


Epo Cem[®]

SikaGard[®] 720 EpoCem[®]

Epoxy Cement Waterproof Levelling Mortar

Technical Data Sheet

DESCRIPTION

SikaGard 720 EpoCem is a three component epoxy modified cementitious mortar.

USES

- * Levelling concrete, mortar or stone surfaces.
- * Repairing minor defects.
- * Protecting concrete in aggressive environments.
- * A pore sealer.
- * Temporary dpm (+2.0 mm).
- * For exterior and interior use.

ADVANTAGES

- * Pre batched for quality.
- * Good chemical resistance.
- * Compatible with **Sika[®] FerroGard[®]** corrosion inhibitors.
- * Easy to mix and apply.
- * Excellent bond to concrete.
- * Contains no chloride admixtures.
- * Waterproof.
- * Overcoatable with **Sika** concrete and floor coatings.
- * Low shrinkage.
- * Vapour permeable.
- * Good mechanical properties.
- * Does not require overcoating.
- * Reduced curing practice.
- * Overcoatable next day.

Technical Data (typical)

Mixed colour:	Grey
Mixed wet density:	2.0 kg/litre
Application temperature:	+5°C min, +30°C max (Substrate and ambient)
Application thickness per layer:	0.5 mm minimum 3.0 mm maximum Small areas up to 5.0 mm

MECHANICAL PROPERTIES 28 days @ 20°C

Compressive strength:	40 N/mm ²
Flexural strength:	9.0 N/mm ²
Bond strength (tensile):	2.5 - 3.5 N/mm ² (Substrate failure)
E-Modulus (static):	12.6 kN/mm ²
Coefficient of thermal expansion:	18 x 10 ⁻⁶ °C ⁻¹
Index of resistance to diffusion of water vapour (μH₂O):	850
Index of resistance to diffusion of carbon dioxide (μCO₂):	34,000
Water absorption coefficient A:	0.03 kg/m ² x h ^{0.5}
'Working time': (@23°C)	40 minutes

All above values are approximate.

SURFACE PREPARATION

Prepare and clean all concrete surfaces by suitable mechanical means such as abrasive blast cleaning or equivalent to ensure cement laitance, surface contamination and all existing coatings are removed and all blowholes and honeycombed areas are exposed.

MIXING

Add component A to component B, shake well for approximately 30 seconds. Pour binder (component A+B) into mixing vessel, add component C and mix thoroughly with suitable low-speed electric mixer for 3 minutes.

SikaGard 720 EpoCem should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

APPLICATION

The surface should be pre-wetted to a saturated surface dry condition before application.

Prefill localised cavities/pores, minor defects etc with **SikaGard 720 EpoCem** before applying final sealing/levelling coat.

Apply by spatula or trowel and finish with a moist neoprene sponge or brush.

IMPORTANT CONSIDERATIONS

- * Do not add water.
- * Do not finish surface with solvent or water.
- * Apply only to prepared, sound substrates.
- * Protect from drying winds and direct sun.
- * Allow repair mortar to harden between applications.
- * Protect from rain for 24 hours.
- * Protect freshly applied material from freezing.

CLEANING

Remove **SikaGard 720 EpoCem** from tools and equipment with water. Hardened material can only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

2.0 kg/m²/mm (2.0 kg/litre)
Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 6 months in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).



Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Please consult our Technical Sales Department for further information

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Epo Cem[®]

SikaTop[®] Armatec 110

EpoCem[®]

Resin Based Steel Reinforcement Primer and Bonding Bridge

Technical Data Sheet

DESCRIPTION

SikaTop Armatec 110 EpoCem is a three component cement modified epoxy resin based anti-corrosive product containing corrosion inhibitors. It has been specifically formulated as a reinforcement primer and bonding bridge for concrete repair mortars.

USES

SikaTop 110 EpoCem may be used to bond concrete repair mortars, screeds or cementitious overlays to existing cementitious substrates. The material is also used as a steel corrosion primer to protect reinforcement in areas of low cover and in the presence of chlorides.

ADVANTAGES

- * Excellent adhesion to both steel and concrete.
- * Contains corrosion inhibitors.
- * Additional barrier to the passage of water and chlorides.
- * Excellent bonding bridge for cement or epoxy based repair mortars.
- * High strength, unaffected by moisture when cured.
- * Spray, brush or roller application.
- * Non-flammable.
- * Solvent free.
- * Long open times.
- * Suitable for drinking water contact.

Technical Data (typical)

Mixed colour:	Grey
Mixed density:	Approx. 2.0 kg/litre
Volume solids:	100%
Application temperatures:	+5°C minimum and rising +30°C maximum (Substrate and ambient)
COATING SYSTEM:	
Steel reinforcement primer:	2 x 1 mm SikaTop Armatec 110 EpoCem
Bonding Bridge:	1 - 2 x SikaTop Armatec 110 EpoCem
Bond strengths:	Concrete: 1 - 3 N/mm ² Steel: 1 - 2 N/mm ²
Index of resistance to diffusion of water vapour: (μH ₂ O)	100
Index of resistance to diffusion of carbon dioxide: (μCO ₂)	14,000
Pot life: (23°C)	90 - 120 minutes (Subject to temperature)
Waiting times between coats:	Minimum 2 hours Maximum 16 hours
Open times of bonding bridge for repair mortar application (hrs):	+5°C +10°C +20°C +30°C 20 16 12 8

Approved for potable water contact.
Details available on request.

All above values are approximate.

CONCRETE SUBSTRATE PREPARATION

Breakout and remove all concrete designated as being defective, loose and unsound, using suitable mechanical equipment.

Ensure sufficient concrete is removed from around reinforcement to allow priming and compaction of the repair material.

At the repair locations, feather edging should be avoided. The edges should be square cut to at least the recommended minimum application thickness of the repair material. Where a saw cut is employed, the substrate should be roughened mechanically to provide a 'key' between the repair mortar and substrate.

STEEL REINFORCEMENT

All exposed reinforcement should be thoroughly prepared to clean, bright metal, using abrasive blast cleaning or other approved means.

MIXING

Thoroughly mix component A (resin) and component B (hardener) individually, then mix together with slow speed drill (150 - 300 rpm). Gradually add component C (filler) and mix for a further 3 minutes until a uniform mix has been achieved. Allow to stand for 10 minutes to mature prior to application.

APPLICATION

Apply by brush to steel/concrete.

Steel reinforcement primer:

Within 4 hours of preparation of the steel, apply one coat of **SikaTop Armatec 110 EpoCem** to a minimum thickness of 1mm. After the first coat has reached initial set, apply a second coat of **SikaTop Armatec 110 EpoCem** onto the previously coated steel.

If the second coat of **SikaTop Armatec 110 EpoCem** is allowed to dry prior to repair mortar application, then a fresh coat must be applied.

Bonding bridge:

Before applying the **SikaTop Armatec 110 EpoCem** as a bonding bridge, all surfaces must be thoroughly prewetted to a saturated surface dry condition.

The **SikaTop Armatec 110 EpoCem** is then applied by brush to the concrete substrate.

IMPORTANT CONSIDERATIONS

- * If a barrier to chlorides is required, then 2 coats should be applied to the concrete substrate.
- * Care should be taken to ensure continuous application behind the reinforcement bars.
- * When used as a bonding bridge, the "grab" properties of the **SikaTop Armatec 110 EpoCem** will reduce if it dries out before the repair mortar application. Repeat application if necessary.
- * Do not part mix components.
- * Under no circumstances should water or solvent be added to the mix.
- * Always apply two coats to the steel reinforcement.
- * The bonding bridge application also forms the second coat for the reinforcement primer.

CLEANING EQUIPMENT

Use clean water. Hardened material may only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

Steel reinforcement primer: Approx 2.0 kg/m² per coat
Bonding bridge: Approx 2.0 - 4.0 kg/m²
Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 1 year in sealed containers stored in dry warehouse conditions (+10°C - +30°C).



Handling Precautions

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SikaTop® 77

Styrene Acrylate Polymer Admixture

Technical Data Sheet

DESCRIPTION

SikaTop 77 is a one component water based styrene acrylate polymer admixture. When diluted with water it produces a gauging solution for improving cementitious mixes.

USES

SikaTop 77 is added to water then mixed with cement and sand/aggregate to produce:

- * Bond coat/slurry.
- * Pourable micro concrete.
- * Renders.
- * Screeds with enhanced mechanical properties.

ADVANTAGES

- * Reduced shrinkage and cracking.
- * Reduced permeability.
- * Improved workability.
- * Improved mechanical properties.
- * Improved resistance to freeze/thaw.
- * Just add water.
- * Suitable for contact with potable water.
- * More durable than SBR and latex mixes.
- * Water based.
- * Solvent free.
- * Non toxic.
- * Chloride free.
- * Non flammable.
- * Compatible with all cement types.

Technical Data (typical)

Colour:	White
Specific gravity:	1.0 kg/litre
Application temperature:	In accordance with render/screed/concrete standards. 5°C (guide only) (Substrate and ambient)

MECHANICAL PROPERTIES

28 days @ 20°C RH 65%
1 : 3 cement : sand mortar mix

	Unmodified control	SikaTop 77 modified 1 : 1 solution	SikaTop 77 modified 1 : 3 solution
Compressive strengths:			
3 days	23 N/mm ²	30 N/mm ²	32 N/mm ²
7 days	30 N/mm ²	38 N/mm ²	40 N/mm ²
28 days	32 N/mm ²	50 N/mm ²	45 N/mm ²

Flexural strengths:

28 days	4.5 N/mm ²	9.0 N/mm ²	11.0 N/mm ²
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Bond strengths: (tensile)

28 days	1.0 N/mm ²	>2.0 N/mm ²	>1.5 N/mm ²
With bond coat: (failure mode)	bondline	bondline/substrate	bondline/substrate

Bond strength can be improved by using **SikaDur® 32** or **SikaTop® Armatec 110 EpoCem®** as a bond coat resulting in a failure mode within the substrate (depending on preparation).

Notes:

- * Final mechanical properties and strength gain will be dependent on temperature, aggregate/sand type, moisture content and curing regime.
- * More accurate information regarding workability, mechanical strengths and strength gains should be obtained from site trials and appropriate strength/bond tests.
- * Bond strength will be dependent on condition of substrate, preparation techniques and application.
- * Where increased open times and bond strength are required for bond coat/slurry use **SikaTop Armatec 110 EpoCem** or **SikaDur 32**.

Approved for potable water contact.
Details available on request.

All above values are approximate.

CONCRETE SUBSTRATE PREPARATION

Concrete substrates must be suitably prepared using mechanical or abrasive blast cleaning techniques such as scabbling, needle gunning, grit blasting and to provide a clean, sound surface free of laitance, surface contaminants such as oil and grease and loosely adhering particles.

MIXING

SikaTop 77 should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

Mix **SikaTop 77** with water to produce a gauging solution in the correct ratio for 90 seconds. Add gauging solution to cement/aggregate mix until desired consistency is achieved.

APPLICATION

The prepared substrate should be thoroughly soaked with clean water until uniformly saturated leaving no standing water. Always apply mix "wet on wet" onto bonding bridge/coat. Re-apply if surface dries.

Bond coat:

Work mix vigorously with a stiff brush onto pre-dampened substrate.

Screed, render, mortar:

Apply mix to wet bond coat. If bond coat dries, reapply.

IMPORTANT CONSIDERATIONS

CURING

Correct curing procedures should be carried out immediately after application to ensure full cement hydration and to minimise cracking. Use polythene sheeting or other approved methods in accordance with render/screed standards.

- * **SikaTop** must be diluted with water and mixed with cement for all applications
- * Do not add water over recommended dosage.
- * Apply only to prepared, sound substrates.
- * Due allowance must be made for the moisture content of the sand to ensure the correct quantity of **SikaTop 77** is used as given in the standard mixes. In some circumstances this will result in the addition of undiluted **SikaTop 77** to the mix.
- * When sand is mixed wet the quantity of water added **must** in all cases be reduced to compensate.
- * Protect freshly applied material from freezing.
- * Do not add additional admixtures without prior consultation with **Sika Limited**.

CLEANING

Remove **SikaTop 77** from tools and equipment with water.

PACKAGING

Refer to latest price list.

STORAGE AND SHELF LIFE

Minimum 1 year in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Standard Mix Design and Consumption Guide

Use	Mix Design Ref	Gauging Solution SikaTop 77:water litres	Dry Mix cement:sand:Agg kg	Thickness layer range mm	Approx 28 day strength N/mm ²	Approx Yield litres (m ³)	Notes
Bond coat for: floor screeds, rendering	1	1 : 1	1 : 1 : 0	-	-	-	- 
Normal duty floor screed	2	7 : Upto 12	50 : 125 : 0	12 - 25	Upto 50	90 (0.09)	Use bond coat. Add on extra 25 kg sand for thickness above 12.0 mm.
Heavy duty floor screed	3	6 : Upto 12	50 : 75 : 75 grave/agg 3-6 mm	15 - 25	Upto 55	100 (0.10)	Apply semi dry. Use bond coat.
Render	4	9 : Upto 9	50 : 125 : 0	12 - 20	55	90 (0.09)	Use bond coat
Pourable micro concrete	5	7 : 13 : 0.4*	50 : 75 : 120 gravel/agg 5-10 mm	75	50	110 (0.11)	Flow trials recommended
Sand to BS 882 1992 Grade M		Aggregates are calculated as dry		Cement type: Ordinary portland cement		* For micro concrete use Sikament N in gauging solution	

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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SikaCem® 810

Modified SBR Polymer Admixture

Technical Data Sheet

DESCRIPTION

SikaCem 810 is a patented one component water based blend of modified SBR emulsion, plasticisers and silica fume. When diluted it produces a gauging solution for improving cementitious mixes.

USES

SikaCem 810 is added to water then mixed with cement and sand/aggregate to produce:

- * Bond coat/slurry.
- * Pourable micro concrete.
- * Renders.
- * Screeds with enhanced mechanical properties.

ADVANTAGES

- * Reduced shrinkage and cracking.
- * Reduced permeability.
- * Improved workability.
- * Improved mechanical properties.
- * Improved resistance to freeze/thaw.
- * Just add water.
- * Suitable for contact with potable water.
- * More durable than SBR and latex mixes.
- * Water based.
- * Solvent free.
- * Non toxic.
- * Chloride free.
- * Non flammable.
- * Compatible with all cement types.
- * Good mechanical properties.
- * Better workability than unmodified SBR and acrylic emulsions.
- * Easier to finish.

Technical Data (typical)

Mixed colour:	Light grey
Specific gravity:	1.1 kg/litre
Application temperature:	In accordance with render/screed/concrete standards. 5°C (guide only) (Substrate and ambient)

MECHANICAL PROPERTIES

28 days @ 20°C RH 65%
1 : 3 cement : sand mortar mix

	Unmodified control	SikaCem 810 modified 1 : 2 solution
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Compressive strengths:

1 day	20 N/mm ²	33 N/mm ²
3 days	33 N/mm ²	45 N/mm ²
7 days	42 N/mm ²	56 N/mm ²
28 days	55 N/mm ²	63 N/mm ²

Bond strengths: (tensile)

28 days	1.0 N/mm ²	>2.0 N/mm ²
With bond coat: (failure mode)	bondline/substrate	bondline/substrate

Bond strength can be improved by using **SikaDur® 32** or **SikaTop® Armatec 110 EpoCem®** as a bond coat resulting in a failure mode within the substrate (depending on preparation).

Notes:

- * Final mechanical properties and strength gain will be dependent on temperature, aggregate/sand type, moisture content and curing regime.
- * More accurate information regarding workability, mechanical strengths and strength gains should be obtained from site trials and appropriate strength/bond tests.
- * Bond strength will be dependent on condition of substrate, preparation techniques and application.
- * Where increased open times and bond strength are required for bond coat/slurry use **SikaTop Armatec 110 EpoCem** or **SikaDur 32**.

Approved for potable water contact.
Details available on request.

All above values are approximate.

CONCRETE SUBSTRATE PREPARATION

Concrete substrates must be suitably prepared using mechanical or abrasive blast cleaning techniques such as scabbling, needle gunning, grit blasting and to provide a clean, sound surface free of laitance, surface contaminants such as oil and grease and loosely adhering particles.

MIXING

SikaCem 810 should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

Mix **SikaCem 810** with water to produce a gauging solution in the correct ratio for 90 seconds. Add gauging solution to cement/aggregate mix until desired consistency is achieved.

APPLICATION

The prepared substrate should be thoroughly soaked with clean water until uniformly saturated leaving no standing water. Always apply mix "wet on wet" to bonding bridge/coat. Re-apply if surface dries.

Bond coat:

Work mix vigorously with a stiff brush onto pre-dampened substrate.

Screed, render, mortar:

Apply mix to wet bond coat. If bond coat dries, reapply.

IMPORTANT CONSIDERATIONS

CURING

Correct curing procedures should be carried out immediately after application to ensure full cement hydration and to minimise cracking. Use polythene sheeting or other approved methods in accordance with render/screed standards.

- ★ **SikaCem 810** must be diluted with water and mixed with cement for all applications
- ★ Do not add water over recommended dosage.
- ★ Apply only to prepared, sound substrates.
- ★ Due allowance must be made for the moisture content of the sand to ensure the correct quantity of **SikaCem 810** is used as given in the standard mixes. In some circumstances this will result in the addition of undiluted **SikaCem 810** to the mix.
- ★ When sand is mixed wet the quantity of water added **must** in all cases be reduced to compensate.
- ★ Protect freshly applied material from freezing.
- ★ Do not add additional admixtures without prior consultation with **Sika Limited**.

CLEANING

Remove **SikaCem 810** from tools and equipment with water.

PACKAGING

Refer to latest price list.

STORAGE AND SHELF LIFE

Minimum 1 year in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Standard Mix Design and Consumption Guide

Use	Mix Design Ref	Gauging Solution SikaCem 810:water litres	Dry Mix cement:sand:Agg kg	Thickness layer range mm	Approx 28 day strength N/mm ²	Approx Yield litres (m ³)	Notes
Bond coat for: floor screeds, rendering	A	1 : 1	1 : 1 : 0	-	-	-	-
Normal duty floor screed	B	10 : Upto 10	50 : 150 : 0	12 - 25	60	100 (0.10)	Use bond coat.
Heavy duty floor screed	C	7.2 : Upto 14	50 : 75 : 75 gravel/agg 3-6	20 - 25	55	100 (0.10)	Apply semi dry. Use bond coat.
Render	D	7.2 : Upto 14	50 : 130 : 0	10 - 25	56	100 (0.10)	Use bond coat
Pourable micro concrete	E	7.2 : 12.5 : 0.5*	50 : 85 : 110 gravel/agg 5-10 mm	25 - 100	55	100 (0.10)	Flow trials recommended
Sand to BS 882 1992 Grade M		Aggregates are calculated as dry		Cement type: Ordinary portland cement		* For micro concrete use Sikament® N in gauging solution	

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Sika® Chapdur® Premix

Mineral Based Coloured "Dry Shake" Floor Hardening System

Technical Data Sheet

DESCRIPTION

Sika Chapdur Premix is a ready to use mixture of cement, pigments, additives and hard aggregate of mineral origin. The particles have been specially selected for their shape, grading, high physical quality and mechanical performance.

It improves abrasion and reduces dusting of concrete floors.

USES

- * Warehouses.
- * Workshops.
- * Garages.
- * Car parks.
- * Storage areas.
- * Distribution centres.
- * Factories.

ADVANTAGES

- * High resistance to abrasion.
- * Reduces surface dust.
- * Improves resistance to impact.
- * Improves resistance to oils and greases.
- * Intrinsic colouring.
- * Easy application.
- * Good finish.
- * Non hazardous.
- * Economic in use.

Technical Data (typical)

Colour:	Refer to current price list for availability and minimum order quantities.
Density (SG):	Approx 1.4 kg/litre
Material consumption:	Approx 3.0 - 6.0 kg/m ² per coat.
MECHANICAL PROPERTIES:	
Abrasion resistance: (Taber)	Concrete with cement content of 450 kg/m ³ wt loss 4.6 g
	Chapdur Premix treated concrete wt loss 2.4g
Mohs hardness:	7 - 8
Final drying times: (Depending on temperature and type of cement)	
Foot traffic:	1 - 2 days
Lightly serviceable:	7 - 10 days
Fully serviceable:	28 days

All above values are approximate.



APPLICATION

Substrate preparation: The concrete slab should be at least 15 cm thick. The concrete should contain an adequate proportion of cement. It is recommended to add a suitable Sika concrete admixture to improve its properties (eg **Sikament**[®]).

Level the freshly poured concrete by means of vibrating beam. As soon as the plasticity permits, smooth the concrete preferably by using a mechanical trowel.

Broadcasting: The concrete slab is ready for the **Sika Chapdur Premix** cement coating when a thumb pressed hard onto the surface only leaves a 'print' of about 3 - 5 mm depth. Broadcast the mix evenly by hand or with suitable device.

Compaction: Wait until the **Sika Chapdur Premix** has been evenly moistened by the water in the concrete. Use a low rpm mechanical trowel, held perfectly flat.

Note: If parts of the surface come loose or if the laitance rises, this means the concrete is still too fresh.

Smoothing: As soon as the plasticity or initial set allows, perform preliminary smoothing with the same machine running at low speed but equipped with metal smoothing blades, set a minimum angle.

Any final smoothing required should be performed later with the machine running at high speed.

Curing: The **Sika Chapdur Premix** surface must be protected to prevent early dry-out, crazing and bloom. Immediately after final smoothing, apply a coat of curing compound (**Antisol**[®] **S**) on the concrete (dosage: approx 0.15 - 0.20 kg/m²). Do not use any other type of curing compound.

Joints: Contraction joints, expansion joints and floor joints should be saw-cut only after 24 hours. When the slab has hardened, the joints can be filled with the appropriate **Sikaflex**[®] sealant in accordance with the floor requirements.

IMPORTANT CONSIDERATIONS

* Concrete substrate characteristics such as water content and cement quality may induce slight colour variations.

PACKAGING

Refer to latest price list

CONSUMPTION

Approximately 3.0 - 6.0 kg/m² (These figures do not allow for profile or wastage).

Maximum yield per pack - refer to latest price list.

STORAGE AND SHELF LIFE

Minimum 1 year in sealed containers stored in dry warehouse conditions (+5°C - +30°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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Please consult our Technical Sales Department for further information

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Sika® Rapid Repair Mortar

Fast Setting Cementitious Repair Mortar

Technical Data Sheet

DESCRIPTION

Sika Rapid Repair Mortar is a one component fast setting cementitious repair mortar.

USES

- * Fast repairs to horizontal or vertical concrete surfaces.
- * Floor slabs
- * Filling/repair mortar for voids, honeycombed areas etc.
- * Concrete pavements.
- * Bedding manhole covers.

ADVANTAGES

- * Only requires mixing with water
- * Rapid setting.
- * Fast and easy to apply.
- * Factory proportioned.
- * High early strength.
- * Excellent adhesion.
- * Increased resistance to de icing salts, chloride ions and carbonation.
- * Free of chloride compounds.
- * Non-corrosive to steel.
- * Can be overcoated.

Technical Data (typical)

Mixed colour:	Concrete grey
Mixed wet density:	2.1 kg/litre
Application temperature:	+5°C min, +25°C max (Substrate and ambient)
Application thickness per layer:	8.0 mm minimum 30.0 mm maximum
Mix ratio:	2.5 - 3.0 litres of water per 25 k bag
MECHANICAL PROPERTIES	
28 days @ 20°C	Air cured
Compressive strength:	2 hrs 24 hrs 7 days 10 N/mm ² 50 N/mm ² 60 N/mm ²
Bond strength: (tensile)	1.0 - 2.3 N/mm ² 
'Working time': (@20°C)	15 - 20 minutes

All above values are approximate.

CONCRETE SUBSTRATE PREPARATION

Breakout and remove all concrete designated as being defective, loose and unsound, using suitable mechanical equipment.

Ensure sufficient concrete is removed from around reinforcement to allow priming and compaction of the repair material.

At the repair locations, feather edging should be avoided. The edges should be square cut to at least the recommended minimum application thickness of the repair material. Where a saw cut is employed, the substrate should be roughened mechanically to provide a 'key' between the repair mortar and substrate.

STEEL REINFORCEMENT PRIMING

Prior to applying **Sika Rapid Repair Mortar** into the repair area, apply two coats of **SikaTop® Armatec 110 EpoCem®** or **Sika MonoTop® 610** onto the reinforcement in accordance with the product technical data sheet.

CONCRETE SUBSTRATE PRIMING

The prepared substrate should be thoroughly soaked with clean water until uniformly saturated leaving no standing water. To the pre-dampened surface, brush apply a bonding bridge of **SikaTop 121** or **SikaTop Armatec 110 EpoCem** prior to the application of the repair mortar. Always apply repair mortar "wet on wet" to bonding bridge. Re-apply bonding bridge if surface dries.

MIXING

Sika Rapid Repair Mortar should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

Mix **Sika Rapid Repair Mortar** with water for at least 3 minutes to achieve a uniform consistency. Immediately apply the repair mortar. When mixed, the product may be bulked out with dry, dust free aggregates (30% by wt of 3-6 mm granite chippings) and remixed to a uniform consistency.

APPLICATION

The mixed mortar must be worked well into the wet primed substrate by gloved hand or trowel, filling all voids ensuring full encapsulation around exposed reinforcement. Compact well. Apply in layers to the maximum application thickness and allow to reach initial set. If more than 12 hours between layers, apply a bonding bridge of **SikaTop 121** or **Armatec 110 EpoCem®**. The final layer is best finished with a wood/plastic float or a damp sponge after initial set has taken place, to provide a textured surface suitable for the subsequent application of reprofiling mortars and coatings.

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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IMPORTANT CONSIDERATIONS

CURING

It is essential to cure the repair mortar immediately after application for a minimum of 7 days to ensure full cement hydration and to minimise cracking. Use polythene sheeting taped down at the edges or other approved method.

★ Large/deep repairs may be subject to shrinkage and cracking. This may be minimised by limiting repair volumes and reducing layer thicknesses.

★ Do not add water over recommended dosage.

★ Apply only to prepared, sound substrates.

★ Allow repair mortar to harden between applications.

★ Protect freshly applied material from freezing.

CLEANING

Remove **Sika Rapid Repair Mortar** from tools and equipment with water. Hardened material can only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

2.1 kg/m²/mm (2.1 kg/litre)

Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 6 months in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).



Sika MonoTop® 610

Cementitious Based Steel Reinforcement Primer and Bonding Bridge

Technical Data Sheet

DESCRIPTION

Sika MonoTop 610 is a one component cementitious, polymer modified primer for reinforcement protection and also a bonding bridge for **MonoTop** concrete repair mortars.

USES

Sika MonoTop 610 may be used to bond **MonoTop** concrete repair mortars to existing cementitious or steel substrates and provide additional corrosion protection to reinforcement in **MonoTop** concrete repair mortars especially in areas of low concrete cover and in the presence of chlorides.

ADVANTAGES

- * Only requires mixing with water.
- * Easy, user friendly application.
- * Active corrosion inhibitors for added protection.
- * Excellent adhesion to concrete and steel.
- * Good resistance to water and chloride penetration.
- * Meets ZTV-SIB requirements for corrosion protection.
- * Good mechanical properties.
- * Sprayable by wet spray method.
- * Adjustable consistency.
- * Low wastage.
- * Disposable packaging.
- * Suitable for drinking water contact.

Technical Data (typical)

Mixed colour:	Light Grey
Mixed density:	2.0 kg/litre
Volume solids:	100%
Mix ratio	
Water:Powder	1:4.13 by volume
For brush application	1:4.75 by weight (5.25 litres of water per 25kg bag)
For spray application	1:5 parts by weight 1:4.35 by volume (5 litres of water per 25kg bag)
COATING SYSTEM:	
Steel reinforcement primer:	2 x 1.0 mm Sika MonoTop 610
Bonding bridge:	1 x 1.0 mm Sika MonoTop 610
Bond strengths:	Concrete 1.0 - 2.5 N/mm ² Steel 1.0 - 2.0 N/mm ²
Application temperatures:	+5°C minimum and rising +30°C maximum (Substrate and ambient)
Pot life:	Approx 90 - 120 minutes Subject to temperature
Waiting time between coats:	4 - 5 hours
Allow similar times before bonding bridge application.	
Approved for potable water contact. Details available on request.	
All above values are approximate.	

CONCRETE SUBSTRATE PREPARATION

Breakout and remove all concrete designated as being defective, loose and unsound, using suitable mechanical equipment.

Ensure sufficient concrete is removed from around reinforcement to allow priming and compaction of the repair material.

At the repair locations, feather edging should be avoided.

The edges should be square cut to at least the recommended minimum application thickness of the repair material. Where a saw cut is employed, the substrate should be roughened mechanically to provide a 'key' between the repair mortar and substrate.

STEEL REINFORCEMENT

All exposed reinforcement should be thoroughly prepared to clean, bright metal, using abrasive blast cleaning or other approved means.

MIXING

Pour water in the correct ratio into the mixing vessel. Add powder while mixing continuously. To avoid entraining too much air use low speed mixer (max 500 rpm) for minimum 3 minutes. By gradually adding the powder in portions, the desired application consistency can be obtained.

APPLICATION

Apply by brush to steel/concrete.

Steel reinforcement primer:

Within 4 hours of preparation of the steel, apply one coat of **Sika MonoTop 610** to a minimum thickness of 1mm. After the first coat has reached initial set, apply a second coat of **Sika MonoTop 610** onto the previously coated steel.

If the second coat of **Sika MonoTop 610** is allowed to dry prior to repair mortar application, then a fresh coat must be applied.

Bonding bridge:

Before applying the **Sika MonoTop 610** as a bonding bridge, all surfaces must be thoroughly prewetted to a saturated surface dry condition. The **Sika MonoTop 610** is then applied by brush to the concrete substrate.

IMPORTANT CONSIDERATIONS

- * Care should be taken to ensure continuous application behind the bar
- * Do no part mix components.
- * Always apply two coats to the steel reinforcement.
- * The bonding bridge application also forms the second coat for the reinforcement primer.
- * When used as a bonding bridge, the "grab" properties of the **Sika MonoTop 610** will reduce if it dries out before **Sika MonoTop** mortar application. Repeat application if necessary.

CLEANING EQUIPMENT

Use clean water. Hardened material may only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

1 litre of fresh mortar: approx 1.65kg dry powder.

Steel reinforcement primer: Approx 2.0 kg/m² per coat.

Bonding bridge: Approx 1.5 - 2.0 kg/m² dry

Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 1 year in sealed containers stored in dry warehouse conditions (+10°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Sika MonoTop[®] 615

Cementitious High Build Concrete Repair and Reprofiling Mortar

Technical Data Sheet

DESCRIPTION

Sika MonoTop 615 is a one component cement based polymer modified high build repair and reprofiling mortar.

USES

- * For repairing all types of structures.
- * Overhead and vertical repairs.
- * Hand applied repairs.
- * Spray applied repairs.
- * For exterior and interior use.

ADVANTAGES

- * Pre bagged for quality.
- * Just add water.
- * Compatible with **Sika[®] FerroGard[®]** corrosion inhibitors.
- * Easy to mix and apply.
- * Sprayable by the wet spray method.
- * Excellent bond to concrete.
- * Contains no chloride admixtures.
- * High build.
- * Overcoatable with **SikaGard[®]** coatings.
- * Low shrinkage.
- * Generally more durable than equivalent class of concrete.
- * Coefficient of thermal expansion similar to concrete.
- * Fire rating and protection properties comparable to concrete.
- * Good mechanical properties.
- * Low wastage.

Technical Data (typical)

Mixed colour:	Grey
Mixed wet density:	1.65 kg/litre
Application temperature:	+5°C min, +30°C max (Substrate and ambient)
Application thickness per layer:	3.0 mm minimum 30.0 mm maximum
Mix ratio:	
Hand application:	2.5 - 2.7 litres water per 25 kg bag
Wet spray application:	2.5 - 3.5 litres water per 25 kg bag

MECHANICAL PROPERTIES

28 days @ 20°C

Compressive strength:	30 - 35 N/mm ²
Flexural strength:	5 - 7 N/mm ²
Bond strength (tensile):	1.5 - 2.5 N/mm ² (Substrate failure)
E-Modulus (static):	13.0 kN/mm ²
'Working time': (@23°C)	30 - 50 minutes



All above values are approximate.

CONCRETE SUBSTRATE PREPARATION

Breakout and remove all concrete designated as being defective, loose and unsound, using suitable mechanical equipment.

Ensure sufficient concrete is removed from around reinforcement to allow priming and compaction of the repair material.

At the repair locations, feather edging should be avoided. The edges should be square cut to at least the recommended minimum application thickness of the repair material. Where a saw cut is employed, the substrate should be roughened mechanically to provide a 'key' between the repair mortar and substrate.

STEEL REINFORCEMENT PRIMING

Prior to applying **Sika MonoTop 615** into the repair area, apply two coats of **Sika MonoTop 610** in accordance with the product technical data sheet.

CONCRETE SUBSTRATE PRIMING

The prepared substrate should be thoroughly soaked with clean water until uniformly saturated leaving no standing water. To the pre-dampened surface, brush apply a bonding bridge of **Sika MonoTop 610** prior to the application of the repair mortar. Always apply repair mortar "wet on wet" to bonding bridge. Re-apply bonding bridge if surface dries.

MIXING

Sika MonoTop 615 repair mortar should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

Pour water in the correct proportion into the mixing vessel. Add powder while mixing continuously. To avoid entraining too much air use low speed mixer (max 500 rpm) for minimum 3 minutes. By gradually adding the powder in portions, the desired application consistency can be obtained.

APPLICATION

The mixed mortar must be worked well into the wet primed substrate by gloved hand or trowel, filling all voids ensuring full encapsulation around exposed reinforcement. Compact well. Apply in layers to the maximum application thickness and allow to reach initial set. If more than 24 hours between layers, apply a bonding bridge of **Sika MonoTop 610** or **Armatec 110 EpoCem**[®]. The final layer is best finished with a wood/plastic float or a damp sponge after initial set has taken place, to provide a textured surface suitable for the subsequent application of reprofiling mortars and coatings.

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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IMPORTANT CONSIDERATIONS

CURING

It is essential to cure the repair mortar immediately after application for a minimum of 3 days to ensure full cement hydration and to minimise cracking. Use polythene sheeting taped down at the edges or other approved method.

- * Large/deep repairs may be subject to shrinkage and cracking. This may be minimised by limiting repair volumes and reducing layer thicknesses.
- * **Sika MonoTop 610** should be used as a bonding bridge for hand and spray applied applications.
- * Do not add water over recommended dosage.
- * Once **Sika MonoTop 615** has started to set it should be discarded. Do not add more water to improve workability.
- * Apply only to prepared, sound substrates.
- * Allow repair mortar to harden between applications.
- * Protect freshly applied material from freezing.

CLEANING

Remove **Sika MonoTop 615** from tools and equipment with water. Hardened material can only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

1.65 kg/m²/mm (1.65 kg/litre)

Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 6 months in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).



Sika MonoTop[®] 620

Cementitious Pore Sealer and Levelling Mortar

Technical Data Sheet

DESCRIPTION

Sika MonoTop 620 is a one component cementitious polymer modified mortar.

USES

- * As a concrete pore sealer/levelling mortar
- * Repairing minor defects.
- * Thin layer render.
- * Repairing pores and honeycombed concrete.
- * For exterior and interior use.

ADVANTAGES

- * Pre bagged for quality.
- * Just add water.
- * Compatible with **Sika[®] FerroGard[®]** corrosion inhibitors.
- * Easy to mix and apply.
- * Excellent bond to concrete.
- * Contains no chloride admixtures.
- * Compatible with **SikaTop[®]** and **MonoTop** mortars.
- * Overcoatable with **SikaGard[®]** coatings.
- * Low shrinkage.
- * Sprayable by wet spray method.
- * Adjustable consistency.

Technical Data (typical)

Mixed colour:	Grey
Mixed wet density:	2.0 kg/litre
Application temperature:	+5°C min, +30°C max (Substrate and ambient)
Application thickness per layer:	1.5 mm minimum 5.0 mm maximum
Mix ratio:	
Hand application:	4.0 - 4.5 litres water per 25 kg bag
Wet spray application:	2.5 - 3.5 litres water per 25 kg bag

MECHANICAL PROPERTIES

28 days @ 20°C

Compressive strength:	30 - 35 N/mm ²
Flexural strength:	4 - 6 N/mm ²
Bond strength (tensile)	1.5 - 2.5 N/mm ² (Substrate failure)
E-Modulus (static):	15.4 kN/mm ²
'Working time' (@23°C)	35 - 45 minutes



All above values are approximate.

SURFACE PREPARATION

Prepare and clean all concrete surfaces by suitable mechanical means such as abrasive blast cleaning or equivalent to ensure cement laitance, surface contamination and all existing coatings are removed and all blowholes and honeycombed areas are exposed.

MIXING

Sika MonoTop 620 repair mortar should be mechanically mixed using a forced action mixer or in a clean drum using a drill and paddle. A normal concrete mixer is NOT suitable.

Pour water in the correct proportion into the mixing vessel. Add powder while mixing continuously. To avoid entraining too much air, mix using a low speed mixer (max 500 rpm) for minimum 3 minutes. By gradually adding the powder in portions, the desired application consistency can be obtained.

APPLICATION

The surface should be pre-wetted to a saturated surface dry condition before application.

Apply by trowel and rub down with wooden/plastic float or damp sponge.

IMPORTANT CONSIDERATIONS

CURING

It is essential to cure the levelling mortar immediately after application for a minimum of 3 days to ensure full cement hydration and to minimise cracking. Use polythene sheeting or other approved method.

- * Do not add water over recommended dosage.
- * Apply only to prepared, sound substrates.
- * Do not add additional water during the surface finishing process as this will cause discolouration and cracking.
- * Protect freshly applied material from freezing.

CLEANING

Remove **Sika MonoTop 620** from tools and equipment with water. Hardened material can only be removed mechanically.

PACKAGING

Refer to latest price list.

CONSUMPTION

2.0 kg/m²/mm (2.0 kg/litre)
Excluding allowances for loss wastage, surface profile and porosity.

STORAGE AND SHELF LIFE

Minimum 6 months in unopened original sealed containers stored in dry warehouse conditions (+5°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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Sikaflex®-Pro 3WF

One Part Chemical resistant Polyurethane Sealant

Technical Data Sheet

DESCRIPTION

Sikaflex-Pro 3WF is a permanently elastic, one part gun grade polyurethane construction sealant, based on new Sika polyurethane technology. The unique two stage cross linking process eliminates many of the problems associated with conventional single stage cross-linking sealants. When combined with the water resistant primer, **Sikaflex-Pro 3WF** can be applied to moist substrates.

USES

- * Industrial floors
- * Containment bunds
- * Sewage treatment plants
- * Car parks
- * Balconies
- * Retaining walls
- * Footbridges
- * Sewer pipes

ADVANTAGES

- * Excellent bond to most construction materials
- * Good chemical resistance
- * One component - ready for use
- * No mixing or heating
- * Excellent adhesion on moist substrates with unique priming system
- * Reduced primer waiting time
- * Extremely durable
- * Bubble free curing system
- * Permanently elastic over a wide range of temperatures
- * Good sag resistance
- * Good water resistance
- * Good mechanical properties.

Technical Data (typical)

Colour:	Black, white, beige, grey, brown
Density:	1.3 kg/litre
Movement Accommodation Factor (MAF):	20%
BS ISO 1160 Classification:	F-20 HM
Service temperature range:	-40°C min, +80°C max
Cure rate:	2 mm/day (+20°C / 65% RH)
Application temperature:	+5°C min, +40°C max (Substrate and ambient)
Shore A hardness:	35 after 28 days (+23°C / 50% RH)
Tack free time:	1 - 2 hours (+23°C / 50% RH)
Elastic recovery:	Approx 80% 
Tensile strength at break:	> 1.4 N/mm ²
Maximum joint width:	40.0 mm
Minimum joint depth for expansion joints:	10.0 mm
Chemical resistance:	Refer to chart Good chemical resistance to a wide range of chemicals. Swelling possible. Refer to chemical resistance chart. Contact Sika Ltd for information.

All above values are approximate.

SURFACE PREPARATION

All surfaces must be sound, clean, dry and free from any surface contaminants.

All loose particles, paint, laitance, rust and other poorly adhering materials should be removed with a rotary mechanical wire brush, grinding or grit blasting followed by blowing out with oil free compressed air. Use epoxy mortars for making good spalled or damaged joints.

Iron and steel must be protected by an anti-corrosion primer such as **Icosit® EG1** prior to sealing.

PRIMING

For the selection of the suitable primer, please consult the Primer Chart. When using **Sika® Primer 3** on moist substrate, maximum substrate moisture content must not exceed 8%.

APPLICATION

Insert **Sika Joint Backing Rod** to required depth.

- * Apply appropriate primer to joint sides and observe waiting time.
- * Firmly extrude **Sikaflex-Pro 3WF** into the joint making sure that it is in full contact with the sides of the joint.
- * Fill the joint, avoiding air entrapment.
- * **Sikaflex-Pro 3WF** should be tooled to a smooth finish.

Masking tape should be used where sharp exact joint lines or exceptionally neat lines are required. Remove the tape whilst the sealant is still soft.

IMPORTANT CONSIDERATIONS

- * **Sikaflex-Pro 3WF** should not be used for structural glazing.
- * Protect the finished joint from water for at least 3 hours.
- * **Sikaflex-Pro 3WF** should be used with care in resealing joints that were previously filled with silicone sealants. All silicone residue must be removed.
- * **Sikaflex-Pro 3WF** should not be applied to coated substrates.
- * Avoid contact with hot bitumen.
- * Slight colour variations may occur from exposure to chemicals and UV radiation.
- * Do not use detergents or soap during tooling operation as chemical resistance may be affected.
- * Chemical exposure and joint movements more than 10% is not permitted during curing.
- * In case of chemical exposure the resistance of the sealant is limited. Joints exposed to chemicals are service joints and may have to be refurbished after exposure.
- * Not recommended for swimming pool chemical exposure.

CLEANING

Clean tools immediately with **Sika Thinner C**.

PACKAGING

Refer to latest price list.

JOINT DESIGN

Refer to BASA/CIRIA Guidelines. (CIRIA Publications 80).

CONSUMPTION

Theoretical consumption of **Sikaflex-Pro 3WF** per 600cc sausage (without wastage):

$$\text{Length of joint per 600cc (m)} = \frac{600}{\text{Joint width (mm)} \times \text{joint depth (mm)}}$$

$$\text{Litres per metre run of joint} = \frac{\text{Joint width (mm)} \times \text{joint depth (mm)}}{1000}$$

STORAGE AND SHELF LIFE

1 year from date of production if stored in cool, dry conditions (+10°C - +25°C).

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Please consult our Technical Sales Department for further information

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