

## PRODUCT DATA SHEET

# Sikafloor®-81 EpoCem®

Epoxy-cement hybrid multipurpose flooring mortar and self-smoothing screed (1,5–3,0 mm)

### DESCRIPTION

Sikafloor®-81 EpoCem® is a 3-part, epoxy modified cementitious, multipurpose flooring mortar.

### USES

Sikafloor®-81 EpoCem® may only be used by experienced professionals.

On interior industrial flooring cementitious substrates including vacuum dewatered concrete floors as a:

#### Temporary moisture barrier (TMB)

- Allows the application of Sika® Epoxy, Polyurethane and PMMA resin floors onto high moisture content substrates or green concrete

#### Self-smoothing screed

- Levelling or patch repairing horizontal floors for new, refurbishment or maintenance works
- Unaesthetic floor topping on non-ventilated damp substrates
- Levelling layer under Sika® Epoxy, Polyurethane and PMMA flooring systems, tiles, carpets, laminate, wooden, linoleum and vinyl sheet flooring

#### Repair mortar

- Repairing the substrate before application of Sika® Epoxy, Polyurethane and PMMA flooring systems

#### Concrete repair and protection EN standards principle and method approach

- Suitable for moisture control (Principle 2, method 2.3 of EN 1504-9)
- Suitable for physical resistance (Principle 5, method 5.1 of EN 1504-9)
- Suitable for restoration work (Principle 3, method 3.1 of EN 1504-9).
- Suitable for preserving or restoring passivity (principle 7, method 7.1 and 7.2 of EN 1504-9).
- Suitable for increasing resistivity (Principle 8, method 8.3 of EN 1504-9)

### CHARACTERISTICS / ADVANTAGES

- Can be overcoated with resin based floor finishes after 24 hours
- Prevents osmotic blistering of resin based floor finishes on damp substrates
- Fast and easy application
- Concrete repair mortar: EN 1504-3:Class R4
- Good levelling properties
- Impervious to liquids, permeable to water vapour
- Freeze thaw and de-icing salt resistant
- Good chemical resistance
- Thermal expansion properties similar to concrete
- Good bond to green or hardened concrete whether damp or dry
- Good early and final mechanical strengths
- Good resistance to water and oils
- Suitable surface for overlaying smooth floor finishes
- Low VOC emissions
- Will not corrode reinforcement steel

### SUSTAINABILITY

- GISCODE RE30
- EPD

*DGNB – New buildings and extensive renovations, version 2020 2.0.0 and 2023:*

The product is assessed to meet requirements for indicator 23, quality level 3, according to criteria matrix for ENV1.2/Environmentally hazardous substances.

### APPROVALS / CERTIFICATES

- CE Marking and Declaration of Performance to EN 1504-2 - Surface protection product for concrete - Coating
- CE Marking and Declaration of Performance to EN 1504-3 - Concrete repair product for structural repair

- CE Marking and Declaration of Performance to EN 13813 - Resin screed material for internal use in buildings
- Migration test EN 23270, Sikafloor®-81 EpoCem, kiwa, Report No. P 8740a
- Water permeability test DIN 1048-5, Sikafloor®-81 EpoCem, Polymer Institut, Report No. P 3439
- Fire testing EN 13501-1, Sikafloor®-81 EpoCem, MPA Dresden, Report No. 041706
- Fire testing EN 13501-1, Sikafloor®-81 EpoCem, Hoch, Report No. KB-Hoch-170138
- Sliding test DIN 51130, Sikafloor®-264 N, Roxeler, Certificates No. 020044-17-7, 020044-17-7a, 020044-17-8a

## PRODUCT INFORMATION

<b>Product declaration</b>	EN 1504-2 - Surface protection product for concrete - Coating Complies with the general requirements of EN 1504-3: Class R4 EN 13813 - Resin screed material for internal use in buildings		
<b>Composition</b>	Epoxy modified cementitious mortar		
<b>Packaging</b>	Pre-batched 23 kg units.		
	Part A	1,14 kg container	
	Part B	2,86 kg container	
	Part C	19 kg plastic bags	
	Refer to current price list for packaging variations		
<b>Shelf life</b>	Part A and Part B	12 months from date of production	
	Part C	12 months from date of production	
<b>Storage conditions</b>	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging.		
<b>Appearance and colour</b>	Final floor appearance: Smooth, matt finish		
	Part A-resin	white liquid	
	Part B - hardener	transparent yellow liquid	
	Part C - filler	natural grey aggregate powder	
	Final floor finish colour	light grey	
<b>Density</b>	Part A	~1,05 kg/l	(EN 1015-6)
	Part B	~1,03 kg/l	
	Resin mixed	~1,72 kg/l	
	Parts A+B+C mixed	~2,10 kg/l	
	All Density values at +20 °C.		

## TECHNICAL INFORMATION

<b>Compressive strength</b>	<b>Time</b>	<b>Strength</b>	(EN 13892-2)
	1 day	~15 N/mm <sup>2</sup>	
	7 days	~50 N/mm <sup>2</sup>	
	28 days	~60 N/mm <sup>2</sup>	
	Values +23 °C / 50 % r.h.		
<b>Tensile strength in flexure</b>	<b>Time</b>	<b>Strength</b>	(EN 13892-2)
	1 day	~5,8 N/mm <sup>2</sup>	
	7 days	~11,1 N/mm <sup>2</sup>	
	28 days	~14 N/mm <sup>2</sup>	
	Values at +23 °C / 50 % r.h.		
<b>Coefficient of thermal expansion</b>	15,2×10 <sup>-6</sup> 1/K	(EN 1770)	
<b>Service temperature</b>	-30 °C to +80 °C for continuous exposure.		
<b>Water absorption</b>	0,02 kg·m <sup>-2</sup> ·h <sup>-0.5</sup>	(DIN 52617)	

<b>Permeability to water vapour</b>	$\mu_{H_2O} = 252$ Equivalent air layer depth for 3 mm thickness: $S_d = 0,75$ m	(DIN 52615)
<b>Permeability to carbon dioxide</b>	$\mu_{CO_2} \approx 4168$	(SN EN 1062-6)
<b>Chemical resistance</b>	Resistant to many chemicals. Contact Sika Technical Services for additional information	
<b>Freeze thaw de-icing salt resistance</b>	Resistance factor WFT-L 98 % (High)	D-R (SN / VSS 640 461)
<b>Carbonation resistance</b>	Carbonation resistance for 3 mm thickness: $R \approx 12,5$ m	
<b>Reaction to fire</b>	A2(fl) S1	(EN 13501-1)

## SYSTEM INFORMATION

### Systems

#### Substrate types

- Green concrete (as soon as mechanical preparation is possible)
- Damp concrete (> 14 days old)
- Damp aged concrete (rising moisture)

#### Temporary moisture barrier (TMB)

Layer thickness: 2,0 mm minimum

Primer: Sikafloor®-155 WN or Sikafloor® EpoCem® Module Primer (Part A+B)

TBM: Sikafloor®-81 EpoCem®

#### Self-smoothing screed (medium substrate roughness)

Layer thickness: 1.5–3 mm

Primer: Sikafloor®-155 WN or Sikafloor® EpoCem® Module Primer ( Part A+B)

Screed: Sikafloor®-81 EpoCem®

#### Concrete patch repair

Layer thickness: 3–9 mm

Bonding primer: SikaTop®-Armotec®-110 EpoCem®

Concrete repair mortar: Sikafloor®-81 EpoCem® - (refer to mixing details)

#### Interlayer primer for Sikafloor®-81/82 EpoCem

Bonding primer: Sikafloor®-155 WN

#### Floor finish

Resin: Suitable product from the Sikafloor® and Sikagard® range

The system structures as described must not be changed.

#### Also refer to the following System Data Sheets:

Sikafloor® MultiDur ES-14 N ECC

Sikafloor® MultiDur EB-24 N ECC

Sikafloor® MultiDur ET-14 N ECC

## APPLICATION INFORMATION

<b>Mixing ratio</b>	Packaging size: Part A : Part B : Part C = 1,14 kg : 2,86 kg : 19 kg <b>TMB and Self-smoothing screed</b>	
	<b>Temperature</b>	<b>Mixing Ratio by weight</b>
	+12 °C min. / +25 °C max.	Part A : Part B : Part C = 1 : 2,5 : 17 Parts (A+B) : Part C = 4 kg : 19 kg
	+8 °C min. / +12 °C max.	Part A : Part B : Part C = 1 : 2,5 : 15,8
	+25 °C min. / +30 °C max.	Parts (A+B) : Part C = 4 kg : 18 kg To improve workability, Part C can be reduced to 18 kg. Never reduce Part C to less than 18 kg
	<b>Concrete patch repair mortar</b> The standard Sikafloor®-81 EpoCem® mix can be bulked out with dry quartz sand. For each 23 kg unit of mixed Sikafloor®-81 EpoCem® add 5–10 kg of: Sikadur®-509 (quartz sand 0,7–1,2 mm) and Sikadur®-510 (quartz sand 2,0–3,0 mm) Final mix will be: 33–43 kg	
<b>Consumption</b>	TMB and Self-smoothing screed: Sikafloor®-81 EpoCem®	~2,25 kg/m <sup>2</sup> /mm
	Concrete patch repair mortar:Sika-floor®-81 EpoCem®	~2,4 kg/m <sup>2</sup> /mm
	Also refer to the following System Data Sheets: <ul style="list-style-type: none"> <li>▪ Sikafloor® MultiDur ES-14 N ECC</li> <li>▪ Sikafloor® MultiDur EB-24 N ECC</li> <li>▪ Sikafloor® MultiDur ET-14 N ECC</li> </ul> These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level or wastage, etc.	
<b>Layer thickness</b>	Temporary moisture barrier (TMB)	2,0 mm min.
	Self-smoothing screed	1,5 mm min. / 3,0 mm max.
	Concrete patch repair mortar maximum surface area ~3 x 5 cm	3,0 mm min. / 9,0 mm max.
<b>Ambient air temperature</b>	+8 °C min. / +30 °C max.	
<b>Relative air humidity</b>	20 % min. / 80 % max.	
<b>Substrate temperature</b>	+8 °C min. / +30 °C max.	
<b>Substrate moisture content</b>	Can also be applied on green or damp concrete with no standing water. Although the system can be applied onto green concrete surfaces (> 24 hours), it is advised to allow at least 3 days for early concrete shrinkage to occur in order to prevent shrinkage cracks from appearing on the TMB / screed surface.	
<b>Pot Life</b>	<b>Temperature</b>	<b>Time</b>
	+10 °C	~40 minutes
	+20 °C	~20 minutes
	+30 °C	~10 minutes
	23 kg units Values at 75 % R.H	

## Curing time

Once Sikafloor®-81 EpoCem® is tack free it is possible to apply vapour permeable resin finishes.

For the application of vapour tight resin finishes on Sikafloor®-81 EpoCem®, allow the substrate moisture content to fall below 4 % and not earlier than:

<b>Substrate Temperature</b>	<b>Waiting Time</b>
+10 °C	~48 hours
+20 °C	~24 hours
+30 °C	~24 hours

## 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.

## FURTHER INFORMATION

- Sika® Method Statement: Evaluation and Preparation of Surfaces for Flooring Systems
- Sika® Method Statement: Mixing & Application of Flooring Systems
- System Data Sheet: Sikafloor® MultiDur ES-14 N ECC
- System Data Sheet: Sikafloor® MultiDur EB-24 N ECC
- System Data Sheet: Sikafloor® MultiDur ET-14 N ECC

## IMPORTANT CONSIDERATIONS

- The incorrect assessment and treatment of cracks in the floor substrate can lead to a reduced service life and reflective cracking.
- Pre-treat cracks as follows before application of Sikafloor®-81 EpoCem®: Static Cracks: Prefill and level with Sikadur® or Sikafloor® epoxy resin. Dynamic Cracks (> 0,4 mm): To be assessed on site and if necessary apply a stripe coat of elastomeric material or design as a movement joint.
- Do not use any water in the mix or for finishing as this will affect the performance, surface finish and cause discolouration.
- If Sikafloor®-81 EpoCem® is used as TMB (Temporary Moisture Barrier), a 2 mm minimum thickness must be applied. (~4,5 kg/m<sup>2</sup>)
- Always ensure good ventilation when using product in a confined space to remove excess moisture.
- After application, product must be protected from damp, condensation and direct water contact for at least 24 hours
- Prevent premature drying by protecting from strong winds and do not expose to direct sun light while in an unhardened condition.
- Apply primer and Sikafloor®-81 EpoCem® on a falling temperature. If applied during rising temperatures "pin holing" can occur.
- Curing is not required, however applications under extreme conditions (high temperature and low humidity) which can cause fast drying of the product must be avoided.
- Do not add water to the mix.
- 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.

- When overlaying with PMMA screeds, the wet surface of Sikafloor®-81 EpoCem® during application must be fully broadcast with kiln dried quartz sand 0,4 - 0,7 mm granulometry.
- The TMB effect in Sikafloor®-EpoCem® is limited in time, without additional preparation. Contact Sika Technical Services for additional information.
- Always verify the surface moisture content if more than 5-7 days have passed since application.

## 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.

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

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / C type wb) is 40 g/l (Limits 2010) for the ready to use product.

The maximum content of Sikafloor®-81 EpoCem® is ≤ 40 g/l VOC for the ready to use product.

## APPLICATION INSTRUCTIONS

### EQUIPMENT

Select the most appropriate equipment required for the project:

#### Substrate preparation

- Abrasive blasting cleaning equipment
- Planing machine
- Scarifying machine
- High pressure water blasting equipment
- Mechanical hand held tools for breaking out concrete

For other types of preparation equipment, contact Sika Technical Services

#### Mixing

- Electric single or double paddle mixer (300–400 rpm) with helix paddle
- Forced action / rotating pan / double paddle or trough type mixer (300–400 rpm).
- Scraper
- Clean mixing containers

For other types of mixing equipment, contact Sika Technical Services

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### Application: TBM & Self-levelling screed

- Mixed material carrier
- Pin leveller
- Trowels
- Spiked roller
- Squeegee
- Fleece rollers

### Application: Concrete patch repairs

- Plasterers hawk
  - Trowel
- Finishing
- Trowel (PVC or wooden)
  - sponge

## SUBSTRATE QUALITY / PRE-TREATMENT

### TMB & Self-levelling screed

The concrete substrate must be sound and of sufficient compressive strength (minimum 25 N/mm<sup>2</sup>) with a minimum tensile adhesion strength of 1,5 N/mm<sup>2</sup>. The substrate can be damp but must be free of standing water (no puddles) and be free of all contaminants such as dirt, oil, grease, coatings and surface treatments etc.

Concrete substrates must be prepared mechanically using abrasive blast cleaning, scarifying or grinding equipment to remove cement laitance and achieve an open textured surface to suit the requirements of the next layer(s).

Weak concrete must be removed and surface defects such as blow holes and voids must be fully exposed. Repairs to the substrate, filling of blowholes/voids and surface levelling must be carried out using products from the Sikafloor<sup>®</sup>, Sikadur<sup>®</sup> and Sikagard<sup>®</sup> range of materials. Products must be cured before applying Sikafloor<sup>®</sup>-81 EpoCem<sup>®</sup>.

High spots can be removed by grinding. All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush or vacuum.

### Concrete Patch repairs

Repair surface areas must be prepared using mechanical hand held tools to provide simple square or rectangular layouts and depths of 3,0 mm minimum.

## MIXING

### TMB and Self-levelling screed

Prior to mixing, shake Part A (white liquid) briefly until uniformly mixed. Then pour into Part B container and shake vigorously for at least 30 seconds. When dosing out of drums, uniformly mix Parts A and B separately before mixing together.

Pour the mixed binder mixture (Parts A+B) into a suitable mixing container (capacity ~30 litres). Using an electric single or double paddle mixer or other similar equipment, gradually add Part C. Mix for a further 3,0 minutes until a uniform lump free mix has been achieved. Mix full units only. Do not add water. Mixing time for A+B = ~30 seconds. A+B+C = ~3,0 minutes 30 seconds.

### Concrete patch repair mortar

Prior to mixing, shake Part A (white liquid) briefly until uniformly mixed. Then pour into Part B container and shake vigorously for at least 30 seconds. When dosing out of drums, uniformly mix Parts A and B separately before mixing together.

Pour the mixed binder mixture (Parts A+B) into a suitable mixing container (capacity ~30 litres). Using an electric single or double paddle mixer or other similar equipment, gradually add Part C. Mix for a further 3,0 minutes until a uniform lump free mix has been achieved. When Parts A+B+C have been thoroughly mixed, gradually add the additional aggregates in the required quantities. Mix for a further 3,0 minutes until a uniform mix has been achieved. Mix full units only. Do not add water. Mixing time for A+B = ~30 seconds. A+B+C = ~3,0 minutes 30 seconds. A+B+C+ aggregate = ~6,0 minutes 30 seconds.

## APPLICATION

### TMB and SELF- LEVELLING SCREED

#### Primer

Pour mixed Sikafloor<sup>®</sup>-155 WN or Sikafloor<sup>®</sup> EpoCem<sup>®</sup> Module primer onto the prepared substrate and apply by brush, roller or squeegee then back roller in two directions at right angles to each other. Ensure a continuous, pore free coat covers the substrate.

#### Sikafloor<sup>®</sup>-81 EpoCem<sup>®</sup>

Pour mixed Sikafloor<sup>®</sup>-81 EpoCem<sup>®</sup> onto the prepared primed substrate and spread evenly using a suitable trowel or pin leveller to the required thickness.

Spike roller immediately in two directions at right angles to each other to remove trowel marks, aid air release, ensure an even thickness and obtain the required surface finish. A seamless finish can be achieved if a 'wet' edge is maintained during application.

### CONCRETE PATCH REPAIR

#### Bonding primer

Apply the mixed SikaTop<sup>®</sup>-Armotec<sup>®</sup>-110 EpoCem<sup>®</sup> onto the prepared substrate by brush.

#### Repair Mortar

Place the mixed Sikafloor<sup>®</sup>-81 EpoCem<sup>®</sup> repair mortar onto the bonding primer 'wet on wet' by gloved hand or trowel between the minimum and maximum layer thicknesses without the formation of voids.

#### Surface finishing

Finishing must be carried out to the required surface texture using trowel and / or sponge as soon as the repair mortar has started to harden.

## CLEANING OF EQUIPMENT

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

## MAINTENANCE

Sikafloor<sup>®</sup>-81 EpoCem<sup>®</sup> must not be used as wearing layer where staining can occur and needs to be removed for aesthetic reasons. A seal coat from the

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Sikafloor® range of products with suitable cleaning capabilities is advisable.

Remove dirt using a brush and/or vacuum. Do not use wet cleaning methods until the product is fully cured. Do not use abrasive methods or cleaners.

## LOCAL RESTRICTIONS

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

## LEGAL NOTES

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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