

PRODUCT DATA SHEET

Sikafloor® P 604

(formerly MTop P 604)

Two-part, economical, pre-filled epoxy resin based primer, suitable for mineral substrates.

PRODUCT DESCRIPTION

Sikafloor® P 604 is a two-part, pre-filled, low viscosity epoxy resin-based primer.

USES

Sikafloor® P 604 is designed for use indoor as a pore sealer primer or scratch coat on mineral substrates such as concrete or cementitious screed. It can be used as scratch primer by adding oven dried silica sand in a proportion of 1 : 0,5 till 1 : 0,8.

CHARACTERISTICS / ADVANTAGES

- low viscosity
- easy to apply
- good penetration
- seals pores and capillaries

- excellent bond to substrate
- pre-filled
- fulfills AgBB requirement. Low emission in system
- fulfills the requirements of standard DIN EN 13578 regarding compatibility on wet concrete

ENVIRONMENTAL INFORMATION

Sikafloor® P 604 is registered in the DGNB (German Sustainable Building Council) Navigator platform and exhibits a DGNB Navigator label. The DGNB Navigator Label provides all the required information about our flooring products (product profiles) to build sustainable projects.

APPROVALS / STANDARDS

CE marking and declaration of performance based on EN 13813:2002 Screed material and floor screeds — Screed material — Properties and requirements — Synthetic resin screed material

PRODUCT INFORMATION

Packaging	Sikafloor® P 604 is supplied in 30 kg working packs and in 247 kg drums of Part A and in 200 kg drums of Part B.	
Colour	Light yellow	
Shelf Life	Under the specified storage conditions the material has a shelf life of 12 months. For maximum shelf life under these conditions, see "Best before" label.	
Storage Conditions	Store in original containers, under dry conditions and a temperature between 15–25°C. Do not expose to direct sunlight.	
Density	Part A at 20°C	1,62 g/cm ³
	Part B at 20°C	1,02 g/cm ³
	Mixed product at 20°C	1,44 g/cm ³

TECHNICAL INFORMATION

Shore D Hardness	Cured 7 days at +23°C	79	(EN ISO 868)
Compressive Strength	After 28 days at +23°C	55 N/mm ²	(EN 12190)
Tensile Strength	After 7 days at +23°C	10 N/mm ²	(DIN 53504)

APPLICATION INFORMATION

Mixing Ratio	100 : 27		
Consumption	The consumption of Sikafloor® P 604 as primer is between 0.3 – 0.8 kg/m ² depending on filling grad, condition and porosity of the substrate. A second coat of 0.2 – 0.4 kg/m ² of Sikafloor® P 604 is recommended for very porous substrates and improves the protection against rising damp. Oven dried silica sand 0.3 – 0.8 mm should be broadcast at approximately 1.0 kg/m ² not in excess into the still wet primer. The above consumption figures are intended as a guide only and may be higher on very rough or porous substrates.		
Ambient Air Temperature	Min.	8°C	
	Max.	30°C	
Relative Air Humidity	Max. at 10°C	75%	
	Max. at > 23°C	85%	
Substrate Temperature	Min.	8°C	
	Max.	30°C	
Pot Life	At 12°C	60 min	
	At 20°C	30 min	
	At 30°C	15 min	
Curing Time	at 10°C	5 d	
	at 23°C	3 d	
	at 30°C	2 d	
Waiting Time / Overcoating	Temperature	Minimum	Maximum
	at 10°C	16 h	48 h
	at 23°C	6 h	48 h
	at 30°C	3 h	24 h

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.

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.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

All substrates (new and old) must be structurally sound, dry and free of laitance and loose particles. Clean floors of oil, grease, rubber skid marks, paint stains and other adhesion impairing contaminants. Mechanical surface profiling by grit or shot blasting, high-pressure water jetting, grinding or scabbling (including the necessary post-treatment) are the preferred floor preparation methods.

After surface preparation the tensile strength of the substrate should exceed 1.5 N/mm² (check with an approved pull-off tester at a load rate of 100 N/s). The residual moisture content of the substrate must not exceed 4% (check with e.g. CM device). A damp proof course must have been properly installed and be intact.

MIXING

MasterTop P 604 is supplied in working packs which are pre-packaged in the exact ratio (except for the deliveries in drums). Before mixing, precondition both A and B components to a temperature of approximately 15 to 25°C. Pour the entire contents of Part B into the container of Part A. **DO NOT MIX BY HAND.** Mix with a mechanical drill and paddle at a very low speed (ca. 300 rpm) for at least 3 minutes. Scrape the sides and the bottom of the container several times to ensure complete mixing. Keep the mixer blades submerged in the coating to avoid introducing air bubbles. **DO NOT WORK OUT OF THE ORIGINAL CONTAINER.** After proper mixing to a homogeneous consistency pour the mixed Parts A and B into a fresh container and mix for another minute.

NOTE: For drum formats, pre-mix part A with a mechanical drill and paddle at a very low speed (ca. 300 rpm). Once part A has been homogenized, mix part A and part B together as previously described and respect the defined mix ratio (100:27) by using a scale.

APPLICATION

After mixing, Sikafloor® P 604 is applied to the prepared substrate by spreading with a squeegee or with a roller. We recommend to broadcast the wet primer with oven dried sand in order to improve adhesion of the following layer in case of PU based coat application. The curing time of the material is influenced by the ambient, material and substrate temperatures.

At low temperatures, the chemical reactions are slowed down; this lengthens the pot life, open time and curing times. High temperatures speed up the chemical reactions thus the time frames mentioned above are shortened accordingly. To fully cure, the material, substrate and application temperature should not fall below the minimum.

After application, the material should be protected from direct contact with water for approx. 24h (at 20°C). Within this period, contact with water can cause a surface bloom and/or surface tackiness, both of which must be removed. The temperature of the substrate must be at least 3 K above the dew point both during the application and for at least 24 hours after the application (at 15°C).

Sikafloor® P 604 should be applied when the ambient temperature is constant or falling as this will decrease the risk of bubble formation due to expansion of air that is enclosed in the concrete.

CLEANING OF TOOLS

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

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.

SIKA LIMITED

Watchmead
Welwyn Garden City
Hertfordshire, AL7 1BQ
Tel: 01707 394444
Web: www.sika.co.uk
Twitter: @SikaLimited



Product Data Sheet

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