

PRODUCT DATA SHEET

Sikafloor®-1230

SELF-SMOOTHING, TOTAL SOLIDS, EPOXY RESIN FOR FLOORING APPLICATION

DESCRIPTION

Sikafloor®-1230 is a multi-component, self-smoothing, total solids epoxy overlay floor system designed to provide durable and seamless protection for concrete floors. The cured material forms a dense, coloured, glossy surface with excellent mechanical strength and durability.

USES

Sikafloor®-1230 provides excellent wear and abrasion resistance, making it ideal for floors subjected to high-volume traffic. The smooth, ultra-dense, and high gloss finish offers a hygienic and easily cleaned surface, perfectly suited for environments requiring cleanliness and durability.

Sikafloor®-1230 may be applied in the following industries:

- Food production and processing facilities
- Beverage production areas, including soft drink manufacturing
- Pharmaceutical facilities, laboratories and clean rooms
- Engineering workshops and assembly lines
- Showrooms and demonstration areas
- Industrial and commercial cold kitchens
- Retail spaces
- Schools, hospitals and hotels

FEATURES

- Easy to apply
- Smooth, high gloss finish suitable for hygienic applications
- Seamless and easily cleanable surface
- Excellent wear and abrasion resistance
- Good chemical and mechanical resistance

PRODUCT INFORMATION

Composition	Epoxy resin, selected fillers and pigments
Packaging	Supplied as a 38 kg multi-component pack
Colour	Sikafloor®-1230 is available in various colour shades. Please contact your Sika sales representative for the colour chart. Under direct sun light there may be some discolouration and colour variation; this has no influence on the function and performance of the coating.

Shelf life	Approximately 12 months from date of production
Storage conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5°C and +30°C.
Density	~1.79 kg/l (mixed, at 25°C)
Solid content by mass	~100 %

TECHNICAL INFORMATION

Shore D Hardness	67	(ASTM D2240)
Abrasion resistance	~50 mg (CS17 Wheel / 1000 cycles / 1000 g weight)	(ASTM D4060)
Resistance to impact	Passes (2 meters with 1.5 kg)	(EN ISO 6272-1: 2011)
Compressive strength	≥ 85 N/mm ² (7 days)	(ASTM C579)
Flexural-strength	≥ 37 N/mm ²	(ASTM C580-18)
Tensile strength	≥ 20 N/mm ²	(ASTM C307)
Tensile adhesion strength	3 N/mm ²	(ASTM D4541)
Water absorption	≤ 0.05%	(ASTM C413)

APPLICATION INFORMATION

Consumption	As a general guide: ~1.8 kg/m²/mm applied as a self-smoothing wearing course. For additional and more detailed information please refer to General Method Statement. Always prime the surface before application of self-smoothing layer. These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level or wastage etc. Sikafloor®-1230 components are supplied in preweighed packs which should not be split or divided. Always mix a full kit.		
Layer thickness	Min. 2 mm Max. 4 mm		
Ambient air temperature	+10°C min. to +30°C max.		
Relative air humidity	80 % r.h. max.		
Dew point	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. Note: Low temperatures and high humidity conditions increase the probability of blooming.		
Substrate temperature	+10°C min. to +30°C max.		
Substrate moisture content	< 4 % pbw moisture content. Test method: Sika®-Tramex meter, CM-measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).		
Pot Life	~35 min (at 25°C)		
Applied product ready for use	Temperature	Foot traffic	Full cure
	+25°C	~24 hours	~7 days

BASIS OF PRODUCT DATA

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

IMPORTANT CONSIDERATIONS

- Do not apply Sikafloor®-1230 on substrates with rising moisture. In case of rising substrate moisture, use the EpoCem® technology range of products and contact the Sika Technical Department for recommendations.
- Freshly applied Sikafloor®-1230 must be protected from dampness, condensation, and water for at least 24 hours after application.
- Incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.
- For exact colour matching, ensure that Sikafloor®-1230 in each area is applied from the same control batch numbers.
- Do not expose the product to chemical or mechanical strain at elevated temperatures.
- Expansion joints in the existing substrate floor must be continued (mirrored) through the Sikafloor®-1230 coating.
- Damaged or deeply pitted areas can be repaired and levelled using Sikafloor®-1230 filled with additional aggregate.
- It is essential to prime or seal the concrete surface before applying Sikafloor®-1230 to prevent air from the substrate rising through the coating during curing. Contact the Sika Technical Department for recommendations.
- Sikafloor®-1230 can be applied to glazed and terrazzo tiles, steel, and timber. For applications other than concrete, contact your Sika® representative.
- Sikafloor®-1230 offers good general resistance to a broad spectrum of chemical agents. However, a full analysis of operating conditions and reference to chemical resistance data are required to ensure product suitability for specific chemical exposures.

ECOLOGY, HEALTH AND SAFETY

For 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.

APPLICATION INSTRUCTIONS

EQUIPMENT

- Vacuum recovery shot blasting machine
- Masking tape / polythene sheets
- Heaters for cold weather work
- Trowels
- Slow speed drill with suitable paddle
- Brushes or short nap hair rollers
- Industrial vacuum
- Scarifier
- Grinder
- Overalls
- Lighting
- Spiked roller
- Spiked shoes
- Pin screed

SUBSTRATE PREPARATION

The concrete substrate must be sound, with a minimum compressive strength of 25 N/mm² and a minimum pull-off strength of 1.5 N/mm². The substrate must be clean, dry, and free from all contaminants such as dirt, oil, grease, coatings, sealers, and surface treatments. Concrete surfaces must be prepared mechanically using suitable methods such as light grit blasting, captive blasting, or surface grinding to achieve a clean, open-textured surface. All weak or unsound concrete must be removed, and any surface defects such as blowholes and voids must be fully exposed. Repairs to the substrate, including the filling of blowholes, voids, and surface irregularities, must be completed using appropriate materials from the Sikafloor®, Sikadur®, or SikaEmaco® product ranges. Before applying the product, all dust, loose, and friable material must be completely removed from all surfaces, preferably by vacuum cleaning or brushing. The preferred method of surface preparation for concrete substrates is captive blasting, as it provides a laitance-free, well-prepared, and vacuum-cleaned surface.

MIXING

Prior to mixing and application, Sikafloor®-1230 must be stored under cover in a dry, air-conditioned environment and protected from extreme temperatures. Exposure to heat or cold may affect the product's workability, finish, and curing characteristics. Pour the entire contents of the Colour Pack into the Base (Part A) and mix thoroughly using a slow-speed electric drill (300–600 rpm) fitted with a suitable spiral or helical mixing paddle. Mix for at least one minute until a uniform consistency is achieved. Transfer the pre-mixed material into a clean, large mixing container. While continuing to mix, gradually add the Sikafloor®-1230 Filler (Part C) and mix until a homogeneous, streak-free colour is obtained, free from lumps of unmixed filler (minimum two minutes). After obtaining a uniform mixture, remix for approximately 30 seconds, then add the Reactor (Part B) and continue mixing until a consistent, even colour is achieved and no streaks or lumps remain. Always maintain the same mixing time and procedure for all batches to ensure uniform colour and finish throughout the application.

APPLICATION

Prior to application, confirm substrate moisture content, relative air humidity and dew point. If > 4 % pbw moisture content, Sikagard® EpoCem® may be applied as a T.M.B. (temporary moisture barrier) system.

Primer:

Make sure that a continuous, pore free coat covers the substrate. If necessary, apply two priming coats. Apply primer by brush, roller or squeegee. Preferred application is by using a squeegee and then back-rolling crosswise.

Smooth wearing course:

Mixed Sikafloor®-1230 is poured and spreaded evenly by means of a serrated trowel or pin rake. After spreading the material evenly, turn the serrated trowel and smooth the surface in order to achieve an aesthetically higher grade of finish. Roll immediately (before material begins to gel) in two directions with a spiked roller to ensure even thickness.

CLEANING OF EQUIPMENT

Clean all tools and application equipment with suitable thinner, immediately after use. Hardened and/or cured material can only be removed mechanically.

MAINTENANCE INSTRUCTIONS

To maintain the appearance of the floor after application, Sikafloor®-1230 must have all spillages removed immediately and must be regularly cleaned using rotary brush, mechanical scrubbers, scrubber dryer, high pressure washer, wash and vacuum techniques, etc. using suitable detergents and waxes.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

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. It may be necessary to adapt the above disclaimer to specific local laws and regulations. Any changes to this disclaimer may only be implemented with permission of Sika® Corporate Legal in Baar.

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