

SikaFiber®

BATCHING, PLACEMENT AND FINISHING

BUILDING TRUST



1. BATCHING

Fiber Type	Introduction Sequence		Recommended Slump (Inch)	Dose-able Bag Packaging	Mixing Time (Min)	Mixing Speed RPMs
	Truck Mixing	Central Mixing				
Micro Fibers	Middle to last Item	Beginning to middle	4 to 6	Yes	5	14
Macro Fibers	Last Item	Beginning to middle	4 to 6	Yes	5	14
Fiber Blends	Last Item	Beginning to middle	5 to 7	Yes	5	14
Steel Fibers	On aggregate or last	On aggregate or last	4 to 6	Open bag and Ribbon Feed	5	14

2. PLACEMENT

- a. Follow standard placement procedures. Vibratory screed will make significant improvement in placement and finishability.
- b. When placing a fiber reinforced slab it is important to have enough paste brought to the surface to help cover/set any fibers.

3. FINISHING

- a. Hard Trowel Finish
 - i. Always follow ACI 302 Guide to Concrete Floor and Slab Construction, finishing guidelines and use properly maintained tools. Many variables affect the timing of concrete finishing.
 - ii. The concrete is generally ready for hand floating when the concrete will support the finishers knee boards without more than approximately 1/8 in indentation.
 - iii. The slab surface is ready for machine floating, when the concrete can support a finisher without more than approximately a ¼ in indentation.
 - iv. Mechanical pan floating should not begin until the surface has stiffened so that footprints are barely perceived on the concrete surface.
 - v. If accelerator dosages are changed during the placement on large pours, make sure to evaluate and respond to those area separately.
 - vi. For least fiber exposure start with a slower blade speed and very low / low blade angle.
 - vii. The weight of a double blade riding power trowel is much greater than single blade walk behind unit. Lower weight units (single blade) may require the blade turned a slightly higher angle, as long as, it's not taking too much paste off of the surface. Sufficient paste is required to bury exposed fiber.
- b. Broom
 - i. After vibratory screed and initial bull float process, broom finishing should commence.
 - ii. The broom should be kept to a small angle to the surface to minimize fiber exposure.
 - iii. The broom should only be pushed or pulled in one direction.
 - iv. Broom type makes a very large difference in the outcome of the finished product.
 1. A short bristle brush usually has a stiffer bristle and will produce a higher chance of fiber exposure.
 2. A longer softer bristle broom will leave more cream at the surface and lay down the fibers at the surface.
 - v. Clean the broom as needed. Concrete build up on the broom will lead to patterning or clumps on the surface of the slab.

WE ARE THE CONCRETE FIBER EXPERTS™

PLEASE CONTACT YOUR SikaFiber® SALES REPRESENTATIVE WITH ANY ADDITIONAL QUESTIONS OR INFORMATION

SIKA CORPORATION • 201 Polito Avenue • Lyndhurst, NJ 07071 • Tel: 833 236 1255 • sikafibers@us.sika.com • usa.sika.com