



PRODUCT DATA SHEET

SikaPronto®-19 4K

High Molecular Weight Methacrylate, Wax-Free, Resin Primer

PRODUCT DESCRIPTION

SikaPronto®-19 4K is a 3-component high modulus, high molecular weight methacrylate, 100% solids penetrating sealer for horizontal concrete. SikaPronto®-19 4K can be modified to a 4-component system with the addition of accelerator for colder climates.

USES

SikaPronto®-19 4K may only be used by experienced professionals.

- Used on above grade concrete and mortar.
- Seals surface of concrete from water and chlorides.
- Primer for SikaPronto®-500 PPC applications.

CHARACTERISTICS / ADVANTAGES

- 100% solids/reactive formula
- Low viscosity for easy, topical applications
- Penetrates cracks by gravity
- Provides a structural repair to cracked concrete.
- Easy handling, workability, mixing
- Prolongs life of cracked concrete
- High bond strength
- Low odor
- Opens to traffic in within 1.5-3 hours at temperatures 40°F and rising

PRODUCT INFORMATION

Packaging	Part 'A' Resin	5 gal. pails, 55 gal. drums
	Part 'B' Norox® MEKP-9	1 gal. container, 5 gal. pails
	Part 'C' Duroct Cobalt 6%	1 gal. container, 5 gal. pails
	Part 'D' DMAA Accelerator (Optional)	1 gal. container, 5 gal. pails
Shelf Life	6 months in original, unopened containers	
Storage Conditions	All components shall be kept separate from one another, specifically the Part 'B' Norox® MEKP-9 and Part 'C' Duroct Cobalt 6%. WARNING!!! DO NOT MIX SikaPronto®-19 4K Part 'B' Norox® MEKP-9 and SikaPronto®-19 4K Part 'C' Duroct Cobalt 6% directly!!! A FLASH FIRE WILL OCCUR!!	

Density	Specific Gravity	1.05	(ASTM D-1475)
	Flash Point	>180°F	(ASTM D-3278)
	Vapor Pressure	<0.1 mm Hg	(ASTM D-323)
Viscosity	< 25 cps		(ASTM D-2196)
Volatile organic compound (VOC) content	15%		(ASTM D-2369)

TECHNICAL INFORMATION

Shore D Hardness	7 days	76	(ASTM D-2240)
Compressive Strength	2 h	7,100 psi (48.9 MPa)	Compressive Yield Strength (ASTM D-695)
	24 h	7,300 psi (50.3 MPa)	
	3 days	11,000 psi (75.8 MPa)	Crushing Strength (ASTM D-695)
	7 days	12,600 psi (86.9 MPa)	
Flexural Strength	> 750 psi		(CTM-551)
Tensile Strength	3 days	3,700 psi (25.5 MPa)	(ASTM D-638)
	7 days	4,500 psi (31.0 MPa)	
Tensile Adhesion Strength	> 500 psi		(CTM-551)
	7 days	1,700 psi (11.7 MPa)	Slant Shear Bond Strength (ASTM C-882)
Mixing Ratio	Refer to the Initiator Cure Matrix for the correct amount of DMAA Accelerator for temperatures below 65°F (18°C)		
	Small Batch		
	Part 'A' Resin	1 gallon (3.78 L)	
	Part 'B' Norox® MEKP-9	1.0 fl. oz. (30 ml)	
	Part 'C' Duroct Cobalt 6%	0.25 fl. oz. (7.5 ml)	
	Large Batch		
	Part 'A' Resin	4.5 gallon (17.0 L)	
	Part 'B' Norox® MEKP-9	4.0 fl. oz. (120 ml)	
	Part 'C' Duroct Cobalt 6%	1.0 fl. oz. (30 ml)	
	WARNING!!! DO NOT MIX SikaPronto®-19 4K Part 'C' Duroct Cobalt 6% and SikaPronto®-19 4K Part 'B' MEKP-9 directly!!! A FLASH FIRE WILL OCCUR!		
Coverage	Theoretical Coverage rate: 100-150 ft ² /gal Coverage rates are dependent on porosity of substrate. In addition, allowance must be made for surface profile, unavoidable variation in applied film thickness, loss and waste. Tined concrete, cracks, spalls, and pop offs will consume more material.		
Ambient Air Temperature	Minimum ambient air temperature of 40°F (4°C). Maximum ambient air temperature of 110°F (43°C)		

Cure Time

Initiator Cure Matrix

Recommended dosages of SikaPronto®-19 4K are designed to have a 20-40 minute pot life in the following temperature ranges.

Temperature	4.5 gallons of SikaPronto®-19 4K Part 'A' Resin	1 gallon of SikaPronto®-19 4K Part 'A' Resin
40-65°F (4-18°C)	Part 'B' Norox MEKP-9 4.0 fl.oz. (120 ml) Part 'C' Duroct Cobalt 6% 1.0 fl.oz. (30 ml) Part 'D' DMAA Accelerator 10 ml (optional)	Part 'B' Norox MEKP-9 1.0 fl.oz. (30 ml) Part 'C' Duroct Cobalt 6% 0.25 fl.oz. (7.5 ml) Part 'D' DMAA Accelerator 2 ml (optional)
66-95°F (18-35°C)*	Part 'B' Norox MEKP-9 4.0 fl.oz. (120 ml) Part 'C' Duroct Cobalt 6% 1.0 fl.oz. (30 ml)	Part 'B' Norox MEKP-9 1.0 fl.oz. (30 ml) Part 'C' Duroct Cobalt 6% 0.25 fl.oz. (7.5 ml)

*For application temperatures above 95°F (35°C) consider a night time application. Contact Sika Technical Services.

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

- **WARNING!!! DO NOT MIX SikaPronto®-19 4K Part 'C' DUROCT COBALT 6% and SikaPronto®-19 4K Part 'B' NOROX® MEKP-9 directly!!! A FLASH FIRE WILL OCCUR!**
- **Take all necessary precautions to prevent SikaPronto®-19 4K Part 'C' DUROCT COBALT 6% and SikaPronto®-19 4K Part 'B' NOROX® MEKP-9 from contacting each other at any time during mixing, storage, clean-up or shipping.**
- For extreme temperatures, refer to initiator cure matrix for proper dosage of initiator, promoter, and accelerator.
- Working time will be greatly reduced at elevated temperatures. Consider a night time application for warmer climate regions.
- Do not use SikaPronto®-19 4K at relative humidity > 90% or if rain is forecast within the specified rain resistance period.
- Do not delay application of SikaPronto®-19 4K on substrate more than 5 minutes @ 73°F (23°C). Rapid curing will take place if resin mixture is left unattended in pail.
- Do not delay overlay of SikaPronto®-500 PPC more than 20 minutes @ 73°F (23°C).
- Do not thin. Addition of solvents will prevent proper cure.
- Minimum ambient temperature for application is 40°F (4°C).
- Minimum age of concrete is 21-28 days, depending on curing and drying conditions.

- Moisture content must be below 5%.
- Sealed concrete surface may appear blotchy due to differential absorption.
- Not designed to seal cracks subject to hydrostatic pressure at the time of application.
- For horizontal applications only.
- Addition of DMAA Accelerator is recommended for substrate temperatures below 65°F (18°C).
- Not recommended for use on asphalt.

ENVIRONMENTAL, HEALTH AND SAFETY

For more 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.

SURFACE PREPARATION

Substrate must be clean, sound and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e. blast cleaning). Substrate shall be dry and moisture content shall be <5% when measured via Tramex moisture meter.

MIXING

To avoid a hazardous, violent reaction, follow the mixing sequence exactly. Use appropriate measuring tools (i.e. syringes, pipettes, measuring cups) to ensure accurate dosage of SikaPronto®-19 4K. Refer to the Initiator Cure Matrix for proper initiator amounts at the current ambient and substrate temperatures.

For a small batch of SikaPronto®-19 4K, Add approximately 1.0 fl. oz. (30 ml) of SikaPronto®-19 4K Part 'B' Norox® MEKP-9 to 1 gallon of SikaPronto®-19 4K Part 'A' Resin. Mix with a jiffy paddle at 300 rpm for 20-30 seconds. For temperatures below 65°F (18°C), 2 ml of DMAA accelerator can be added to the resin mixture to facilitate curing of SikaPronto®-19 4K. If DMAA Accelerator is to be used, it should be added after the SikaPronto®-19 4K Part 'B' Norox® MEKP-9, and mixed in for 10-15 seconds before the addition of the SikaPronto®-19 4K Part 'C' Duroct Cobalt 6%. Then add 0.25 fl. oz. (7.5 ml) of SikaPronto®-19 4K Part 'C' Duroct Cobalt 6% and mix at same speed for another 20-30 seconds.

Never mix SikaPronto®-19 4K Part 'B' Norox® MEKP-9 with SikaPronto®-19 4K Part 'C' Duroct Cobalt 6%, a violent chemical reaction will occur!

APPLICATION

SikaPronto®-19 4K is applied to horizontal surfaces by roller, squeegee, or broom. Spread material over area and allow to pond over cracks. Let material penetrate into cracks and substrate; remove excess material leaving no visible surface film. For cracks greater than 1/8 in. (3 mm) wide, fill crack with oven-dried sand before applying SikaPronto®-19 4K. Seal cracks from underside, when accessible, to prevent leakage.

CLEANING OF TOOLS

Equipment should be cleaned immediately with an approved solvent (e.g. Acetone, MEK, or Xylene). Once the material has cured, it can only be removed using mechanical means.

OTHER RESTRICTIONS

See Legal Disclaimer.

LEGAL DISCLAIMER

- 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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