

## PRODUCT DATA SHEET

# Sikafloor®-330

### FLEXIBLE POLYURETHANE MEMBRANE

#### PRODUCT DESCRIPTION

Sikafloor®-330 is an elastic, two part, solvent free, self leveling polyurethane resin system. Sikafloor®-330 is used as a self leveling wear course for the Sika Comfortfloor Systems.

#### USES

Sikafloor®-330 may only be used by experienced professionals.

Particularly suitable for all commercial and public buildings including healthcare facilities, schools, retail spaces, laboratories, nursing facilities, showrooms, lobbies, museums and office space. For interior use only.

#### CHARACTERISTICS / ADVANTAGES

- Low VOC emission
- Solvent free
- Flexible and resilient
- Non shrinking after cure
- High strength
- Reduces footfall sound

#### PRODUCT INFORMATION

<b>Packaging</b>	Component A	2.7 US gal.(10.2L). filled in a 5 gal pail
	Component B:	0.9 US gal.(3.5L).filled in a 1 gal pail .
	Component A+B:	3.6 US gal. (13.6L).
	Sikafloor SEP-N color Pack:	1 quart per 3.6 US gal. (13.6L)
<b>Shelf Life</b>	6 months in original unopened container.	

<b>Storage Conditions</b>	Store material in a dry, cool 50–86 °F (10–30 °C) environment. Avoid prolonged storage at temperatures below 41 °F (5 °C) or above 86 °F (30 °C.) Prolonged vibration and higher ambient temperatures during transportation can result in settling of the component A. Premixing of the component A is required.
<b>Appearance / Color</b>	Refer to Sika Comfort floor Color Additives Selection Guide. Be aware of the color of Sikafloor®-330 should be close to the color of the Sikafloor 305 W Topcoat to ensure good hiding characteristics.
<b>Volatile organic compound (VOC) content</b>	15 g/l (Sikafloor®-330 (A) neutral + Sikafloor®-330 (B) Combined) 25 g/l (Sikafloor®-330 (A) custom color or color Additive + Sikafloor®-330 (B) Combined)

## TECHNICAL INFORMATION

<b>Shore A Hardness</b>	>80 (14 days)	ASTM D2240 73°F (23°C) and 50% R.H
<b>Tensile Strength</b>	1,142 psi.(~ 8.0 N/mm <sup>2</sup> )	ASTM D412 at 73°F(23°C) and 50% R.H
<b>Elongation at Break</b>	~180 % (14 days)	ASTM D412 73°F (23°C) and 50% R.H
<b>Tensile Adhesion Strength</b>	> 400 psi (concrete failure)	ASTM D4541 73°F (23°C) and 50% R.H
<b>Tear Strength</b>	142.75 lb./in.(~ 25 N/mm 14 days)	ASTM D624 at 73°F(23°C) and 50% R.H
<b>Chemical Resistance</b>	Sikafloor®-330 must be sealed with Sikafloor® 305 W or another suitable Sikafloor® topcoat. For chemical resistance of the system, Please consult Sikafloor® Technical Services.	

## APPLICATION INFORMATION

<b>Coverage</b>	For ComfortFloor systems, applied film thickness should be 80 mils or 20 square feet per gallon. Theoretical coverage is 72 sq.ft per 3.61 kit	
<b>Pot Life</b>	<b>Temperature</b>	<b>Time</b>
	50 °F (10 °C)	~ 21 minutes
	68 °F (20 °C)	~ 15 minutes
	86 °F (30 °C)	~ 12 minutes
<b>Cure Time</b>	Before overcoating Sikafloor®-330 allow:	
	<b>Substrate temperature</b>	<b>Minimum</b> <b>Maximum</b>
	50 °F (10 °C)	24 hours                      72 hours
	68 °F (20 °C)	16 hours                      48 hours
	86 °F (30 °C)	16 hours                      36 hours
<b>Waiting / Recoat Times</b>	Before applying Sikafloor®-330 on Sikafloor® 161 allow 6 to 24 hours @ 77 °F (25 °C). Apply Sikafloor®-330 to Sikafloor Comfort Porefiller 8 to 60 hours @ 68 °F (20 °C) after application of the Porefiller.	

## BASIS OF PRODUCT 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.

## LIMITATIONS

- Do not apply Sikafloor®-330 on substrates with rising moisture.
- Do not apply on substrate surfaces with a slope > 1 %.
- Freshly applied Sikafloor®-330 must be protected from damp, condensation and water for at least 24 hours.
- Uncured material reacts in contact with water which will result in foaming. During application, care must be taken that no sweat drops into fresh Sikafloor®-330 (wear head and wrist bands).
- If heating is required to bring the substrate and environment temperature to recommended levels, use only electric powered air blower systems. Do not use gas, oil, paraffin or other fossil fuel heaters, these produce large quantities of both carbon dioxide and water vapor, which may adversely affect the finish.

**Substrate Temperature:** 50 °F (10 °C) min. / 86 °F (30 °C) max.

**Ambient Temperature:** 50 °F (10 °C) min. / 86 °F (30 °C) max.

**Substrate Moisture Content:** Moisture content of concrete substrate must be ≤ 4% by mass (pbw – part by weight) as measured with a Tramex® CME/CMExpert type concrete moisture meter on mechanically prepared surface according to this product data sheet.

(preparation to CSP-3 to CSP-4 as per ICRI guidelines). Do not apply to concrete substrate with moisture levels > 4% mass (pbw – part by weight) as measured with Tramex® CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate is > 4% by mass (pbw – part by weight) as measured with Tramex® CME/CMExpert type concrete moisture meter, use Sikafloor 1620 or Sikafloor PurCem® 22NA or Sikafloor PurCem® 24NA . When relative humidity tests for concrete substrate are conducted per ASTM F2170 for project specific requirements, values must be ≤ 85%. If values are > 85% according to ASTM F2170 use Sikafloor 1620 or Sikafloor PurCem® 22 NA or Sikafloor PurCem® 24 NA .

ASTM F2170 testing is not a substitute for measuring substrate moisture content. Use a Tramex® CME/CMExpert type concrete moisture meter as described above.

**Material Temperature:** Precondition material for at least 24 hours between 65° to 75°F (18° to 24°C)

**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 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:** Maximum ambient humidity 75% (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. Mixing: Do not hand mix Sikafloor materials. Mechanically mix only.

- If heating is required do not use gas, oil, paraffin or other fossil fuel heaters since these heaters produce large quantities of both carbon dioxide and water vapor, which may adversely affect the finish. For heating use only electric powered warm air blower systems.
- Do not apply while ambient and substrate temperatures are rising, as pinholes may occur.
- 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.
- Use of unvented heaters and certain heat sources may result in defects (e.g. blushing, whitening, debonding, etc.).
- Beware of air flow and changes in air flow. Introduction of dust, debris, and particles, etc. may result in surface imperfections and other defects.
- For professional use only by experienced applicators.

### Product Data Sheet

Sikafloor®-330

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## ENVIRONMENTAL, HEALTH AND SAFETY

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

## APPLICATION INSTRUCTIONS

### SURFACE PREPARATION

Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, Preparation bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc should be dressed off to achieve a level surface prior to the application.

Concrete should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by shot blasting or equivalent mechanical means. (CSP-3 as per ICRI guidelines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. Whenever "shot-blasting" is utilized, be careful to leave concrete with a uniform texture.

Over "blasting" will result in reduced coverage rates of the primer and/or subsequent topcoats. The compressive strength of the concrete substrate should be at least 3,626 psi (25 MPa) with minimum pull of strength of 218psi (1.5 MPa) in tension at the time of application of Sikafloor®-330. Sikafloor®-330 should be applied following sealing of the mat with Sika Comfort Porefiller in the Sika ComfortFloor® Pro System and following prep of the slab and placement of Sikafloor® 160, Sikafloor® 161, Sikafloor® 1610, Sikafloor® 2570 and Sikafloor® 264, Primer in the Sika ComfortFloor® System.

## MIXING

Mix full units only.

Sikafloor®-330 must be thoroughly mixed using a low speed drill and jiffy blade (300–400 rpm). Premix the Resin A Component for a minimum of 2 minutes and check the mixture for lumps. If lumps are present, continue mixing until homogenous.

Add the color paste and mix again for 2 minutes. Add the complete contents of the Hardener B Component and thoroughly mix resin and hardener to a homogeneous mixture. Do not dilute.

Pour the mixture through a 0.5–1 mm sieve into a separate clean pail and mix for an additional 30 seconds to assure there is no unmixed material from the sides and bottom of the first pail present in the pour. Do not scrape the sides of the pail. Over mixing must be avoided to minimize air entrainment.

## APPLICATION

Levelling: Rough surfaces need to be leveled prior to application of a self leveling screed material. See Sikafloor® 161 Technical Data Sheet for information regarding leveling of the application area or call Sika Technical service at 800-933-SIKA. (see TDS).

### Self-smoothing system 80 mils (2.0 mm)

This product is a continuous flooring application. It is imperative that all materials and equipment be present and in working order to ensure no lapse in the mix to mix installation.

To gain the maximum flow properties, the full contents of the mixture should be poured out as quickly as possible (within the potlife). Sikafloor®-330 is poured and spread evenly by means of a swedish knife, knotted trowel, pin rake or a serrated squeegee.

## OTHER RESTRICTIONS

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or 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 label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA 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 if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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