

PRODUCT DATA SHEET

Sikafloor®-327

2-part tough elastic polyurethane for indoor use in Decorative and Industrial flooring.

PRODUCT DESCRIPTION

Sikafloor®-327 is a two-part, solvent free, very low VOC emission, tough-elastic, coloured, self-smoothing PUR resin.

USES

Sikafloor®-327 may only be used by experienced professionals.

- Tough-elastic smooth wearing course for the Sika Comfortfloor® Tough system.
- Sikafloor® Smooth Tough Elastic PU for Industrial flooring.
- Sikafloor® Broadcast Tough Elastic PU for Industrial flooring for improved friction.
- Particularly suitable for hospitals, schools, sales premises, showrooms, entrance halls, lobbies, open-plan offices, museums and light to medium heavy industrial use.
- For interior use only.

CHARACTERISTICS / ADVANTAGES

- Very low VOC emission
- Solvent free
- Good mechanical resistance

- Easy to apply
- Easy to maintain
- Flexible and tough-elastic
- Economical
- Solvent-free
- Possible slip resistant surface

ENVIRONMENTAL INFORMATION

LEED Rating

Sika can help to earn credit points under certain circumstances for USGBC LEED Rating, conform the IEQ Credit 4.2 Low-Emitting Materials Paints and Coatings.

APPROVALS / STANDARDS

- Synthetic resin screed material according to EN 13813:2002, Declaration of Performance 02 08 01 04 040 0 000010 1041, certified by notified factory production control certification body 0620, and provided with the CE marking.
- Coating for surface protection of concrete according to EN 1504-2:2004, Declaration of Performance 02 08 01 04 040 0 000010 1041, certified by notified factory production control certification body 0620, and provided with the CE marking.
- Reaction to Fire classification according to EN 13501-1. Test institute Ghent University, Belgium. Report No. CR-13-167/1 for the Sika Comfortfloor® Tough.

PRODUCT INFORMATION

Chemical Base	PUR	
Packaging	Part A	16.2 kg containers
	Part B	3.8 kg containers
	Part A+B	20.0 kg ready to mix units
Shelf Life	12 months from date of production.	
Storage Conditions	The packaging must stored properly in original, unopened and undamaged	

sealed packaging, in dry conditions at temperatures between +5 °C and +30 °C.

Appearance / Colour	Resin - part A	coloured, liquid
	Hardener - part B	brown, transparent, liquid
	Available in RAL 1014, RAL 2000, RAL 3009, RAL 5015, RAL 6010, RAL 7042, RAL 8002, RAL 9001, RAL 9005 The colour of the Sikafloor®-327 has to be approximately adjusted to the colour of the Sikafloor®-305 W seal / top coat. Applied colours selected from colour charts will be approximate. For colour matching: Apply colour sample and confirm selected colour under real lighting conditions. When product is exposed to direct sunlight, there may be some discolouration and colour variation, this has no influence on the function and performance of the floor finish.	
Density	Mixed Resin: ~ 1,4 kg/l All Density values at +23 °C.	(ISO 1183-1)
Solid content by mass	~100 %	
Solid content by volume	~100 %	

TECHNICAL INFORMATION

Shore D Hardness	~ 60–70 (14 days / +23 °C)	(DIN 53505)
Tensile Strength	~ 19 N/mm ² (14 days / +23 °C)	(DIN 53504)
Elongation at Break	~ 28 % (14 days / +23°C)	(ISO 37)
Tensile adhesion strength	> 1.5 N/mm ² (failure in concrete)	(EN 13892-8)
Tear Strength	~ 40 N/mm (14 days / +23 °C)	(ISO 34-1)
Chemical Resistance	Sikafloor®-327 always has to be sealed with pigmented topcoat. Therefore, refer to chemical resistance of the used topcoat.	

SYSTEM INFORMATION

Systems	Please refer to the System Data Sheet of: Sika Comfortfloor® PS-27 Seamless, smooth, unicolour, low voc, tough elastic polyurethane floor covering	
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APPLICATION INFORMATION

Mixing Ratio	Part A : part B = 81:19 (by weight)
Consumption	~ 1.4 kg/m ² /mm
Layer Thickness	2.80 kg/m ² - film thickness ~ 2.0 mm Refer to the respective System Data Sheet.
Ambient Air Temperature	+10 °C min. / +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.
Substrate Temperature	+10 °C min. / +30 °C max.
Substrate Moisture Content	< 4 % pbw moisture content. Test method: Sika®-Tramex meter, CM - measurement or Oven-dry-meth-

od. No rising moisture according to ASTM (Polyethylene-sheet).

Pot Life	Temperature	Time
	+10 °C	~ 25 minutes
	+20 °C	~ 20 minutes
	+30 °C	~ 15 minutes

Curing Time	Before overcoating Sikafloor®-327 allow:		
	Substrate temperature	Minimum	Maximum
	+10 °C	24 hours	72 hours
	+20 °C	18 hours	48 hours
+30 °C	16 hours	36 hours	

Times are approximate and will be affected by changing ambient conditions particularly temperature and relative humidity.

If maximum waiting time is exceeded, exposed surface of Sikafloor®-327 has to be grinded to achieve mechanical bonding between the layers of Sikafloor®.

Applied Product Ready for Use	Temperature	Foot traffic	Full cure
	+10 °C	~ 24 hours	~ 72 hours
	+20 °C	~ 18 hours	~ 60 hours
	+30 °C	~ 16 hours	~ 48 hours

VALUE BASE

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.

FURTHER DOCUMENTS

Substrate Quality & Preparation

Please refer to Sika Information Manual: "EVALUATION AND PREPARATION OF SURFACES FOR FLOORING SYSTEMS".

Application Instructions

Please refer to Sika Information Manual: "MIXING & APPLICATION OF FLOORING SYSTEMS".

Maintenance

Please refer to "Sikafloor®- CLEANING REGIME".

LIMITATIONS

- Maximum relative humidity during application and curing 80 %.
- Do not apply Sikafloor®-327 on substrates with rising moisture.
- Do not apply on substrate surfaces with a slope > 1 %.
- Freshly applied Sikafloor®-327 must be protected from damp, condensation and water for at least 24 hours. Uncured material reacts in contact with water (foaming).
- During application care must be taken that no sweat drops into fresh Sikafloor®-327 (wear head and wrist bands).
- If heating is required do not use gas, oil, paraffin or other fossil fuel heaters, these produce large quantities of both CO₂ and H₂O water vapour, which may adversely affect the finish. For heating use only electric powered warm air blower systems

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

Regulation (EC) No 1907/2006 (REACH) - Mandatory training

As from 24 August 2023 adequate training is required before industrial or professional use of this product. For more information and a link to the training visit www.sika.com/pu-training.



DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

According to the EU-Directive 2004/42, the maximum allowed content of VOC (Product category IIA / j type sb) is 500 g/l (Limits 2010) for the ready to use product.

The maximum content of Sikafloor®-327 is < 500 g/l VOC for the ready to use product.

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY / PRE-TREATMENT

- Concrete substrates 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.
- Substrate Preparation. Concrete substrates must be prepared mechanically using vacuum assisted shot blasting, scabbling / scarifying or diamond grinding equipment to remove cement laitance and achieve an open textured surface.
- Weak concrete must be removed and surface defects such as blowholes and voids must be fully exposed.
- Repairs to the substrate, filling of blowholes/voids and surface levelling must be carried out using appropriate products from the Sikafloor®, SikaDur® and SikaGard® range of materials.
- The concrete or screed substrate has to be primed or levelled in order to achieve an even surface.
- High spots must be removed by e.g. grinding.
- All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush and/or vacuum.

MIXING

Prior to mixing, stir part A mechanically. When all of part B has been added to part A, mix continuously for 2 minutes until a uniform mix has been achieved. To ensure thorough mixing pour materials into another container and mix again to achieve a consistent mix. Over mixing must be avoided to minimise air entrainment.

Mixing Tools

Sikafloor®-327 must be thoroughly mixed using a low speed electric stirrer (300 - 400 rpm) or other suitable equipment.

APPLICATION

Prior to application, confirm substrate moisture content, relative humidity and dew point. Sikafloor®-327 is poured and spread evenly by means of a serrated trowel or pin rake. When used in a self smoothing system, roll in two direction with a spike roller to ensure even thickness and to remove entrapped air.

CLEANING OF TOOLS

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

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Product Data Sheet

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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.

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