

PRODUCT DATA SHEET

Sikafloor® Marine-504

Waterbased 2-component Polyurethane clear matt topcoat for internal decks

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

| Properties | Sikafloor® Marine-504 (A) | Sikafloor® Marine-504 (B) |
|--------------------------------|--------------------------------|----------------------------|
| Chemical Base | Acrylic dispersion | Isocyanate |
| Color (CQP001-1) | White | Transparent |
| Density | mixed (+ 5 % H ₂ O) | 1.1 kg/l |
| | | 1.1 kg/l |
| Solid Content | | 57 % |
| Mixing Ratio | by weight (A:B) | 80 : 20 |
| Application Temperature | substrate / climate | 10 – 30 °C ^{A, B} |
| Pot-Life | at 10 °C | 50 minutes |
| | at 20 °C | 30 minutes |
| | at 30 °C | 20 minutes |
| Shelf Life | | 6 months ^C |
| | | 12 months ^C |

CQP = Corporate Quality Procedure ^{A)} Substrate must be 3 °C above dew point

^{B)} Maximum 80 % r. h.

^{C)} stored in sealed container in up-right position in a dry place between 5 and 30 °C, protected from direct sunlight

DESCRIPTION

Sikafloor® Marine-504 is a water based 2-component polyurethane clear matt topcoat for internal decks. It is used as a component of the Sikafloor® Marine Deco systems.

Sikafloor® Marine-504 has been tested according to FTP Code system and approved according to the IMO Marine Equipment Directives.

PRODUCT BENEFITS

- Excellent working characteristics
- Very low VOC emission
- IMO approved
- Easy to clean

AREAS OF APPLICATION

Sikafloor® Marine-504 is designed as a component of the Sikafloor® Marine Deco systems for internal decks in ship and boat construction.

This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

The curing of Sikafloor® Marine-504 takes place by a chemical reaction of the two components.

Higher temperatures speed up and lower temperatures slow down the curing process.

CHEMICAL RESISTANCE

For advice on chemical resistance contact the Technical Department of Sika Industry.

METHOD OF APPLICATION

Surface Preparation

Dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush or vacuum. Ensure that substrates are clean, dry and free from all contaminants such as dirt, oil, grease, coatings and other surface treatments.

Mixing Process

Prior to mixing both components, stir part A with a proper mixing paddle.

Add part B and start mixing. During this mixing process add 5 – 7 % of water and continuously mix for 3 minutes until a uniform mix has been achieved.

To ensure thorough mixing pour materials into another container and mix again for at least 1 minute.

Mix with mixing paddles not higher than 300 rpm's to minimize air entrapment.

After mixing wait 10 minutes before start working with Sikafloor® Marine-504.

Application

Prior to application confirm relative air humidity and dew point.

When starting to coat, make sure the coating rollers are well saturated with coating.

After proper mixing the product is poured and spread out on the floor in respect of the coat weight. Note: Keep an eye on the pot life since the end of the pot-life is not visible.

Roll with a larger 50 cm roller in one direction cross the working direction to eliminate lap-marks.

Always consult the most current corresponding Application Manual.

Curing

Indications regarding curing details see table below.

| Temperature | Foot traffic | Light traffic | Full cure |
|-------------|--------------|---------------|-----------|
| 10 °C | 36 hours | 48 hours | 6 days |
| 20 °C | 16 hours | 24 hours | 4 days |
| 30 °C | 12 hours | 18 hours | 3 days |

Removal

Uncured Sikafloor® Marine-504 can be removed from tools and equipment with water. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Application Limits

Freshly applied Sikafloor® Marine-504 must be protected from damp, condensation and water for at least 5 days. Uncured material reacts in contact with water (foaming).

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Application Manual
Sikafloor® Marine-504

PACKAGING INFORMATION

Sikafloor® Marine-504 (A)

| | |
|-----------|------|
| Container | 6 kg |
|-----------|------|

Sikafloor® Marine-504 (B)

| | |
|-----------|--------|
| Container | 1.5 kg |
|-----------|--------|

BASIS OF PRODUCT DATA

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

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse 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.

PRODUCT DATA SHEET

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