

PRODUCT DATA SHEET

SikaTransfloor®-352 ST

IMO approved 2-component polyurethane thixotropic floor levelling compound

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaTransfloor®-352 ST	Component B SikaTransfloor®-352 Rapid
Chemical Base	Polyurethane	Isocyanate
Color (CQP001-1)	Grey	Brown
Consistency	Thixotropic	
Density	0.93 kg/l	1.22 kg/l
	mixed	1.0 kg/l
Solid Content	100 %	
Mixing Ratio	by weight	4 : 1
Application Temperature	substrate / climate	10 – 35 °C ^{A)}
Working Time	10 °C	45 minutes
	20 °C	35 minutes
	30 °C	25 minutes
Shore A (CQP023-1)	EN ISO 868 + ASTM D2240	80
Tensile Strength (CQP036-1 / ISO 527)	2.3 MPa	
Elongation at Break (CQP036-1 / ISO 527)	50 %	
Shelf Life	12 months	

CQP = Corporate Quality Procedure

^{A)} max. 80 % r.h.

DESCRIPTION

SikaTransfloor®-352 ST is a 2-component, polyurethane, low VOC marine flooring resin for filling and levelling sloped floor substrates up to 3 %.

Consider SikaTransfloor®-352 SL for slightly sloped floor surfaces and SikaTransfloor®-352 VSL for creating non-sloped levelled floor surfaces.

PRODUCT BENEFITS

- Good application characteristics
- Solvent-free
- Low density
- No shrinkage
- Permanently elastic
- Easy to sand

AREAS OF APPLICATION

SikaTransfloor®-352 ST is designed for levelling surface irregularities of metallic welded floors (steel, aluminum) or GRP decks in ship and boat construction.

The prepared levelling is then ready to receive the finishing layer of Sikafloor® Marine-500 series or timber decking applying Sikaflex®-298 as the bedding compound.

SikaTransfloor®-352 ST is suitable for interior and exterior use.

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

APPROVAL / CERTIFICATES

SikaTransfloor®-352 ST has been tested as a floor covering according to FTP Code system and approved according to the IMO Marine Equipment Directives.

SikaTransfloor®-352 ST is IMO approved for floor covering up to max. 500 g/m².

CURE MECHANISM

The curing of SikaTransfloor®-352 ST takes place by a chemical reaction of the two components.

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

METHOD OF APPLICATION

Surface Preparation

For steel decks, an anti-corrosion protection layer applied and intact as designed by the shipyard is a pre-requisite.

The anti-corrosion protection layer needs to be clean, free of dirt, dust, grease, oil and loose particles before application of the SikaCor® ZP Primer. The adhesion between the anti-corrosion protection layer and SikaCor® ZP Primer must be verified.

Aluminum deck needs to be clean, free of dirt, dust, grease, oil and loose particles. The aluminum substrate must be sanded with 40 – 80 grit sanding paper and dust free vacuum cleaned before application of SikaCor® ZP Primer (Tiecoat).

In the case of cementitious substrates, it must be ensured that the laitance layer is completely removed. This is usually achieved by grinding. All dust, loose and friable material must be completely removed by vacuum before the next application.

Repairs to the substrate, filling of cracks, holes/voids or surface levelling must be carried out first. Repair areas must be cured before applying primers.

Ensure the substrate moisture content is equal or less than 4 % (Calcium carbide method (CM-method)). Apply Sikafloor®-150/- 151 as a primer to obtain a closed pore free surface.

Polyurethane substrates need usually to be sanded with 40 – 80 grit sanding paper up to diamond disc. In case the substrate is not clean, it is required to clean it before the sanding process to ensure no debris is sanded into the surface. All dust, loose and friable material must be completely removed from the surface by vacuum cleaning before next application.

The application area must be protected against dirt, sun light, water and draught.

Consider: the substrates must be 3 °C above the dew point prior and during application and the relative humidity must be below 80 %.

For other substrates and their pre-treatment consult the Sika Pre-Treatment Chart for Sikafloor® Marine.

Mixing Process

Use an electric single spiral mixer operating at 300 – 500 rpm to mix. Prior to mixing both components, mix part A until a homogenous color is achieved. Add part B to part A and mix continuously for 2 minutes.

To ensure thorough mixing pour materials into a clean container and mix again for at least 1 minute to achieve a smooth consistent mix. Excessive mixing must be avoided to minimize air entrainment.

For areas with cambers or slopes Sika® Extender T may be added to adapt the consistency of the product.

Note: By adapting the consistency, the deaeration properties may be affected.

Application

SikaTransfloor®-352 ST is poured and spread evenly by means of a suitable trowel or pin leveller. A spike roller may be used to improve levelling and deaeration.

For liquid application on cambers and slopes multiple applications steps might be needed.

A seamless finish can be achieved when a "wet" edge is maintained during application.

Curing

The product is walkable after 24 hours and is ready for the next stage in the process.

Removal

Uncured SikaTransfloor®-352 ST can be removed from tools and equipment with Sika® Colma Cleaner or another suitable solvent. 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

Layer thickness of the product 0.5 - 30 mm. If a higher layer thickness is needed the operation must be carried out in multiple applications with intermediate sanding + vacuum cleaning of the cured product.

The application area must be protected against weather and direct sunlight. Freshly applied SikaTransfloor®-352 ST must be protected from moisture, condensation and water for at least 1 day.

If 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 product. For heating use only electric powered warm air blower systems.

STORAGE CONDITIONS

The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between 5 °C and 30 °C. Always refer to packaging.

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
- Sika Pre-Treatment Chart
For Sikafloor® Marine Applications
- Sika Marine Application Guide
Teak Decking

PACKAGING INFORMATION

SikaTransfloor®-352 ST (A)

Pail	20 kg
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SikaTransfloor®-352 Rapid (B)

Pail	5 kg
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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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