



PRODUCT DATA SHEET

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FLUID-APPLIED FLOORING

Sikafloor® Duochem-6030

CLEAR, WATER-BASED AND HIGH-GLOSS EPOXY COATING

Description	Sikafloor® Duochem-6030 is a two-component, clear, water-based, epoxy coating that hardens to a tough, glossy and highly abrasion resistant finish.
Where to Use	<ul style="list-style-type: none"> As a final finishing coat or as a refresher coat for Sikafloor® Quartzite®, Sikafloor® Morritex®, Sikafloor® DecoFlake® and Sikafloor® Terrazzo Systems.
Advantages	<ul style="list-style-type: none"> Odour-free / low VOC. Seamless and very easy to clean and maintain. Good abrasion and chemical resistance. Good U.V. resistance properties. Meets the requirements of CFIA and USDA for Use in food plants. Potential LEED® Canada credit: Low Emission Material – Paints and Coatings

Technical Data	
Packaging	18.9 L (5 US gal.) units
Colour and Appearance	Clear, High-gloss
Yield	22 - 29 m ² /L (900 - 1200 ft ² /US gal.) at 1.4 - 2 mils w.f.t. / 0.6 - 0.8 mils d.f.t. per coat. Two (2) coats are recommended. Actual coverage rates and material consumption will depend upon porosity and profile of substrates. Allowance must be also made for variation in film thickness or number of coats required to achieve complete coverage of surfaces. Test sections are recommended to establish correct coverage.
Shelf Life	1 year in original unopened container. Store and transport dry at 5 - 32 °C (41 - 89 °F). Protect from freezing. If frozen, discard product. Condition product at temperatures between 18 and 30 °C (65 and 86 °F) before using.
Mix Ratio	A:B= 4:1 by volume
Properties at 23 °C (73 °F) and 50 % R.H.	
Solids Content	
By volume	~ 43 %
By weight	~ 40 %
Pot Life, 250 g (8.8 oz)	~ 6 h
Drying Times	
Touch dry	~ 4 to 5 h
Recoat time	~ 6 to 18 h
Hard dry	~ 16 to 18 h
Complete cure	~ 7 days
<i>Drying times will vary according to air and substrate temperature and humidity.</i>	
Water Vapour Transmission and Permeance ASTM E96	
Procedure B – water	~ 1.6 grams/h/m ²
4 mils d.f.t.	~ 5.3 perms
Abrasion Resistance ASTM D4060	
Taber Abraser, CS-17 Wheel/ 1000 g (2.2 lb)/1000 cycles	~ 79 mg loss
Resistance to Accelerated Weathering ASTM G53, 3 weeks	
(UVB condensation)	No yellowing at 4 hours Slight yellowing up to 1 - 4 days Yellowing and chalking thereafter
Tensile Strength ASTM D2370	
4 mils d.f.t.	~ 20 MPa (2900 psi)
Elongation ASTM D2370	
4 mils d.f.t.	~ 14.7 %
Pull off Strength ASTM D7234	
On concrete	> 3.3 MPa (> 480 psi) (substrate failure)
Static Coefficient of Friction ASTM C1028	
Dry surface	~ 0.66
Wet surface	~ 0.70
VOC	< 50 g/L
Chemical Resistance	Consult Sika Canada
<i>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.</i>	

HOW TO USE

Surface Preparation

New Sikafloor® or Sikagard® Surfaces: Sikafloor® Duochem-6030 must be applied within the critical recoat window following the last application of the Sika® resin. If the recoat window is exceeded, the existing Sika® resin surface must be sanded (abraded) to remove any sheen or gloss. The prepared surface must then be wiped clean with a solvent-moistened rag to remove all traces of dust, dirt or preparation residue prior to application of the Sikafloor® Duochem 6030 top coat.

Previously Coated Surfaces: Existing coated surfaces must be intact and tightly bonded to the substrate. Completely remove all traces of waxes or sealers, dust, dirt, oil, grease or other contaminants that may inhibit bonding. Hard or glossy surfaces must be abraded and wiped clean with a solvent to improve performance.

Note: Sika strongly recommends that a trial application be carried out to determine compatibility and acceptable performance of Sikafloor® Duochem-6030 with the existing surface, prior to general top-coating works being undertaken. Contact Sika Canada for recommendations.

Mixing

Pre-mix each component of Sikafloor® Duochem-6030 separately. Empty component B in the correct mix ratio into the component A container. Mix the combined components for at least three (3) minutes, using a low-speed drill (300 - 450 rpm) to minimize entrapping air. Use an *Exomixer*® type mixing paddle (recommended model) suited to the volume of the mixing container. During the mixing operation, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once, to ensure complete mixing. When completely mixed, Sikafloor® Duochem-6030 should be uniform in colour and consistency. Mix only that quantity which can be used within its pot life.

Application

Apply Sikafloor® Duochem-6030 at a rate of 22 to 29 m²/L (900 to 1200 ft²/US gal.) 1.4 - 2 mils w.f.t. / 0.6 - 0.8 mils d.f.t. per coat depending on surface profile, using a non-marking squeegee or flexible steel trowel, followed by backrolling to provide a uniform texture and appearance. Apply the second top coat to achieve specific texture or desired final appearance.

Note: Sika Canada strongly recommends that a test area be applied to confirm specific top coat selection and application rates required to produce the desired final appearance.

Clean Up

Clean all tools and equipment immediately with warm water. Once cured, product can only be removed mechanically. Wash hands and skin thoroughly with hot soapy water or use Sika® Hand Cleaner towels.

Limitations

- Sikafloor® Duochem-6030 is best installed by skilled and experienced applicators. Consult Sika Canada for advice and recommendations.
- Prior to application, measure and confirm 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.).
- Ambient / substrate temperature (Min. / Max.): 15 / 30 °C (59 / 86 °F).
- Maximum Relative Humidity during application and cure: 75 %.
- Sikafloor Duochem-6030 should not be applied when the Relative Humidity is greater than 75 % as curing times will be longer and water will be retained in the film reducing ultimate coating performance.
- **Beware of condensation!** The substrate temperature must be at least 3 °C (5.5 °F) above the measured dew point. Be aware the substrate temperature may be lower than the ambient temperature.
- Water-borne products require moisture to evaporate from the film to cure to full properties. Provide adequate fresh air ventilation to remove the excess moisture from the curing product.
- The consistent application of the product to the recommended wet film thicknesses is necessary to achieve a uniform appearance: Do not apply at thicknesses below or above those recommended as this will result in a variation in gloss level. Do not puddle or apply at excessive thicknesses as this will extend drying times and may cause the product to cure to a cloudy white finish.
- Beware of air flow and changes in air flow. Introduction of dust, debris, and particles, etc. may result in surface imperfections and other defects.
- Protect from dampness, condensation and water contact during the initial 24 hour cure period.
- At low temperatures and/or under high humidity conditions, curing time will be extended.
- Application of a single coat of Sikafloor® Duochem-6030 will result in a premature loss of gloss of the coating. Always follow two (2) coat application process.
- Maximum waiting time between coats: 18 hours.
- Protect components A and B from freezing. If frozen, discard.
- Do not hand mix Sikafloor® materials; always mix mechanically.
- Unlike most other systems, Sikafloor® Duochem-6030 does not become hard after pot life has expired, it remains liquid during a prolonged period. However, if pot life is exceeded, application will result in a lower gloss, loss of chemical resistance and physical properties of coating. **DO NOT APPLY AFTER SIX (6) HOURS EVEN IF STILL LIQUID.**
- For interior use only; not suitable for exterior applications.
- Published Static Coefficient of Friction (SCOF) wet and dry test results are approximate values based on laboratory test samples produced in a controlled environment following the application instructions published on the product data sheet. Resin flooring products are hand applied finishes subject to minor variations in surface texture due to influences partly beyond Sika Canada's control. Substrate profile, environmental conditions, variable regional aggregate size, shape and gradation, aggregate distribution, uniformity of applied resin mil thickness, and application technique can all affect the final SCOF test results achieved. Adequate provision should be made by the client throughout the selection and installation process to ensure the finished surface texture meets the end user's traction requirements.

**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

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