

PRODUCT DATA SHEET

Sikafloor®-324

2-PART PUR TOUGH-ELASTIC, LOW-VOC, SELF SMOOTHING FLOOR

DESCRIPTION

Sikafloor®-324 is a two part solvent free, pigmented with FP3 epoxy paste, self smoothing 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.

USES

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

- 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.),
- Car park decks and loading ramps etc.
- Applicable on asphalt surfaces
- Indoor areas, as in shopping centers, exhibition and storage areas.

CHARACTERISTICS / ADVANTAGES

- Flexible and tough-elastic
- i-Cure based chemistry
- Crack-bridging
- Application on asphalt substrates possible (mastic asphalt)
- Good chemical and mechanical resistance
- Solvent-free and low VOC emissions
- Possible slip resistant surface
- Easy to apply and to keep clean
- Economical
- Not sensitive to moisture

APPROVALS / STANDARDS

- Synthetic resin screed material according to EN 13813:2002, certified by Factory Production Control Body and provided with the CE-marking
- Coating for concrete protection according to EN 1504-2:2004, certified by Factory Production Control Body and provided with the CE-marking
- Fire classification according to DIN EN 13501-1:2010-01: Report No. 20150909/01, MPA Dresden
- Paint compatibility according to PV 3.10.7 tested at HQM Induserv Germany, test report 15-08-15203573-001.
- Crack bridging properties following to EN 1062-7 method A, Test report No: 51-15-0056, IBOS GmbH.
- Slip resistance class determined according to DIN 51131, test reports 020109-15-16, 020109-15-16a, 020109-15-17, 020109-15-17a, 020109-15-18, 020109-15-18a

PRODUCT INFORMATION

Composition	Polyurethane (PUR)	
Packaging	Part A	20.25 kg containers
	Part B	4.75 kg containers
	Part A+B	25.0 kg ready to mix units
Appearance / Colour	Part A	coloured, liquid
	Part B	brownish, liquid
Sikafloor®-324 is available in broad range of colours.		
Shelf Life	12 months from date of production	
Storage Conditions	The packaging must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +30 °C.	
Density	Part A	~1.4 kg/l (DIN EN ISO 2811-1)
	Part B	~1.2 kg/l
	Mixed resin (filled 1:0.5)	~1.6 kg/l
Filling 1:0.5 with quartz sand F34 0.1–0.3 mm. All Density values at +23 °C.		
Solid content by weight	~100 %	
Solid content by volume	~100 %	

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 D 4060)
Tensile Strength	~14 N/mm ² (14 days/23 °C/50 % r.h.)	(DIN EN ISO 527-2)
Elongation at Break	~90 % (resin / 28 days / +23 °C / 50 % r.h)	(ISO 527-2)
Tensile Adhesion Strength	> 1.5 N/mm ² (failure in concrete)	(EN 13892-8)
Chemical Resistance	Resistant to many chemicals. Contact Sika technical service for specific information.	

SYSTEM INFORMATION

Systems	Please refer to the System Data Sheet of:	
	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

Mixing Ratio	Part A : Part B = 81 : 19 (by weight)
Consumption	Please refer to the System Data Sheets
Ambient Air Temperature	+10 °C min. / +30 °C max.
Relative Air Humidity	~75–80 %

Dew Point	Beware of condensation! The substrate and uncured floor must be at least 3 °C above dew point to reduce the risk of condensation or blooming on the floor finish.			
Substrate Temperature	+10 °C min. / +30 °C max.			
Substrate Moisture Content	< 4 % pbw moisture content. Test method: Sika®-Tramex meter, CM - measurement or Oven-dry-method.No rising moisture according to ASTM (Polyethylene-sheet).			
Pot Life	Temperatures	Time		
	+10 °C	~40 minutes		
	+20 °C	~30 minutes		
	+30 °C	~20 minutes		
Curing Time	Before overcoating Sikafloor®-324 allow:			
	Substrate temperature	Minimum	Maximum	
	+10 °C	~30 hours	~72 hours	
	+20 °C	~24 hours	~48 hours	
+30 °C	~16 hours	~36 hours		
Applied Product Ready for Use	Temperature	Foot traffic	Light traffic	Full Cure
	+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				

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY / PRE-TREATMENT

The surface must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings and surface treatments, etc. All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by vacuum. Pull of strength shall not be less than 1.5 N/mm². If in doubt apply a test area first.

MIXING

Prior to mixing, stir part A mechanically. When all of part B has been added to part A mix continuously for 2 minutes until a uniform mix has been achieved. When parts A and B have been mixed, add the quartz sand F34 0.1–0.3 mm and mix for a further 2 minutes until a uniform mix has been achieved. To ensure thorough mixing pour the materials into another pail and mix again to achieve a consistent mix. After mixing leave the mixture for 3 minutes to react before applying.

Mixing Tools

Sikafloor®-324 must be thoroughly mixed using a low speed electric stirrer (300–400 rpm) or other suitable equipment.

APPLICATION

Prior to application, confirm substrate moisture content, relative humidity and dew point. Sikafloor®-324 is poured and spread evenly by means of a serrated trowel or pin rake. When used in a self-smoothing system, roll in two directions with a spike roller to ensure even thickness and to remove entrapped air.

CLEANING OF TOOLS

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

MAINTENANCE

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.

FURTHER DOCUMENTS

Substrate quality & Preparation

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

Application instructions

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

Maintenance

Please refer to "Sikafloor®- CLEANING REGIME".

IMPORTANT CONSIDERATIONS

- Colour variations are un-avoidable due to raw materials. 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.

- 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.
- Do not apply Sikafloor®-324 on substrates with rising moisture.
- Do not apply on substrate surfaces with a slope > 1 %.
- 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).
- The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.
- In smooth applications with sun light exposure use Sikafloor®-357 N or Sikafloor®-305 W as seal coat.
- 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 CO₂ and H₂O water vapour, which may adversely affect the finish. For heating use only electric powered warm air blower systems.

BASIS OF PRODUCT DATA

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

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

According to the EU-Directive 2004/42, the maximum allowed content of VOC (Product category IIA / j type sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sikafloor®-324 is < 500 g/l VOC for the ready to use product.

LEGAL NOTES

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

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Product Data Sheet
Sikafloor®-324
March 2019, Version 01.01
020812040020000096

Sikafloor-324-en-MY-(03-2019)-1-1.pdf