

# PRODUCT DATA SHEET

## Sikafloor®-327

2-PART TOUGH ELASTIC POLYURETHANE FOR INDOOR USE IN DECORATIVE AND INDUSTRIAL FLOORING.

### PRODUCT DESCRIPTION

Sikafloor®-327 is a two part, solvent free, very low VOC emission, tough-elastic, coloured, self-smoothing PUR resin.

### USES

Sikafloor®-327 installation works to be carried out only by Sika Approved Contractors. Please observe information given by Product Data Sheets.

- Tough-elastic smooth wearing course for the Sika Comfortfloor® Tough system
- Sikafloor® Smooth Tough Elastic PU for Industrial flooring
- Sikafloor® Broadcast Tough Elastic PU for Industrial flooring for improved friction
- 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
- Good mechanical resistance

- Easy to apply
- Easy to maintain
- Flexible and tough-elastic
- Economical
- Solvent-free
- Possible slip resistant surface

### ENVIRONMENTAL INFORMATION

#### LEED Rating

Sika can help to earn credit points under certain circumstances for USGBC LEED Rating, conform the IEQ Credit 4.2 Low-Emitting Materials Paints and Coatings.

### APPROVALS / STANDARDS

- Synthetic resin screed material according to EN 13813:2002, Declaration of Performance 02 08 01 04 040 0 000010 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 000010 1041, certified by notified factory production control certification body 0620, and provided with the CE marking.
- Reaction to Fire classification according to EN 13501-1. Test institute Ghent University, Belgium. Report No. CR-13-167/1 for the Sika Comfortfloor® Tough.

### PRODUCT INFORMATION

Chemical Base	PUR	
Packaging	Part A	16.2 kg containers
	Part B	3.8 kg containers
	Part A+B	20.0 kg ready to mix units

<b>Appearance / Colour</b>	Resin - part A	coloured, liquid
	Hardener - part B	brown, transparent, liquid
<b>Available standard colours:</b> Substrate for local tinting. Grey White, Grey, Green, Blue shades. Bright and Pastel colours on request.		
<b>Shelf Life</b>	12 months from date of production.	
<b>Storage Conditions</b>	The packaging must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +30 °C.	
<b>Density</b>	Mixed Resin: ~ 1,4 kg/l All Density values at +23 °C.	(ISO 1183-1)
<b>Solid content by weight</b>	~100 %	
<b>Solid content by volume</b>	~100 %	

## TECHNICAL INFORMATION

<b>Shore D Hardness</b>	~ 60–70 (14 days / +23 °C)	(DIN 53505)
<b>Tensile Strength</b>	~ 19 N/mm <sup>2</sup> (14 days / +23 °C)	(DIN 53504)
<b>Elongation at Break</b>	~ 28 % (14 days / +23 °C)	(ISO 37)
<b>Tensile Adhesion Strength</b>	>1.5 N/mm <sup>2</sup> (failure in concrete)	(EN 13892-8)
<b>Tear Strength</b>	~ 40 N/mm (14 days / +23 °C)	(ISO 34-1)
<b>Chemical Resistance</b>	Sikafloor®-327 always has to be sealed with pigmented topcoat. Therefore, refer to chemical resistance of the used topcoat.	

## SYSTEM INFORMATION

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

<b>Mixing Ratio</b>	Part A : part B = 81:19 (by weight)	
<b>Consumption</b>	~ 1.4 kg/m <sup>2</sup> /mm	
<b>Layer Thickness</b>	2.80 kg/m <sup>2</sup> - film thickness ~ 2.0 mm Refer to the respective System Data Sheet.	
<b>Ambient Air Temperature</b>	+10 °C min. / +30 °C max.	
<b>Relative Air Humidity</b>	80 % r.h. max.	
<b>Dew Point</b>	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.	
<b>Substrate Temperature</b>	+10 °C min. / +30 °C max.	
<b>Substrate Moisture Content</b>	< 4 % pbw moisture content. Test method: Sika®-Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).	
<b>Pot Life</b>	<b>Temperature</b>	<b>Time</b>
	+10 °C	~ 25 minutes
	+20 °C	~ 20 minutes
	+30 °C	~ 15 minutes

## Curing Time

Before overcoating Sikafloor®-327 allow:

Substrate temperature	Minimum	Maximum
+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, exposed surface of Sikafloor®-327 has to be grinded to achieve mechanical bonding between the layers of Sikafloor®.

Applied Product Ready for Use	Temperature	Foot traffic	Full cure
	+10 °C	~ 24 hours	~ 72 hours
	+20 °C	~ 18 hours	~ 60 hours
	+30 °C	~ 16 hours	~ 48 hours

## 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/mm<sup>2</sup>. 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®-327 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®-327 is poured and spread evenly by means of a serrated trowel or pin rake. When used in a self smoothing system, roll in two direction 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.

## FURTHER DOCUMENTS

### Substrate Quality & Preparation

Please refer to Sika Information Manual: "EVALUATION AND PREPARATION OF SURFACES FOR FLOORING SYSTEMS".

### Application Instructions

Please refer to Sika Information Manual: "MIXING & APPLICATION OF FLOORING SYSTEMS".

### Maintenance

Please refer to "Sikafloor®- CLEANING REGIME".

## LIMITATIONS

- Maximum relative humidity during application and curing 80 %.
- Do not apply Sikafloor®-327 on substrates with rising moisture.
- Do not apply on substrate surfaces with a slope > 1 %.
- Freshly applied Sikafloor®-327 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®-327 (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 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

## VALUE BASE

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

## 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 the exact product data and uses.

## ECOLOGY, HEALTH AND SAFETY

Local safety regulations must be observed and it advisable to wear PPI when working with this product with particular attention paid to cutting and handling. Transportation Class: The product is not classified as hazardous good for transport. Disposal: The material is

recyclable. Disposal must be according to local regulations. Please contact your local Sika sales organisation for more information.

## **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®-327 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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