

PRODUCT DATA SHEET

Sikafloor®-328

2-Component Polyurethane part of the Sika ComfortFloor® system series

DESCRIPTION

Sikafloor®-328 is a two part, solvent free, very low VOC emission, elastic, self-smoothing PUR resin.

USES

Sikafloor®-328 may only be used by experienced professionals.

- Tough-elastic smooth wearing course for the Sika ComfortFloor® PS-27 flooring system
- Particularly suitable for hospitals, schools, sales premises, showrooms, entrance halls, lobbies, open-plan offices, museums and light to medium heavy industrial use
- For interior use only

CHARACTERISTICS / ADVANTAGES

- Very low VOC emission
- Solvent free
- Permanently tough elastic
- Good mechanical resistance
- Easy to apply
- Easy to maintain

PRODUCT INFORMATION

Chemical Base	PUR	
Packaging	Part A	15.8 kg containers
	Part B	4.2 kg containers
	Part A+B	20.0 kg ready to mix units
Shelf Life	12 months from date of production	
Storage Conditions	The product must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +30 °C.	

ENVIRONMENTAL INFORMATION

LEED Rating

Sikafloor®-328 conforms to the requirements of LEED EQ Credit 4.2: Low-Emitting Materials: Paints & Coatings
SCAQMD Method 304-91 VOC Content < 100 g/l

APPROVALS / STANDARDS

- Synthetic resin screed material according to EN 13813:2002, Declaration of Performance 02 08 01 04 040 0 000008 1041, certified by notified factory production control certification body 0620, and provided with the CE marking.
- Coating for surface protection of concrete according to EN 1504-2:2004, Declaration of Performance 02 08 01 04 040 0 000008 1041, certified by notified factory production control certification body 0620, and provided with the CE marking.
- Fire classification according to EN 13501-1, Test report 11-491, University of Ghent - Belgium

Appearance / Colour	Resin - part A	coloured, liquid
	Hardener - part B	light brown, transparent, liquid
	10 Standard colours available: Grey white, beige, light grey, middle grey, dark grey, light blue, dark blue, light green, dark green, red.	
Density	Mixed resin	~ 1.57 kg/l (DIN EN ISO 2811-1)
	All Density values at +23 °C	
Solid content by weight	~100 %	
Solid content by volume	~100 %	

TECHNICAL INFORMATION

Shore D Hardness	~60–70 (14 days / +23 °C)	(ISO 868)
Tensile Strength	~ 18.0 N/mm ² (14 days / +23 °C)	(DIN 53504)
Elongation at Break	~ 60 % (14 days / +23 °C)	(DIN 53504)
Tensile Adhesion Strength	> 1.5 N/mm ² (failure in concrete)	(EN 13892-8)
Tear Strength	~ 75 N/mm (14 days / +23 °C)	(ISO 34-1)
Chemical Resistance	Sikafloor®-328 always has to be sealed with Sikafloor®-305 W. Therefore, refer to chemical resistance of Sikafloor®-305 W.	

SYSTEM INFORMATION

Systems	Please refer to the System Data Sheet of: Sika ComfortFloor® PS-27 Seamless, smooth, unicolour, low voc, tough elastic polyurethane floor covering	
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APPLICATION INFORMATION

Mixing Ratio	Part A : part B = 79 : 21 (by weight)	
Consumption	~ 1.5 kg/m ² /mm	
Layer Thickness	2.80 kg/m ² - film thickness ~ 1.6 mm Refer to the respective System Data Sheet.	
Ambient Air Temperature	+10 °C min. / +30 °C max.	
Relative Air Humidity	80 % r.h. max.	
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	Temperature	Time
	+10 °C	~ 21 minutes
	+20 °C	~ 15 minutes
	+30 °C	~ 12 minutes

Curing Time

Before overcoating Sikafloor®-328 allow:

<u>Substrate temperature</u>	<u>Minimum</u>	<u>Maximum</u>
+10 °C	24 hours	72 hours
+20 °C	18 hours	48 hours
+30 °C	16 hours	36 hours

Times are approximate and will be affected by changing ambient conditions particularly temperature and relative humidity.

If maximum waiting time is exceeded, the surface of Sikafloor®-328 has to be grinded to achieve mechanical bonding between the layers of Sikafloor® system.

Applied Product Ready for Use

<u>Temperature</u>	<u>Foot traffic</u>	<u>Full cure</u>
+10 °C	~ 24 hours	~ 72 hours
+20 °C	~ 18 hours	~ 60 hours
+30 °C	~ 16 hours	~ 48 hours

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.

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".

LIMITATIONS

- Do not apply Sikafloor®-328 on substrates with rising moisture.
- Do not apply on substrate surfaces with a slope > 1 %.
- Freshly applied Sikafloor®-328 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®-328 (wear head and wrist bands).
- If 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

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 550 / 500 g/l (Limits 2007 / 2010) for the ready to use product.

The maximum content of Sikafloor®-328 is < 500 g/l VOC for the ready to use product.

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 off 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. To ensure thorough mixing pour materials into another container and mix again to achieve a consistent mix. Over mixing must be avoided to minimise air entrainment.

Mixing Tools

Sikafloor®-328 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®-328 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.

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.

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. It may be necessary to adapt the above disclaimer to specific local laws and regulations. Any changes to this disclaimer may only be implemented with permission of Sika® Corporate Legal in Baar.

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Product Data Sheet

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