

Method Statement for Application Of **Sikafloor -94**

“SIKA EGYPT” Flooring Systems

Scope: **Sikafloor -94** a two component,
solvent free, low viscosity epoxy primer.

Limitation

- Minimum age of cementitious substrate (3-6) weeks depending on climate conditions and curing, unless we use one of Epocem's technology products
- The compressive strength should be ≥ 25 N/mm² or to meet defined loads.
- The adhesive tensile strength should be ≥ 1.5 N/mm²
- The moisture content in the concrete should be $< 4\%$
- The relative humidity should be $< 80\%$
- The bearing layer surface temperature should be 3°C degrees above the determined dew point temperature in order to avoid water condensation.
- Minimum substrate temperature + 10°C

SUBSTRATE PREPARATION

The substrate must be clean, sound, and of sufficient strength (min. compressive strength 25 N/mm²).

The surface must be even, fine gripping, dense, dry (moisture content < 4% for cementitious substrates) and free from loose or friable particles and of any other contamination. Minimum surface pull-off strength 1.5 N/mm².

Unsound layers, cement laitance, loose and friable particles and contaminations must be removed mechanically. Vacuuming up of dust is absolutely necessary.

3. Substrate Requirements**3.1 Pull off and compressive strength**

The concrete substrate must be sound and of sufficient compressive strength (minimum 25 N/mm²) with a minimum pull off strength of 1.5 N/mm².

The substrate must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings and surface treatments, etc.

If in doubt, apply a test area first.



Testing of the substrate
Pull-off strength > 1.5 N/mm².
E.g. Proceq, Dyna pull-off tester.

3.2 Moisture content

Prior to application, confirm substrate moisture content, r.h. and dew point.
If > 4% pbw moisture content, Sikafloor[®] EpoCem[®] may be applied as a T.M.B. (temporary moisture barrier) system.



Measuring of the substrate moisture:
Moisture content < 4% by weight.
E.g. Sika Tramex moisture meter.

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Tramex moisture meter.

There must be no rising moisture according to ASTM D 4263 (Polyethylene sheet test)



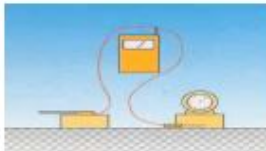
< 4% pbw if priming with Sikafloor[®]-

> 4% pbw application of a temporary moisture barrier with Sikafloor[®]-81 EpoCem (please refer to Sikafloor-81 EpoCem Product Data Sheet)

3.3 Ambient and surface temperature

Ambient and Surface temperature:

- Min. +10°C (but at least 3°C above dew point)
- Max. +30°C



Defining the climatic conditions:
Substrate temp. > 3°C above dew point
E.g. thermometer, hygrometer, dew point table.

MIXING

Primer

Mix ratio: **Sikafloor 94 Primer**

A : B = 66 : 34 pbw (equal to 2 : 1)

Add component B in the right mixing ratio to Component A and mix by means of a slow speed electric stirrer (approx. 300 - 400 rpm). Mix for at least 3 minutes until a homogeneous mixture is obtained. Fill into a clean container.



Prior to mixing, stir component A (resin) and add all of component B (hardener).



Make sure the hardener is fully emptied into the resin component



Mix both components thoroughly with a low speed electric stirrer (300 - 400 rpm).



Mix for at least 3 minutes until a uniform mix has been achieved.

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7. Application of Sikafloor- 94 as a Primer

Make sure, that all substrate requirements are met, such as temperature, moisture content of the prepared substrate etc. (please refer to section 5). Apply Sikafloor-161, if the moisture content is below 4%, (test method: Sika-Tramex, or CM-measurement or Oven-dry-method; no rising moisture according to ASTM (Polyethylene-sheet)). If the moisture content is above 4%, apply Sikafloor EpoCem system as a temporary moisture barrier – please refer to the PDS).

Apply the mixed material by roller, taking care to ensure good wetting of the substrate but avoiding puddles on the surface. Work within the potlife of the material (15 minutes at 30°C).

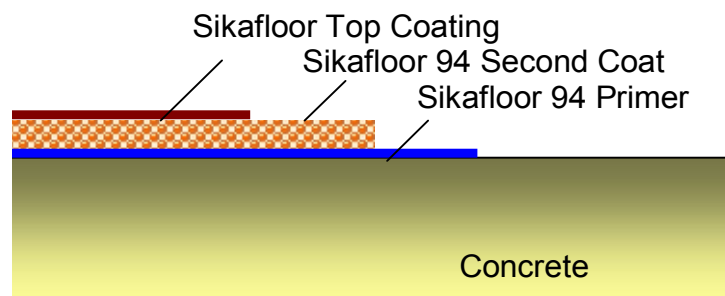
Clean all tools and application equipment with Thinner C immediately after use. Hardened and / or cured material can only be removed mechanically.

Freshly applied Sikafloor®- 94 should be protected from damp, condensation and water for at least 24 hours. Sikafloor®- 94 mortar screed is not suitable for frequent or permanent contact with water unless sealed.



Apply by brush, roller or squeegee and work well into the substrate.

Apply **Sikafloor 94** by brush or roller using a consumption of approx. 0.2-0.3 kg/m². Work the primer coat firmly into the substrate to ensure entire wetting out of the surface.



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WAITING TIMES

<i>Between Sikafloor 94 and top Coat</i>	<i>10°C</i>	<i>20°C</i>	<i>30°C</i>
Minimum	15 hours	8 hours	Approx. 5 h.
Maximum	3 days	2 days	36 hours

REMARKS

- Ambient and substrate temperature Min. +10°C (but at least + 3°C above dew point) and max. +30°C
- Relative air humidity max. 80%

CLEANING

Clean all tools and equipment immediately after use with Thinner C or Colma Cleaner. Hardened material can only be removed mechanically.

Safety

Health and safety instructions on the latest Technical Data Sheet must be strictly observed.

For any additional information, please do not hesitate to consult our Technical Services Department.

Technical Department.



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