

# PRODUCT DATA SHEET

## Sikafloor®-161 HC

### 2-PART EPOXY PRIMER, LEVELLING MORTAR, INTERMEDIATE LAYER AND MORTAR SCREED

#### DESCRIPTION

Sikafloor®-161 HC is an economic, two part, solvent free, low viscosity epoxy resin.

#### USES

- For priming concrete substrate, cement screeds and epoxy mortars
- For normal to strong absorbent substrates
- Primer for the Sikafloor®-263 SL HC and Sikafloor®-264 HC economic flooring systems
- Binder for levelling mortars and mortar screeds
- Intermediate layer underneath Sikafloor®-263 SL HC and Sikafloor®-264 HC

#### CHARACTERISTICS / ADVANTAGES

- Low viscosity
- Good penetration
- Excellent bond strength
- Solvent free
- Easy application
- Short waiting times
- Multi-purpose

#### PRODUCT INFORMATION

<b>Chemical Base</b>	Epoxy		
<b>Packaging</b>	PART A :	220 kg drums, 15.8 kg can	
	PART B :	177 kg, 59 kg drums, 4.2 kg can	
	PART A+B :	1 drum part A + 1 drum part B = 279 kg	
		3 drum part A + 1 drum part B = 837 kg	
		20 kg set (A+B)	
<b>Appearance / Colour</b>	PART A – Resin :	Liquid, brownish-transparent	
	PART B – Hardener :	Liquid, transparent	
<b>Shelf Life</b>	24 months from date of production if stored properly in original, unopened and undamaged sealed packaging		
<b>Storage Conditions</b>	Store in dry conditions at temperatures between +18 °C and +30 °C.		
<b>Density</b>	PART A :	~1.6 kg/L (at +23 °C)	(DIN EN ISO 2811-1)
	PART B :	~1.0 kg/L (at +23 °C)	
	Mixed Resin :	~1.4 kg/L (at +23 °C)	
<b>Solid Content</b>	~ 100 % (by volume) / ~ 100 % (by weight)		

## TECHNICAL INFORMATION

<b>Compressive Strength</b>	Resin: ~ 60 N/mm <sup>2</sup> (28 days / +23 °C)	(EN 196-1)								
<b>Tensile Adhesion Strength</b>	> 1.5 N/mm <sup>2</sup> (failure in concrete)	(ISO 4624)								
<b>Chemical Resistance</b>	Resistant to many chemicals. Please ask for a detailed chemical resistance table.									
<b>Thermal Resistance</b>	<table><thead><tr><th>Exposure*</th><th>Dry Heat</th></tr></thead><tbody><tr><td>Permanent</td><td>+50 °C</td></tr><tr><td>Short-term max. 7 d</td><td>+80 °C</td></tr><tr><td>Short-term max. 12 h</td><td>+100 °C</td></tr></tbody></table> <p>Short-term moist/wet heat* up to +80°C where exposure is only occasional steam cleaning etc.).</p> <p>*No simultaneous chemical and mechanical exposure and only in combination with Sikafloor® systems as a broadcast system with approx. 3 - 4 mm thickness.</p>	Exposure*	Dry Heat	Permanent	+50 °C	Short-term max. 7 d	+80 °C	Short-term max. 12 h	+100 °C	
Exposure*	Dry Heat									
Permanent	+50 °C									
Short-term max. 7 d	+80 °C									
Short-term max. 12 h	+100 °C									
<b>Shore D Hardness</b>	76 (7 days / +23 °C)	(DIN 53 505)								
<b>Tensile Flexural Strength</b>	Resin: ~ 30 N/mm <sup>2</sup> (28 days / +23 °C)	(EN 196-1)								

## SYSTEM INFORMATION

### System

#### Primer:

Low / medium porosity concrete: 1 x Sikafloor®-161 HC

High porosity concrete: 2 x Sikafloor®-161 HC

Levelling mortar fine (surface roughness < 1 mm):

Primer: 1 x Sikafloor®-161 HC

Levelling mortar: 1 x Sikafloor®-161 HC + quartz sand  
(0.1 - 0.3 mm) + Extender T

Levelling mortar medium (surface roughness up to 2 mm):

Primer: 1 x Sikafloor®-161 HC

Levelling mortar: 1 x Sikafloor®-161 HC + quartz sand  
(0.1 - 0.3 mm) + Extender T

Intermediate layer (self-smoothing 1.5 to 3 mm):

Primer: 1 x Sikafloor®-161 HC

Levelling mortar: 1 x Sikafloor®-161 HC + quartz sand  
(0.1 - 0.3 mm)

Epoxy screed (15 - 20 mm layer thickness) / repair mortar

Primer: 1 x Sikafloor®-161 HC

Bonding bridge: 1 x Sikafloor®-161 HC

Screed: 1 x Sikafloor®-161 HC + suitable sand mixture

In practice the following sand mixtures proved to be suitable (grain size distribution for layer thicknesses of 15 - 20 mm):

25 pbw quartz sand 0.1 - 0.5 mm

25 pbw quartz sand 0.4 - 0.7 mm

25 pbw quartz sand 0.7 - 1.2 mm

25 pbw quartz sand 2 - 4 mm

Note: The largest grain size should be a maximum 1/3 of the finished layer thickness. Dependent on the grain shape and application temperatures, the aggregates and the most suitable mix should be selected.

## APPLICATION INFORMATION

**Mixing Ratio** Part A : part B = 79 : 21 (by weight)

### Consumption

Coating System	Product	Consumption
Priming	Sikafloor® -161 HC	0.35 - 0.55 kg/m <sup>2</sup>
Levelling mortar fine (surface roughness < 1 mm)	1 pbw Sikafloor® -161HC + 0.5 pbw quartz sand (0.1 - 0.3 mm) + 0.015 pbw Extender T	1.7 kg/m <sup>2</sup> /mm
Levelling mortar medium (surface roughness up to 2 mm)	1 pbw Sikafloor® -161 HC + 1 pbw quartz sand (0.1 - 0.3 mm) + 0.015 pbw Extender T	1.9 kg/m <sup>2</sup> /mm
Intermediate layer (self-smoothing 1.5 to 3 mm)	1 pbw Sikafloor® -161 HC + 1 pbw quartz sand (0.1 - 0.3 mm) + optional broadcast quartz sand 0.4 – 0.7 mm	1.9 kg/m <sup>2</sup> mixture (0.9 kg/m <sup>2</sup> binder + 0.9 kg/m <sup>2</sup> quartz sand) per mm layer thickness ~ 4.0 kg/m <sup>2</sup>
Bonding bridge	Sikafloor® -161 HC	0.3 - 0.5 kg/m <sup>2</sup>
Epoxy screed (15 - 20 mm layer thickness ) / Repair Mortar	1 pbw Sikafloor® -161 HC + 8 pbw quartz sand	2.2 kg/m <sup>2</sup> /mm

Note: These figures are theoretical and do not allow for any additional material required due to surface porosity, surface profile, variations in level or wastage etc.

**Layer Thickness** As Top Coat : 70 microns min. / 140 microns max.  
As stand alone coating : 140 microns min. / 275 microns max

**Ambient Air Temperature** +10 °C min / +30 °C

**Relative Air Humidity** 80 % r.h. max.

**Substrate Quality** Concrete substrates must be sound and of sufficient compressive strength (minimum 25 N/mm<sup>2</sup>) with a minimum pull off strength of 1.5 N/mm<sup>2</sup>. 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 abrasive blast cleaning or scarifying 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.

**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.

<b>Substrate Temperature</b>	+10 °C min / +30 °C
<b>Substrate Moisture Content</b>	< 4 % pbw moisture content. Test method: Sika®-Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).

<b>Pot Life</b>	<b>Temperature</b>	<b>Time</b>
	+10 °C	~50 min
	+20 °C	~25 min
	+30 °C	~15 min

<b>Curing Time</b>	<b>Waiting Time</b>	Before applying solvent free products on Sikafloor®-161 HC allow:	
	<b>Substrate Temperature</b>	<b>Minimum</b>	<b>Maximum</b>
	+10 °C	24 hours	4 days
	+20 °C	12 hours	2 days
	+30 °C	8 hours	24 hours

Before applying solvent containing products on Sikafloor®-161 HC allow:

<b>Substrate Temperature</b>	<b>Minimum</b>	<b>Maximum</b>
+10 °C	36 hours	6 days
+20 °C	24 hours	4 days
+30 °C	16 hours	2 days

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

**Applied Product ready for use**

<b>Substrate Temperature</b>	<b>Foot Traffic</b>	<b>Light Traffic</b>	<b>Full Cure</b>
+10 °C	~24 hours	~6 days	~10 days
+20 °C	~12 hours	~4 days	~7 days
+30 °C	~8 hours	~2 days	~5 days

Note: Times are approximate and will be affected by changing ambient and substrate conditions.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

Concrete substrates must be prepared mechanically using abrasive blast cleaning or scarifying 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 TIME

Prior to mixing, stir part A mechanically. When all of part B has been added to part A, mix continuously for 3 minutes until a uniform mix has been achieved. When parts A and B have been mixed, add the quartz sand and if required the Extender T and mix for a further 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®-161 must be thoroughly mixed using a low speed electric stirrer (300 - 400 rpm) or other suitable equipment.

For the preparation of mortars use a forced action mixer of rotating pan, paddle or trough type. Free fall mixers should not be used.

## APPLICATION

Prior to application, confirm substrate moisture content, r.h. and dew point.

If > 4% pbw moisture content, Sikafloor® EpoCem® may be applied as a T.M.B. (temporary moisture barrier) system.

Primer:

Make sure that a continuous, pore free coat covers the substrate. If necessary, apply two priming coats. Apply Sikafloor®-161 HC by brush, roller or squeegee.

Levelling mortar

Rough surfaces need to be levelled first. Apply the levelling mortar by squeegee/trowel to the required thickness.

Intermediate layer

Sikafloor®-161 HC is poured, spread evenly by means of a serrated trowel. Roll immediately in two directions with spiked roller to ensure even thickness and if required broadcast with quartz sand, after about 15 minutes (at +20°C) but before 30 minutes (at+20°C), at first lightly and then to excess.

Bonding bridge:

Apply Sikafloor®-161HC by brush, roller or squeegee.

Epoxy screed / repair mortar:

Apply the mortar screed evenly on the still “tacky” bonding bridge, using leveling battens and screed rails as necessary. After a short waiting time compact and smoothen the mortar with a trowel or Teflon coated power float (usually 20 – 90 rpm).

## CLEANING OF TOOLS

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

## LIMITATIONS

Do not apply Sikafloor®-161 HC on substrates with rising moisture.

Freshly applied Sikafloor®-161 HC should be protected from damp, condensation and water for at least 24 hours.

Avoid puddles on the surface with the primer.

Sikafloor®-161 HC mortar screed is not suitable for frequent or permanent contact with water unless sealed.

Practical trials should be carried out for mortar mixes to assess suitable aggregate grain size distribution.

For external applications, apply on a falling temperature. If applied during rising temperatures “pin holing” may occur from rising air.

**Tools:**

Recommended supplier of tools:

PPW-Polyplan-Werkzeuge GmbH, Phone: +49 40/5597260, [www.polyplan.com](http://www.polyplan.com)

Construction joints require pre-treatment. Treat as follows:

- Static Cracks: prefill and level with SikaDur® or Sikafloor® epoxy resin
- Dynamic cracks: to be assessed and if necessary apply a stripe coat of elastomeric material or design as a movement joint

The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking.

Under certain conditions, underfloor heating or high ambient temperatures combined with high point loading, may lead to imprints in the resin.

If heating is required do not use gas, oil, paraffin or other fossil fuel heaters, these produce large quantities of both CO<sub>2</sub> and H<sub>2</sub>O water vapour, which may adversely affect the finish. For heating use only electric powered warm air blower systems.

## BASIS OF PRODUCT DATA

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.

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data and uses.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

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## 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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