <sup>2</sup>	x	0.84	=	m <sup>2</sup>	х	1.2	=	yd²
mile <sup>2</sup>	х	2.6	=	km²	х	0.38	=	mile <sup>2</sup>

#### English Units

12 inches = 1 foot 3 feet = 1 yard 144 in<sup>2</sup> =  $1ft^2$ 1728 in<sup>3</sup> =  $1 ft^3$ 27 ft<sup>3</sup> =  $1 yd^3$ 8 fl.oz. = 1 cup2 cups = 1 pint4 quarts = 1 gallon1 gallon = 231 in. 1 ft = 7.48 gallons

#### **Comparison of Typical Concrete Quantities**

Metric to U	S Cu	stomary	US Customary to Metric					
1 MPa	=	145 psi	1 ft.	=	0.3 m			
1 m3	=	1.3 yd³	1 in.	=	2.5 cm			
1 liter/ m3	=	0.2 gal./ yd³	1 fl.oz/ 100 lbs.cement	=	65 ml/100 kg cement			
1 kg	=	2.2 lbs.	1 lb./yd³	=	0.6 kg/m³			
1 kg/m3	g/m3 = 1.686 lbs/yd <sup>3</sup>		1 yd³	=	0.7646 m³			
Unit weight (water)	=	1 kg/L	1 fl.oz	=	30 ml			
1 metric ton (1000 kg)	=	2205 lbs.	1 gal.	=	3.8 liter			

## Comparison of Typical (Approximate) Concrete Values

Typical value	US Customary	Metric			
Weight: bag of cement	94 lb	± 43 kg			
Typical Design Strength	3000 psi	21 MPa			
High Strength Concrete	6000 psi	41 MPa			
Cement Content 5 bag mix 6 bag mix 7 bag mix	470 lbs/yd³ 564 lbs/yd³ 658 lbs/yd³	279 kg/m³ 335 kg/m³ 390 kg/m³			
Concrete Density	145 lb./ft <sup>3</sup>	2323 kg/m³			
Slump	3 - 4 in.	7.5 - 10 cm			
Slab thickness	4 in.	10 cm			

## Volume Conversions (approximate)

US Measure		Multiply by		SI (Metric)		Multiply by		US Customary
in³	х	16.0	=	ml	х	0.06	=	in. <sup>3</sup>
fl. oz.	х	29.6	=	ml	х	0.03	=	fl. oz.
cups	х	0.24	=	liters	х	0.036	=	cups
pints	х	0.47	=	liters	х	2.1	=	pints
quarts	х	0.95	=	liters	х	1.06	=	quarts
gallons	х	3.79	=	liters		0.26	=	gallons
ft.	х	0.028	=	m		35.3	=	ft.
yds <sup>3</sup>	x	0.76	=	ft.		1.31	=	yds³
ft <sup>3</sup>	x	28.3	=	liters			=	
yds³	х	764.5	=	liters			=	

#### **Comparison of Typical Concrete Quantities**

US Measure		Multiply by		SI (Metric)		Multiply by		US Customary
OZ.	х	28.3	=	grams	х	0.035	=	OZ.
lbs.	х	0.45	=	kg	х	2.2	=	lbs.
short tons	х	0.91	=	Metric Tons	х	1.1	=	short tons

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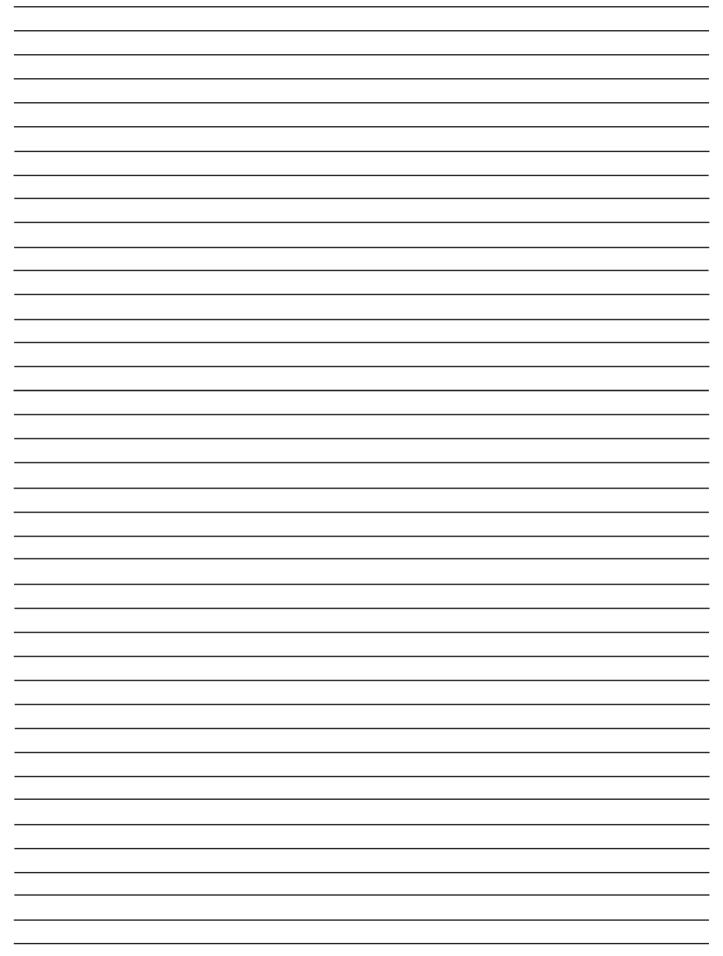
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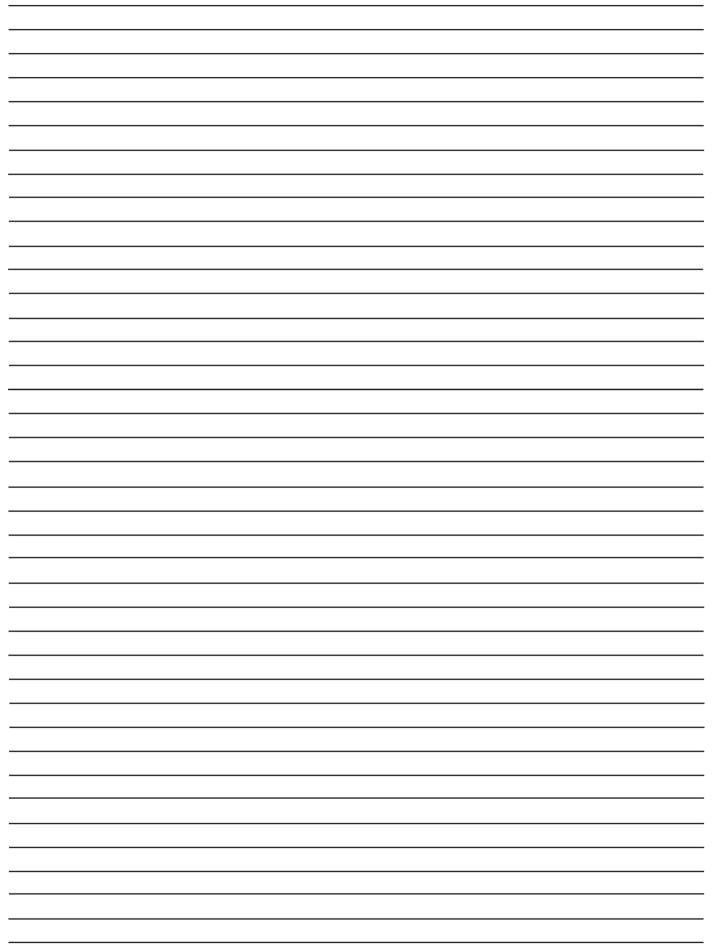
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