

## PRODUCT DATA SHEET

# Sikafloor®-324

Tough-elastic, low-VOC, aromatic polyurethane resin

### DESCRIPTION

Sikafloor®-324 is a two part solvent free, pigmented, aromatic polyurethane resin, with tough-elastic properties.

Sikafloor®-324 makes use of Sika's unique i-Cure technology to improve surface aesthetics and reduce sensitivity for ambient humidity during application. Suitable for use in hot and tropical climatic conditions.

### USES

Sikafloor®-324 may only be used by experienced professionals.

- Sikafloor®-324 is used as part of the Sikafloor® MultiFlex polyurethane traffic deck coating system range.
- Smooth wearing course with crack-bridging properties for industrial floors in production and storage facilities, work shops etc.
- Broadcast wearing course with crack-bridging properties for wet working areas (food and beverage industry etc.),
- Indoor areas, as in shopping centers, exhibition and storage areas.

### FEATURES

- Flexible and tough elastic
- i-Cure technology improves surface aesthetics and reduces sensitivity for ambient humidity during application
- Good crack-bridging ability
- Good chemical and mechanical resistance
- Total solids and Low VOC emissions
- Easy to apply
- Low maintenance
- Application on asphalt substrates possible (mastic asphalt)

### SUSTAINABILITY

- Contributes towards satisfying Indoor Environmental Quality (EQ) Credit: Low-Emitting Materials under LEED® v4
- Contributes towards satisfying Materials and Resources (MR) Credit: Building product disclosure and optimization — Environmental Product Declarations under LEED® v4

### CERTIFICATES AND TEST REPORTS

- Sikafloor®-324 follows the requirements of EN 13813:2002 synthetic resin screed material
- Sikafloor®-324 follows the requirements of EN 1504-2:2004 coating for concrete protection
- Fire classification according to DIN EN 13501-1:2010-01: Report No. 20150909/01, MPA Dresden
- Crack bridging properties following to EN 1062-7 method A, Test report No: 51-15-0056, IBOS GmbH.

## TECHNICAL INFORMATION

Shore D Hardness	~60 (7 days / 23 °C / 50% r.h.)	(DIN 53505)
Abrasion resistance	~65 mg (14 days / 23 °C / 50 % r.h.)	(ASTM D4060)
Tensile strength	~14 N/mm <sup>2</sup> (14 days / 23 °C / 50 % r.h.)	(ISO 527-2)
Tensile adhesion strength	> 1.5 N/mm <sup>2</sup> (failure in concrete)	(EN 13892-8)
Elongation at break	~90 % (28 days / 23 °C / 50 % r.h.)	(ISO 527-2)

## PRODUCT INFORMATION

Composition	Solvent-free polyurethane		
Packaging	Container Part A	20.25 kg	
	Container Part B	4.75 kg	
	Container Part A + Part B	25.0 kg	
	Refer to the current price list for available packaging variations.		
Shelf life	12 months from date of production		
Storage conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging. Protect from direct sunlight, heat and moisture. Refer to the current Safety Data Sheet for information on safe handling and storage.		
Appearance and colour	Part A	Coloured	
	Part B	Brownish	
	Cured colour	Available in various colours	
Density	Part A	~1.4 kg/l	(EN ISO 2811-1)
	Part B	~1.2 kg/l	
	Mixed Product	~1.6 kg/l (filled 1 : 0.5 with quartz sand 0.1–0.3 mm)	
	All density values at +23 °C.		
Solid content by mass	~100 %		
Solid content by volume	~100 %		

## SYSTEM INFORMATION

### Systems

Please refer to the System Data Sheet of:

Sikafloor® MultiFlex Traffic 1330	UV stable car park traffic deck system for intermediate and exposed decks
Sikafloor® MultiFlex Traffic 1331	Car park traffic deck system for intermediate decks
Sikafloor® MultiFlex Traffic 1332	UV stable, trafficable watertight deck membrane system
Sikafloor® MultiFlex Traffic 1342	UV stable, trafficable waterproofing deck membrane system

Sikafloor® MultiFlex PB-15 (G)	Car park traffic deck system for intermediate decks
Sikafloor® MultiFlex PB-15 UV (G)	UV stable car park traffic deck system for intermediate and exposed decks
Sikafloor® MultiFlex PS-32	Smooth unicolour tough elastic polyurethane floor covering
Sikafloor® MultiFlex PS-32 UV	Smooth unicolour tough elastic polyurethane floor covering with UV sealer
Sikafloor® MultiFlex PB-32	Broadcast unicolour tough elastic polyurethane floor covering
Sikafloor® MultiFlex PB-32 UV	Broadcast unicolour tough elastic polyurethane floor covering with UV sealer

## APPLICATION INFORMATION

<b>Mixing ratio</b>	Part A : Part B = 81:19 (by weight)			
<b>Consumption</b>	Please refer to the particular System Data Sheets and related Method Statement.			
<b>Ambient air temperature</b>	Min. +10 °C / Max. +35 °C			
<b>Relative air humidity</b>	Max. 80 % r.h.			
<b>Dew point</b>	Beware of condensation. The substrate and uncured applied product must be at least +3 °C above dew point to reduce the risk of condensation on the surface of the applied product.			
<b>Substrate temperature</b>	Min. +10 °C / Max. +35 °C			
<b>Pot Life</b>	+10 °C	~40 minutes		
	+20 °C	~30 minutes		
	+30 °C	~20 minutes		
<b>Waiting time to overcoating</b>	Before overcoating the Product, allow:			
	<b>Temperature</b>	<b>Minimum</b>	<b>Maximum</b>	
	+10 °C	30 hours	72 hours	
	+20 °C	24 hours	48 hours	
	+30 °C	16 hours	36 hours	
If the maximum waiting time is exceeded, the surface must be prepared by grinding to obtain a mechanical key between the layers. Note: Times are approximate and will be affected by changing ambient conditions, particularly temperature and relative humidity.				
<b>Applied product ready for use</b>	<b>Temperature</b>	<b>Foot Traffic</b>	<b>Light Traffic</b>	<b>Full Cure</b>
	+10 °C	1 day	3 days	9 days
	+20 °C	12 hours	2 days	5 days
	+30 °C	8 hours	1 day	3 days
Note: Times are approximate and will be affected by changing ambient conditions				

## BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## FURTHER DOCUMENTATION

- Particular System Data Sheet
- Particular System Method Statement
- General Method Statement — "Evaluation and preparation of surfaces for flooring systems"
- General Method Statement — "Mixing and application of flooring systems"

## IMPORTANT CONSIDERATIONS

- Under UV and weathering changes in colour are possible.
- For colour matching, ensure Sikafloor®-324 components A and B are applied from the same control batch numbers.
- Colour variations can occur due to raw materials in self smoothing system. It can occur with quartz sand in bright shades such as yellow or orange where colour variations through the backfill may be visible. With these colours, the opacity is limited if the product is used as a top coat. Applying a reference area is strongly recommended.
- Do not apply Sikafloor®-324 on substrates with rising moisture.
- Do not apply self smoothing systems on substrates with a slope > 1 % gradient.
- Freshly applied Sikafloor®-324 must be protected from damp, condensation and water for at least 24 hours. Uncured material reacts in contact with water (foaming). During application care must be taken that no 'sweat' drops into fresh Sikafloor®-324 (wear head and wrist bands).
- In smooth applications with sun light exposure use aliphatic polyurethane top coat. Refer to particular System Data Sheet.
- The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.
- Construction joints and existing static surface cracks in substrate require pre-treating before full layer application. Use Sikadur® or Sikafloor® resins.
- Under certain conditions, under floor heating or high ambient temperatures combined with high point loading, may lead to imprints in the resin.
- If during application temporary heating is required do not use gas, oil, paraffin or other fossil fuel heaters, these produce large quantities of both CO<sub>2</sub> and H<sub>2</sub>O water vapour, which may adversely affect the finish. For heating use only electric powered warm air blower systems.

## ECOLOGY, HEALTH AND SAFETY

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

## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY / PRE-TREATMENT

Substrates must be clean, dry and free of contaminants such as dirt, oil, grease, coatings, laitance, surface treatments and loose friable material. Cementitious substrates must be structurally sound and of sufficient compressive strength (minimum 25 N/mm<sup>2</sup>) with a minimum tensile adhesion strength of 1.5 N/mm<sup>2</sup>. Prepare the surface and prime the area as per recommendation stated in particular System Data Sheet and related Method Statement. If in a doubt, apply test area first.

### MIXING

- Mix part A until a uniform colour and mix has been achieved. Add Part B (hardener) to Part A.
- **IMPORTANT:** Do not mix excessively. Mix Part A + B continuously for ~2 minutes until a uniformly coloured mix is achieved.
- When required, add the quartz sand (e.g. Sikadur®-504) and mix for a further 2 minutes until a uniform mix has been achieved.
- To ensure thorough mixing, pour materials into another container and mix again to achieve a smooth and uniform mix.
- During the final mixing stage, scrape down the sides and bottom of the mixing container with a flat or straight edge trowel at least once to ensure complete mixing.
- Leave the Product to stand for 3 minutes before application.
- **MIXING EQUIPMENT:** Electric double paddle mixer (>700 W, 300 to 400 rpm).

### APPLICATION

Follow the application procedures as defined in particular System Method Statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

Prior to application, confirm substrate moisture content, relative humidity and dew point.

Generally, Sikafloor®-324 is poured and spread evenly by means of a short piled roller, serrated trowel or pin rake. When used in a selfsmoothing system applications, roll in two directions with a spike roller, to ensure even thickness and to remove entrapped air.

### CLEANING OF EQUIPMENT

Clean all tools and application equipment with Sika® Thinner C immediately after use. Hardened material can only be removed mechanically.

## MAINTENANCE INSTRUCTIONS

### CLEANING

To maintain the appearance of the floor after application, Sikafloor®-324 must have all spillages removed immediately and be regularly cleaned using rotary brush, mechanical scrubbers, scrubber dryer, high pressure washer, wash and vacuum techniques etc., using suitable detergents and waxes.

### LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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



#### Product Data Sheet

Sikafloor®-324

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