**Sikafloor®-24NA PurCem®**

**Advanced Generation, Self-Levelling, Polyurethane/Cement Screed for General Industrial and Commercial Use**

**Description**
Description Sikafloor-24NA PurCem is a state of the art, phthalate-free, water dispersed polyurethane based/cement and aggregate screed, applicable at thicknesses ranging from 80 to 160 mils (2 to 4 mm). It is designed to be installed as a self-leveling floor topping that provides an easy-to-clean, smooth surface with medium slip resistance values and is typically used for general, industrial applications. Sikafloor-24NA PurCem represents superior polyurethane/cement technology, combining easier application, resistance to blistering and improved performance.

**Where to Use**
- Typically used in areas to provide a smooth, flat and thin self-leveling polyurethane cement layer in general industrial areas, including warehouses, production facilities, laboratories and workshops, either with or without a Sikafloor® sealer top coat.
- As thin layer, flat but slip-resistant screed in commercial environments, with a suitable UV-stable Sikafloor sealer for retention of aesthetics.
- As broadcast receiving coat, flat but slip-resistant screed in commercial environments, with a suitable UV-stable Sikafloor sealer for retention of aesthetics.
- When used as a base for MVT system, total thickness must be 1/8-inch (3.2mm).

**Advantages**
- Can be applied on green concrete (typically 7 -10 days) after preparation (see surface prep section) and where substrate has tensile bond strength in excess of 218 psi (1.5 MPa).
- Can be applied over partially cured concrete substrates (<10% surface moisture), full 28 days cure time is not necessary.
- Easy installation requiring less labor to install than traditional Sikafloor® PurCem® trowel and heavy duty slurry grade materials.
- Can be applied to concrete substrates where <100% relative humidity is measured as per ASTM F2170.
- Wide range of application temperatures from 7°C (45°F) minimum to 38°C (100°F) maximum.
- Good abrasion resistance, providing cost effective and durable floor topping.
- Similar coefficient of thermal expansion to concrete allowing movement with the substrate through normal thermal cycling.
- Performs and retains its physical characteristics through a wide, wet or dry temperature range from 41°F (-5°C) at 2.0 mm and 14°F (-10°C ) at 4.0 mm up to 248°F (120°C).
- Superior formulation eliminates formation of blisters, such as those arising out of application during elevated temperatures or early and multiple layer applications.
- Non-tainting, odorless and phthalate-free, avoiding associated toxicity to health and environmental hazards.
- Bond strength in excess of the tensile strength of concrete, concrete will fail first.
- Compatible with a wide range of Sikafloor epoxy or polyurethane resin sealers, enabling UV-stable sealers to be applied where required. Consult Sika Technical department for full details.
- Minimal maintenance costs, superior life cycle cost advantage versus tile.
- Extra expansion joints are not necessary; maintain and extend existing expansion joints up through the Sikafloor PurCem Flooring System.
- Behaves plastically under impact / deforms but will not crack or debond.
- Achieves highest performance ratings according to ASTM G21 resistance to fungi and ASTM

### TYPICAL DATA

**RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.**

<table>
<thead>
<tr>
<th>Packaging</th>
<th>Component A: 1 US gal (3.78 L) 8.53 lb (3.87 kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Component B: 0.7 US gal (2.64 L) 7.33 lb (3.325 kg)</td>
<td></td>
</tr>
<tr>
<td>Component C: 45.21 lbs (20.51 kg) in a bag (powder)</td>
<td></td>
</tr>
<tr>
<td>Mix Units = 2A + 2B + 1C = 76.87 lb (34.87 kg) (5.33 US gal)</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Colors</th>
<th>RAL 7012 Basalt Gray</th>
<th>RAL 3009 Oxide Red</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>RAL 7038 Agate Gray</td>
<td>RAL 1001 Beige</td>
</tr>
<tr>
<td></td>
<td>RAL 7042 Traffic Grey A</td>
<td></td>
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</tbody>
</table>

**Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current product data sheet, product label and safety data sheet which are available online at https://usa.sika.com or by calling Sika's technical service department at 800.953.7462 nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current product data sheet, product label and safety data sheet prior to product use.**
Coverage
Scratch coat: (where surface/substrate profile requires such. Not required under full quartz broadcast)
Sikafloor 24 NA PurCem® 215 ft²/unit (20 m²/unit) @ 40 mils (1 mm) per coat
Screed: (These figures do not allow for surface porosity, profile or wastage)
Approx. 107 ft² (10 m²) per unit at 80 mils (2 mm)
Approx. 85 ft² (7.9 m²) per unit at 100 mils (2.5 mm)
Approx. 71 ft² (6.6 m²) per unit at 120 mils (3 mm)

Broadcast Application
Primer/Scratch Coat (where surface/substrate profile requires)
Body Coat: Approx. 107 ft² (10 m²) per unit at 80 mils (2 mm)
Screed to excess

Pot Life
Material Temperature Time
+50°F (10°C) ~ 25 - 30 minutes
+68°F (20°C) ~ 15 - 20 minutes
+86°F (30°C) ~ 5 - 10 minutes

Waiting / Recoat Times
Before applying Sikafloor-24NA PurCem when a scratch primer and sealer coat is used allow:
Ambient & Substrate Temperature
Minimum Maximum
+50°F (10°C) 24 hours 7 days
+68°F (20°C) 6 hours 3 days
+86°F (30°C) 4 hours 2 days

Cure Times
Ambient & Substrate Temperature
Foot traffic Light traffic Full cure
4 mm
(160 mils)
+50°F (10°C) ~ 24 hours ~ 48 hours ~ 10 days
+68°F (20°C) ~ 18 hours ~ 24 hours ~ 5 days
+86°F (30°C) ~ 12 hours ~ 18 hours ~ 3 days

Properties Tested at 73°F (23°C) and 50% R.H, Neat Material:
Application Temperature 45°F (7°C) min / 100°F (38°C) max
Softening Point 266°F (130°C)
Density ASTM C905 14.45 lb/US gal. (1.73 kg/L)
Service Temperature The product is suitable for use when exposed to continuous temperatures, wet or dry, of up to 248°F (120°C).
The minimum service temperature is 41°F (-5°C) at 2.0 mm and 14°F (-10°C) at 4.0 mm.

Compressive Strength
ASTM C579
24 hrs 5,366 psi (37 MPa)
3 days 6,236 psi (43 MPa)
7 days 6,771 psi (46 MPa)
28 days 6,961 psi (48 MPa)

Tensile Strength
ASTM C307
1,290 psi (8.9 MPa)

Flexural Strength
ASTM C680
2,726 psi (18.8 MPa)

Pull-off Strength
ASTM D4541
297 psi (2.0 MPa) (substrate failure)

Thermal Compatibility
ASTM C884
Pass

Hardness Shore D
ASTM D2240 83

Indentation
MIL-PRF-24613 ~ 0%

Abrasiveness
ASTM D4060
H-17/1000 cycles/1000 g (2.2 lb) 0.07 g (0.0025 oz)
H-22/1000 cycles/1000 g (2.2 lb) 0.239 g (0.0084 oz)

Coefficient of Thermal Expansion
ASTM D696
3.02 x 10⁻⁵ in/in/ºF (5.43 x 10⁻⁵ mm/mm/ºC)

Shrinkage
0.248%

Flexural Modulus
ASTM C580 14 days 2.71 x 10¹⁰ psi (1.87 x 10¹⁰ MPa)

Water Absorption
ASTM C413 0.10%

Resistance to Fungi Growth
ASTM G21 Rated 0 (no growth)

Resistance to Mold Growth
ASTM D3273 Rated 10 (highest resistance)

VOC
Components A+B+C: 5 g/l
Components A+B+C+D 5.3 g/l

Flammability
ASTM E-648 - 2017
With Sikafloor 217 or 510N LPL Top Coat
Class I

Shelf Life
Components A, B and C; 1 year in original unopened packaging
Store dry between 50° - 77°F (10° - 25°C). Protect from freezing.
If frozen, discard product. Condition material for at least
24 hours to 65 - 75°F (18 - 24°C) before use.

Chemical Resistance
Please consult Sikafloor Technical Services.

Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site.
Industrial Flooring

How to Use

Surface Preparation

Concrete surfaces must be clean and sound. Remove all dust, dirt, existing paint films, efflorescence, exudates, laitance, form oils, hydraulic or fuel oils, brake fluid, grease, fungus, mildew, biological residues or any other contaminants which may prohibit a good bond. Prepare the surface by any appropriate mechanical means, in order to achieve a profile equivalent to ICRI - CSP 3-6. The compressive strength of the concrete substrate should be at least 3,625 psi (25 MPa) at 28 days and a minimum of 218 psi (1.5 MPa) in tension at the time of application. Repairs to cementitious substrates, filling of blowholes, leveling of irregularities, etc. should be carried out using an appropriate Sika profiling mortar. Contact Sika Technical Service for a recommendation.

Edge Terminations - all free edges of a Sikafloor PurCem floor, whether at the perimeter, along gutters or at drains, require extra anchorage to distribute mechanical and thermal stresses. This is best achieved by forming or cutting grooves in the concrete. Grooves should have a depth and width of 2 times thickness of the Sikafloor PurCem floor. Refer to the edge detail provided at http://usa.sika.com. If necessary, protect all free edges with mechanically attached metal strips. Do not featheredge, always turn into an anchor groove.

Expansion Joints - should be provided in the substrates at the intersection of dissimilar materials. Isolate areas subject to thermal stresses, vibration movements or around load-bearing columns and at vessel sealing rings. Refer to details provided at http://usa.sika.com.

Mixing

Mix Ratio Components A : B : C (2A : 2B : 1C)= Mix full units only

Mixing will be affected by temperature; condition materials for use to 65 to 75°F (18 to 24°C) for at least 24 hours before use.

A ‘Kol’ type mixer, incorporating a motor spun mixing pail and a shear angle mixing blade, is recommended. Alternatively, use a low speed drill (300-450 rpm) and Exomixer-type mixing paddle (recommended) suited to the size of mixing container to minimize air entrapment.

Pre-agitate Components A and B separately, making sure all solids, including pigments, are uniformly distributed. Start mixer; add Component A and Component B, blending for 30 seconds. Add Component C (powder) pouring slowly over a period of 20 seconds. DO NOT DUMP POWDER INTO RESIN, ADD GRADUALLY.

Allow Component C to further blend for 2 1/2 more minutes after all of the powder is emptied into the resin to ensure all powder is wetted out and a completely uniform mix is achieved. During the mixing operation, and observing good safety practices, ie turning off and removing revolving parts, scrape down the sides and bottom of the mixing container with a flat or straight edge trowel at least once to ensure complete blending of Components A + B + C. Note: Do not attempt to attend to unmixed material that may gather on the sides of the mixing container while mechanical or electrical parts are in motion.

Cool Substrates: Application attempted at material, ambient and substrate temperatures below 18°C (65°F) will result in a decrease in product workability and slower cure rates. Accelerated cure rates and improved flowability on cool substrates can be achieved via the addition of Sikafloor®-15 NA PurCem® Accelerator. Please refer to the Sikafloor-15NA product data sheet for complete use and mixing instructions.

Do not mix more material than can be applied within the working time limits (i.e. Pot Life) at the actual field temperature.

Application

Priming of concrete substrates is not usually required under typical circumstances. However, due to variations in concrete quality, surface conditions, surface preparation and ambient conditions, reference test areas are recommended to determine whether priming is required to prevent the possibility of blisters, debonding, pinholes and other aesthetic variations. Note: Given the fluidity and relatively thin-layer installation of Sikafloor-24 NA PurCem a primer for porous substrates or a scratch coat where the surface profile demands such, are highly recommended.

Primer:

Mix and apply a primer coat of Sikafloor-31NA PurCem at a yield of approximately 165 ft²/unit (15.3 m²/unit) per coat to achieve a complete 10 mils d.f.t. coverage of the substrate, using a short or medium nap roller. Work the priming resin well into the surface, making sure the floor is fully saturated and then pull back lightly with the roller to the required thickness. Prime retaining (anchor) grooves but do not fill. Allow a cure period of at least 3 hours at 68°F (20°C) before application of the screed mortar.

Scratch Coat:

Where the surface profile requires such, and where a flat floor is intended, mix and apply a scratch coat of Sikafloor-24 NA PurCem using steel trowels to spread the materials at a consumption of approximately 215 ft²/unit (20 m²/unit) per unit, achieving a minimum 40 mils (1 mm) thickness. This application must be applied to seal the concrete surface, fill in surface irregularities; including pock marks, non-moving control joints and cracks. (Note: Should the scratch coat at 40 mils (1 mm) not fill and level the irregularities, additional coats can be applied, observing the necessary intercoat curing times.) Allow a cure period of at least 3 hours at 20°C (68°F) before application of the screed.

Continued next page:
Screed:
Mix and pour the Sikafloor-24 NA PurCem onto the floor. Spread to the desired thickness, from 80 - 160 mils (2 - 4 mm), at approximate yield of 107 ft² (10 m²) per unit at 80 mils (2 mm), to 53.5 ft² (5 m²) per unit at 160 mils (4 mm), using a notched trowel or pin or cam gauge rake. Note: Take care to spread freshly mixed materials across the transition of previous applied mixes before the previously applied material begins to set. Immediately spike roll the surface to release trapped air in the matrix. Roller spikes must be at least three times longer than the applied product thickness. Allow a minimum 18 hours cure period at 68°F (20°C) before foot traffic.

Broadcast Application 125 mils (3 mm)

Body Coat: Priming or scratch coat of concrete substrates is not usually required under typical circumstances. However, due to variations in concrete quality, surface conditions, surface preparation and ambient conditions, reference test areas are recommended to determine whether priming is required to prevent the possibility of blisters, debonding, pinholes and other aesthetic variations.

Mix and pour the Sikafloor-24NA PurCem materials on the floor. Spread mixed material to approximately 107 ft² (10 m²) per unit at 80 mils (2 mm) using a screed gauge rake or trowel. Take care to spread newly mixed materials across the transition of previous applied mixes before the surface begins to set. Immediately spike roll the surface to release trapped air in the matrix. Broadcast selected aggregate to rejection. Aggregate must fall vertically to avoid surface defects / do not broadcast up to the transition line of new mixes, always broadcast 2 - 3 feet beyond the wet edge. Allow broadcast surface to cure sufficiently to be able to resist foot traffic without damaging the surface. Remove excess aggregate by sweeping or vacuuming until surface is free of all loose particles and dust. A topcoat of Sikafloor-31NA PurCem can be applied to lock in the aggregate. Allow a minimum 24 hour cure period at 68°F (20°C) before light traffic after the Sikafloor-31NA PurCem is applied.

Limitations

Notes on Limitations: Prior to application, measure and confirm Substrate Moisture Content, Ambient Relative Humidity, Ambient and Surface Temperature and Dew Point. During installation, confirm and record above values at least once every 3 hours, or more frequently whenever conditions change (e.g. Ambient Temperature rise/fall, Relative Humidity increase/decrease, etc.).

Material Temperature: Precondition material for at least 24 hours between 65° to 75°F (18° to 24°C). IMPORTANT: Product must be protected from freezing. If frozen, discard.

Ambient Temperature: Minimum/Maximum 50˚/85˚F (10˚/30˚C)

Substrate Temperature: Minimum/Maximum 50˚/85˚F (10˚/30˚C). Substrate temperature must be at least 5 °F (3°C) above measured Dew Point. Accelerated cure rates and improved flowability on cool substrates can be achieved via the addition of Sikafloor®-15 NA PurCem® Accelerator. Refer to Sikafloor-15NA PurCem Accelerator product data sheet for complete application information.

Mixing and Application must adhere to Material, Ambient and Substrate temperatures listed above or a decrease in product workability and slower cure rates will occur.

Relative Ambient Humidity: Minimum ambient humidity 30%
Maximum ambient humidity 85% (during application and curing)

Dew Point: Beware of condensation! The substrate must be at least 5°F (3°C) above the Dew Point to reduce the risk of condensation, which may lead to adhesion failure or “blushing” on the floor finish. Be aware that the substrate temperature may be lower than the ambient temperature. Calculate Dew Point from the substrate surface temperature, not the ambient temperature.

Mixing: Do not hand mix Sikafloor materials. Mechanically mix only. Do not thin this product. Addition of thinners (e.g. water, solvent, etc.) will slow cure and reduce ultimate properties of this product. On no account should thinners be added to the mix. Adding thinners will void any applicable Sika warranty.
Limitations

- Do not apply below 7°C (45°F) or above 38°C (100°F) / maximum relative humidity 85%. Use at temperatures between 7 - 18°C (45 - 64°F) requires addition of Sikafloor-15NA PurCem Accelerator. Refer to Sikafloor-15NA PurCem Accelerator product data sheet for complete application information. Use at temperatures around 38°C (100°F) is likely to result in reduced pot and working lives.
- Do not apply to polymer modified cement mortars (PCC) that may expand when sealed with an impervious resin.
- Do not apply to water-soaked, glistening-wet concrete substrates, (i.e. standing water)
- Do not apply to un-reinforced sand cement screeds, asphaltic or bitumen substrates, glazed tile or non-porous brick, tile and magnesite, copper, aluminum, soft wood, or urethane composition, elastomeric membranes, fiber reinforced polyester (FRP) composites.
- Do not apply to cracked or unsound substrates.
- Do not apply while ambient and substrate temperatures are rising, as pinholes may occur.
- Freshly applied material should be protected from dampness, condensation and water for at least 24 hrs.
- Protect substrate during application from condensation from pipes or any overhead leaks.
- Do not apply to vertical or overhead surfaces/ for vertical surfaces refer to Sikafloor-29NA PurCem.
- Do not featheredge.
- Applied material will follow undulations, depressions, lines, etc. of the underlying substrate. Visual appearance of the finished floor may vary, including, but not limited to, reflection of “waviness”, slab transitions, etc.
- Color uniformity cannot be completely guaranteed from batch to batch (numbered). Take care when using Sikafloor PurCem products to draw from inventory in batch number sequence, do not mix batch numbers in a single floor area.
- Will discolor over time when exposed to UV light and under certain artificial lighting conditions. Use Sikafloor-510 or 510N LPL as a solid color, UV resistant top coat. Use of clear, UV resistant top coats may not prevent discoloration of underlying materials.
- Do not apply Sikafloor to concrete substrate containing aggregates susceptible to ASR (Alkali Silica Reaction) due to risk of natural alkali redistribution below the Sikafloor product after application. If concrete substrate has or is suspected to have ASR (Alkali Silica Reaction) present, do not proceed. Consult with design professional prior to use.
- Any aggregate used with Sikafloor systems must be non-reactive and oven-dried.
- This product is not designed for negative side waterproofing.
- Hot steam cleaning may lead to delamination due to thermal shock. Where thermal shock resistance is required, use an alternate Sikafloor® NA Purcem® material, consult Sikafloor technical service for advice.
- Do not use on exterior, on-grade substrates; for interior use only.
- For professional use only by experienced applicators.

Application:

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Certificate # RC 510999
Certificate # FM 69711
Certificate # ISO 9001
Certificate # ISO 14001

Prior to each use of any Sikafloor product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, Product Label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800.933.7452 Nothing contained in any Sikafloor materials relieves the user of the obligation to read and follow the warnings and instructions for each Sikafloor product as set forth in the current Product Data Sheet, Product Label and Safety Data Sheet Prior to Product Use.

Keep container tightly closed. Keep out of reach of children. Not for internal consumption. For industrial use only. For professional use only.

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For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product.

In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet, product label and Safety Data Sheet which are available online at http://usa.sika.com/ or by calling Sika's Technical Service Department at 800.933.7452. Nothing contained in any Sikafloor materials relieves the user of the obligation to read and follow the warnings and instructions for each Sikafloor product as set forth in the current Product Data Sheet, product label and Safety Data Sheet prior to product use.

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Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

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