



**PRODUCT DATA SHEET**

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SPECIALTY FLOORING

# Sikafloor®-330

SELF-LEVELLING, ELASTOMERIC, SOLVENT-FREE AND LOW-VOC, POLYURETHANE BASE COAT  
WITHIN Sika ComfortFloor® SYSTEMS

<b>Description</b>	Sikafloor®-330 is a two-component, solvent-free and low VOC, elastomeric, self-smoothing polyurethane resin. It is used as the self-levelling base coat for Sika ComfortFloor® and Sika ComfortFloor® Pro systems.								
<b>Where to Use</b>	Suitable for interior use in public and commercial buildings including: <ul style="list-style-type: none"> <li>Healthcare facilities; hospitals, nursing stations, clinics, residential homes.</li> <li>Educational premises; pre-schools, schools, colleges, universities.</li> <li>Retail spaces; stores, superstores, showrooms.</li> <li>Research areas; laboratories, corridors.</li> <li>Leisure premises; museums, art galleries, theatres.</li> <li>Business facilities; lobbies, passage-ways, offices.</li> </ul>								
<b>Advantages</b>	<ul style="list-style-type: none"> <li>Low VOC content.</li> <li>Solvent-free.</li> <li>Non shrinking after cure.</li> <li>High strength.</li> <li>Elastic and resilient.</li> <li>Reduces footfall noise.</li> <li>Fire classification acc. to EN 13501-1 Report No. 08-199, Universiteit Gent.</li> <li>Sound reduction capacity of 2 dB when used in Sika ComfortFloor® system and 19 dB when used in Sika ComfortFloor® Pro system.</li> </ul>								
<b>Technical Data</b>	<p><b>Packaging</b> 13.7 L (3.61 US gal.) ready to mix kits Part R: 10.2 L (2.69 US gal.), Part H: 3.5 L (0.92 US gal.) containers</p> <p><b>Colour</b> Clear. Colours available through use of Sikafloor® Epoxy Color Additive. (See Colour Card). <b>Note:</b> Never use Sikafloor® Urethane Color additives.</p> <p><b>Yield</b> Approx. 0.5 m<sup>2</sup>/L (20 ft<sup>2</sup>/US gal.) at 80 mils w.f.t.</p> <p><b>Shelf Life</b> 6 months in original, unopened containers when stored in dry and cool conditions (10 - 30 °C [50 - 86 °F]). Avoid prolonged storage at temperatures below 5 °C (41 °F) or above 30 °C (86 °F).</p> <p><b>Pot Life</b></p> <table border="1"> <thead> <tr> <th>Time</th> <th>Temperature</th> </tr> </thead> <tbody> <tr> <td>~ 21 min</td> <td>10 °C (50° F)</td> </tr> <tr> <td>~ 15 min</td> <td>20 °C (68° F)</td> </tr> <tr> <td>~ 12 min</td> <td>30 °C (86° F)</td> </tr> </tbody> </table> <p><b>Properties (Resin) at 23 °C (73 °F) and 50 % R.H.</b></p> <p><b>Density</b> Mixed Resin: 1.43 kg/L (11.9 lb/US gal.)</p> <p><b>Tensile Strength DIN 53504</b> 14 days ~ 8 MPa (1142 psi)</p> <p><b>Bond Strength ASTM D4541</b> 2.7 MPa (400 psi) (concrete failure)</p> <p><b>Shore A Hardness DIN 53505</b> 14 days ~ 80</p> <p><b>Elongation at Break DIN 53504</b> 14 days ~ 180 %</p> <p><b>Tear Growth Strength ISO 34-1</b> 14 days ~ 25 N/mm (142.75 lb/in)</p> <p><b>VOC Content</b> 10 g/L</p> <p><b>Chemical Resistance</b> Consult Sika Canada</p> <p><small>Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.</small></p>	Time	Temperature	~ 21 min	10 °C (50° F)	~ 15 min	20 °C (68° F)	~ 12 min	30 °C (86° F)
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**HOW TO USE**

**Surface**

All surfaces must be clean, sound and dry before proceeding with the installation of the Sikafloor®-330.

**Preparation**

Where applying onto concrete or similar substrates, remove all dirt and dust, laitance, grease, oil, asphalt, tar, bituminous materials, grease, curing agents, impregnations, wax, foreign matter, impregnations, coatings or sealers and detritus from the surface by appropriate mechanical means, such as abrasive blast cleaning in order to achieve a contaminant-free profile equivalent to ICRI / CSP 3. Whenever abrasive blast cleaning is used, be careful to leave concrete with a uniform texture. Over blasting will result in increased consumption/reduced coverage rates of the primer and/or subsequent topcoats.

All projections must be ground off and the surface suitable level before proceeding. Rough surfaces need to be levelled prior to application of a self levelling/smoothing topping. Contact Sika Canada for project specific recommendations.

Following surface preparation, remove all preparation residue, including dirt and loose friable material, preferably by industrial wet/dry vacuum (sweeping can result in making dust airborne to settle on the floor surface at a later juncture). This will help to ensure a tenacious bond between the primer and substrate

The compressive strength of the concrete substrate should be at least 24 MPa (3500 psi) at 28 days and at least 1.7 MPa (250 psi) in tension following preparation of the substrate at the time of application of Sikafloor®-156<sup>CA</sup>, Sikafloor®-1610 or Sikafloor®-165 FS epoxy primer and Sikafloor®-330 self-levelling base coat. Where applying onto Sikafloor® Comfort Regupol mats, Sikafloor®-330 should be applied following sealing of the mat with Sikafloor® Comfort Porefiller.

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#### Mixing

Pre-stir each component at low speed (300 - 400 rpm) using a drill fitted with a *Jiffy* type paddle until uniform in colour and consistency are achieved. Prolonged vibration and higher ambient temperatures during transportation can result in settling of the resin component. Additionally, agitating of the resin component is required at or below 32 °C (90 °F). In the case of Part R, this requires mechanical mixing for a period of at least two (2) minutes to ensure that all solids are dispersed and evenly distributed. Add colour paste mix again for two (2) minutes or until the pigment is consistent throughout the resin.

Empty Part H into Part R and thoroughly mix for two (2) minutes at low-speed (300 - 400 rpm) using a drill fitted with a *Jiffy* or *Exomixer*® type paddle.

**Note:** Mix entire units only. While mixing, keep the mixing paddle within the resin and below the surface in order to minimize air entrapment. During the mixing operation, scrape down the sides and bottom of the pail with a flat or straight edge trowel at least once to ensure thorough mixing.

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.

Upon completion of mixing, Sikafloor®-330 should be uniform in colour and consistency.

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#### Priming

**Concrete substrates:** Must be primed with either Sikafloor®-156<sup>CA</sup>, Sikafloor®-1610 or Sikafloor®-165 FS. Allow the primer to cure until tack-free before applying subsequent coats. Ensure that the primer is pore- and pinhole-free and provides uniform and complete coverage over the entire substrate.

**Sikafloor® Comfort Regupol mats:** Sikafloor®-330 should be applied following sealing of the mat with Sikafloor® Comfort Porefiller. Ensure that the porefiller is pore- and pinhole-free and provides uniform and complete coverage over the entire substrate.

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#### Application

Apply Sikafloor®-330 as a 'continuous flooring application'; it being imperative that all surfaces are prepared, primed or sealed, all materials are suitably cured for over-coating and the wearing surface resin itself is properly mixed and equipment is present and in working order. This will then ensure that there is no lapse or delays in the 'mix to mix' installation. To gain the maximum flow properties, the full contents of the mixed resin should be poured out onto the substrate as quickly as possible and within the pot-life. Sikafloor®-330 is then evenly spread by means of a notched trowel, CAM gauge rake, pin-rake or a serrated squeegee at a coverage of 0.5 m<sup>2</sup>/L (20 ft<sup>2</sup>/US gal.) approx. Roll immediately with a spiked roller to ensure an even thickness of 80 mils (2 mm) and remove any entrapped air. Sikafloor®-330 must always be sealed with Sikafloor®-305 W NA.

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#### Clean Up

Clean all tools and application equipment with Sika® Urethane Thinner and Cleaner immediately after use. Once hardened, product can only be removed mechanically. Wash soiled hands and skin thoroughly in hot soapy water or use Sika® Hand Cleaner towels.

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#### Limitations

- Sikafloor®-330 is best installed by skilled and experienced applicators. Consult Sika Canada for advice and recommendations.
- Prior to application, measure and confirm the following: substrate moisture content, ambient relative humidity, ambient and surface temperature and dew point. During installation, confirm and record above values at least once every three (3) hours, or more frequently whenever conditions change (e.g. ambient temperature rise/fall, relative humidity increase/decrease, etc.).
- Beware of condensation! Substrate temperature must be 3 °C (5.5 °F) above the measured dew point in order to reduce the risk of condensation or 'blooming' on the floor finish.
- 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 ICRI / CSP 3). Do not apply to concrete substrate with moisture levels exceed 4 % by mass, as measured with Tramex® CME/CMExpert type concrete moisture meter. If moisture content of concrete substrate exceeds 4 % by mass, as measured with Tramex® CME/CMExpert type concrete moisture meter, use Sikafloor®-1610 or Sikafloor®-81 EpoCem®<sup>CA</sup>.
- When relative humidity tests for concrete substrate are conducted per ASTM F2170 for project specific requirements, values must be ≤ 85 %. If values exceed 85 % according to ASTM F2170, use Sikafloor®-1610 or Sikafloor®-81 EpoCem®<sup>CA</sup>
- ASTM F2170 testing is not a substitute for measuring substrate moisture content with a Tramex® CME/CMExpert type concrete moisture meter as described above.

- Do not apply while ambient and substrate temperatures are rising. Ensure there is no vapour drive at the time of application. Refer to ASTM D4263, may be used for a visual indication of vapour drive.
- 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).
- Use of unvented heaters and certain heat sources may result in defects (e.g. blushing, whitening, debonding, etc.).
- Maximum ambient relative humidity during application and cure: 80 %.
- Protect from damp, condensation and water for at least 24 hours
- Do not apply Sikafloor® products 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
- Minimum / Maximum ambient and substrate temperature: 10 / 30 °C (50 / 85 °F).
- Material temperature: Precondition material for at least 24 hours between 18 to 24°C (65 to 75°F).
- Mixing and application attempted at material, ambient and/or substrate temperature conditions less than 18 °C (65 °F) will result in a decrease in product workability and slower cure rates.
- Do not hand mix Sikafloor® materials. Mechanically mix only.
- Mechanical, chemical & physical properties will be fully achieved at full cure.
- This product is not designed for negative side waterproofing.
- Typically not recommended for exterior slabs on grade where freeze/thaw conditions may exist.
- Do not apply onto substrates with a slope > 1 %.
- The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.
- A seamless finish can be achieved if a “wet” edge is maintained during application.
- For exact colour matching, ensure the resin in each area is applied from the same batch number.
- Under certain conditions, radiant heating or high ambient temperatures combined with high point loading, may lead to imprints in the resin.
- Must be sealed with Sikafloor®-305 W NA or another suitable Sikafloor® top coat, especially when requiring chemical resistance. Please contact Sika Canada for advice.

**Health and Safety Information**

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.

KEEP OUT OF REACH OF CHILDREN  
FOR INDUSTRIAL USE ONLY

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, within their shelflife. 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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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