

## Sikafloor®-20 N PurCem®

Heavy duty, high strength, easy trowel, polyurethane screed

### Product Description

Sikafloor®-20 N PurCem® is a three part, resin rich, water dispersed, high strength, smooth trowel grade, coloured polyurethane modified, cement and aggregate screed suitable for floors subject to heavy loading, abrasion and chemical exposure.

It has a textured aggregate surface providing medium to heavy profile slip resistance and is typically installed at 6 to 9 mm thick.

### Uses

In areas subject to heavy loading, abrasion and high chemical exposure, to provide a hard wearing surface, such as in:

- Food processing plants, in wet or dry process areas, freezers and coolers, thermal shock areas
- Chemical plants
- Laboratories
- Workshops

### Characteristics / Advantages

- Fluid consistency requires less labour to install than conventional heavy duty modified PU trowel grade screeds
- Excellent chemical resistance. Resists a wide range of organic and inorganic acids, alkalis, amines, salts and solvents. Please refer to the Chemical Resistance Chart or consult your local Technical Dept.
- Similar coefficient of thermal expansion to concrete, allowing movement with the substrate through normal thermal cycling. It will perform and retain its physical characteristics through a wide temperature range from -40°C (-40°F) up to +120°C (239°F)
- Steam cleanable at 9 mm thick
- Bond strength in excess of the tensile strength of concrete. Concrete will fail first
- Non taint, odourless
- VOC free
- High mechanical resistance. Behaves plastically subject to impact. Will deform but will not crack or debond
- Slip resistance. Natural textured surface provides anti-slip traction
- High abrasion resistance resulting from its silica aggregate structure
- Rapid one step application. Normally, no concrete primer or sealer required
- Fast curing will allow foot traffic after ten hours and full service after twelve hours. Production downtime is cut to an absolute minimum.
- Jointless. Extra expansion joints are not necessary; simply maintain and extend existing expansion joints up through the Sikafloor® -PurCem® flooring system
- Easily maintained

Construction



## Tests

### Approval / Standards

Conforms to the requirements of EN 13813: 2002 as CT - C50 - F10 - AR0.5

Concerning contact with foodstuffs, it conforms to the requirements of:

- EN1186, EN 13130, and prCEN/TS 14234 standards, and the Decree on Consumer Goods, representing the conversion of directives 89/109/EEC, 90/128/EEC and 2002/72/EC for contact with food stuffs, according to test report by ISEGA, Registered N° 24549 U 07, dated May 18<sup>th</sup>, 2007.
- USDA. Acceptance for use in food plants in the USA
- Canadian Food Inspection Agency acceptance for use in food plants in Canada.
- British Standards Specifications (BSS) acceptance for use in the UK. Campden and Chorleywood Food Research Association, Ref. S/REP/98152/2A, dated March 6th, 2007

Test reports from Warrington Fire Research Centre for Sikafloor® -20N PurCem®: WFRC No. 163876, dated XXX, 2007 (BS EN ISO 11925-2:2002) and WFRC No. 163877, dated XXX, 2007 (BS EN ISO 9239-1:2002) for Fire rating

All other values indicated are internal test results.

## Product Data

### Form

#### Appearance / Colours

Part A: coloured liquid  
Part B: brown liquid  
Part C: natural grey powder

Available colours: Beige (~ RAL 1001), Maize yellow (~ RAL 1006), Oxide red (~ RAL 3009), Sky blue (~ RAL 5015), Grass green (~ RAL 6010), Dusty grey (~ RAL 7037), Agate grey (~ RAL 7038), Telegrey2 (~ RAL 7046).

#### Packaging

Part A+B+C: 31.0 kg ready to mix units  
Part A: 3.22 kg plastic drum  
Part B: 2.78 kg plastic jerrycan  
Part C: 25.0 kg plastic lined, double paper bags

### Storage

#### Storage Conditions / Shelf-Life

If stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +10°C and +25°C.

Parts A and B: 6 months from date of production. Must be protected from frost.

Part C: 6 months from date of production. Must be protected from humidity.

### Technical Data

#### Chemical Base

Part A: Water borne polyol  
Part B: Isocyanate  
Part C: Aggregates, cement and active fillers

#### Density

Part A: ~ 1.07 kg/l (at +20°C) (EN ISO 2811-1)  
Part B: ~ 1.24 kg/l (at +20°C) & (ASTM C 905)  
Part C: ~ 1.58 kg/l (at +20°C)  
Part A+B+C mixed: ~ 2.08 kg/l ± 0.03 (at +20°C)

#### Capillary Absorption

Permeability to water: 1.07 g/h/m<sup>2</sup> (EN 1062-3)  
(3 mm)

#### Layer Thickness

6 mm min. / 9 mm max.

#### Thermal Expansion Coefficient

$\alpha \approx 2.7 \times 10^{-5}$  per °C (ASTM E 381, ASTM D-696, ISO 11359)  
(temperature range: -20°C to +60°C)

#### Water Absorption

0.22% (ASTM C 413)

<b>Permeability</b>	To Water Vapour: 0.148 g/h/m <sup>2</sup> (6.1 mm)	(ASTM E-96)
<b>Fire Rating</b>	Class B <sub>(fl)</sub>	(BS EN 13501-1)
<b>Service Temperature</b>	The product is suitable for use when exposed to continuous temperatures, wet or dry, of up to +120°C.  The minimum service temperature is -40°C	

### Mechanical / Physical Properties

<b>Compressive Strength</b>	> 45 MPa after 28 days at +23°C / 50% r.h. > 50 N/mm <sup>2</sup> after 28 days at +23°C / 50% r.h.	(ASTM C 579) (BS EN 13892-2)
<b>Flexural Strength</b>	> (3 mm) 9.5 MPa after 28 days at +23°C / 50% r.h. >10 N/mm <sup>2</sup> after 28 days at +23°C / 50% r.h.	(ASTM C 580) (BS EN 13892-2)
<b>Tensile Strength</b>	> 4.3 N/mm <sup>2</sup> after 28 days at +23°C / 50% r.h.	(ASTM C 307)
<b>Bond Strength</b>	> 1.75 N/mm <sup>2</sup> (failure in concrete) (1.5 N/mm <sup>2</sup> is the minimum pull off strength of the recommended concrete substrate)	(EN 1542)

<b>Shore D Hardness</b>	80 - 85	(ASTM D 2240)
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<b>Flexural Modulus</b>	3750 MPa	(ASTM C 580)
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<b>Coefficient of Friction</b>	Steel: 0.4 Rubber: 1.25	(ASTM D 1894-61T)
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<b>Slip Resistance</b>	Slip Resistance Values			(BS 8204 Part 2)
	Substrate	SRV Dry	SRV Wet	
	Sikafloor®-20N PurCem®	70	65	
	TRL Pendulum, Rapra 4S Slider			

<b>Abrasion Resistance</b>	Class "Special" Severe abrasion resistance AR 0.5 (Less than 0.05 mm wear depth)  2730 mg Taber Abrader H-22 wheel / 1000 gr / 1000 cycles	(BS 8204 Part 2) (EN 13892-4)  (ASTM D 4060-01)
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<b>Indentation</b>	≈ 0%	(MIL - PFR 24613)
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<b>Impact Resistance</b>	Class A (Less than 1 mm indentation depth)  2 pounds / 45 inches (3 mm thick)	(BS 8204 Part 1)  (ASTM D 2794)
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### Resistance

<b>Chemical Resistance</b>	Resistant to many chemicals. Please ask for a detailed chemical resistance chart.	
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<b>Thermal Resistance</b>	The product is designed to withstand thermal shock caused by steam cleaning when thickness is 9 mm.	
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<b>Resistance to Thermal Shock</b>	Pass	(ASTM C 884)
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<b>Softening Point</b>	130°C (266°F)
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### System Information

<b>System Structure</b>	Use the products mentioned below as indicated in their respective Product Data Sheets.  Substrate Priming Systems  Substrate priming is normally not required under typical circumstances. (See Substrate Quality). When necessary use the systems indicated below.
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*System 1: moisture control on green concrete:*

- Primer:  
Sikafloor®-155 WN / Sikafloor®-80 Primer
- and Temporary Moisture barrier (TMB):  
Sikafloor®-81 EpoCem® or Sikafloor®-82 EpoCem®  
Layer thickness: from 2 to 3 mm or 3 to 7 mm respectively, and then apply System 3

*System 2: Inadequate substrate and moisture content between 4% and 6%*

- Primers:  
Sikafloor®-155 WN / Sikafloor®-80 Primer  
fully blinded with quartz sand 0.4 - 0.7 mm for the subsequent application of Sikafloor®-19 N / -20 N PurCem®.

*System 3: Inadequate substrate and moisture content below 4%*

- Primers:  
Sikafloor®-155 WN / Sikafloor®-80 Primer  
or Sikafloor®-156  
or Sikafloor®-157 for faster curing  
any of which must be fully blinded with quartz sand 0.4 - 0.7 mm for the subsequent application of Sikafloor®-19N / 20N PurCem®

On porous excessively absorbent substrates use Sikafloor®-155 WN / Sikafloor®-80 Primer, in two coats, the first thinned with 10% water.

*Heavy duty screed*

- Layer thickness:  
6 - 9 mm
- Screed:  
Sikafloor®-19 N PurCem® or Sikafloor®-20 N PurCem®

*Medium to heavy duty screed:*

- Layer thickness:  
4.5 - 6 mm (including scratch coat)
- Scratch coat:  
A scratch coat 1.5 mm thick will seal the surface and fill irregularities and improve appearance of the final layer.
- Standard screed:  
Sikafloor®-21 N PurCem® or
- High slip resistance screed:  
(Scratch coat typically not required)  
Sikafloor®-22 N PurCem® broadcast with quartz sand sealed with 1 - 2 coats of Sikafloor®-31 N PurCem® depending on the desired texture.  
(See build up Slip Resistance in Sikafloor®-22 N PurCem® PDS)

*Coving and detailing and vertical applications:*

- Primer:  
Sikafloor®-10 N PurCem® Primer or Sikafloor®-155 WN / Sikafloor®-80 Primer  
Reprime if no longer tacky.
- Coving Mortar:  
Sikafloor®-29 N PurCem®
- Seal coat:  
1 x Sikafloor®-31 N PurCem®

*Seal Coat:*

- Base coat:  
Sikafloor®-20 N or Sikafloor®-21 N or Sikafloor®-22 N or Sikafloor®-29 N PurCem®
- Seal Coat:  
1 x Sikafloor®-31 N PurCem®

Note: These system configurations must be fully complied with as described and may not be changed.

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## Application Details

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**Consumption / Dosage** *Primer (If priming is necessary, see System Structure above and respective PDS)*

*Screed 6 - 9 mm:*  
Sikafloor®-20 N PurCem® (part A+B+C) ~ 2.0 kg/m<sup>2</sup> / mm layer thickness.

This figure is theoretical and does not allow for any additional material due to surface porosity, surface profile, variations in level or wastage etc.

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**Substrate Quality**

The concrete substrate 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 oil, grease, coatings and surface treatments, etc.

If in doubt, apply a test area first.

Substrate priming is normally not required under typical circumstances. However due to variations in concrete quality, surface conditions, surface preparation and ambient conditions, reference test areas are recommended to determine whether priming is required to prevent the possibility of blisters, debonding pinholes and other aesthetic variations.

Sikafloor® PurCem® can be applied onto recent concrete over 7 days old or onto old damp concrete (up to 10%) without having to prime first, as long as the substrate fulfils the above requirements.

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**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 to achieve CSP 3-6 according to the International Concrete Repair Institute.

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 appropriate products from the Sikafloor®, Sikadur® and Sikagard® range of materials.

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 and/or vacuum.

Edge terminations.  
All free edges and working day joints of Sikafloor®-19N / 20N / 21N / 22N and 29N PurCem®, whether at the perimeter, along gutters or at drains require extra anchorage to distribute mechanical and thermal stresses. This is best achieved by forming or cutting grooves in the concrete. Grooves must have a depth and width of twice the thickness of the Sikafloor®- PurCem®. Refer to the edge details provided in the Method Statement. If necessary, protect all free edges with mechanically attached metal strips. Never featheredge, always turn into an anchor groove.

Expansion joints.  
Expansion joints must be provided in the substrates at the intersection of dissimilar materials. Isolate areas subject to thermal stresses, vibration movements or around load-bearing columns and at vessels sealing rings. Refer to the edge details provided in the Method Statement.

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## Application Conditions / Limitations

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**Substrate Temperature** +10°C min. / +30°C max.

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**Ambient Temperature** +10°C min. / +30°C max.

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**Substrate Moisture Content** ≤ 10% pbw  
Test method: Sika®-Tramex meter (<6%), CM - measurement or Oven-dry-method.

No rising moisture according to ASTM D 4263 (Polyethylene sheet test).

Always confirm substrate moisture content prior to the application.

Refer to System Structure and options for substrate priming.

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**Relative Air Humidity** 85% max.

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<b>Dew Point</b>	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>Application Instructions</b>									
<b>Mixing</b>	Part A : B : C = 1 : 0.86 : 7.76 (packaging size = 3.22 : 2.78 : 25) by weight								
<b>Mixing Time</b>	Material and ambient temperature will affect the mixing process. If necessary, condition the materials for best use to 15°C – 21°C.  Premix part A and B separately, make sure all pigment is uniformly distributed with a low speed electric stirrer. Start mixer and add parts A and then B and blend for 30 seconds.  Gradually add part C (aggregate) to the mixed resin parts over a period of 15 seconds. <b>DON'T DUMP!</b> Allow part C to blend for further 2 minutes minimum, to ensure complete mixing and a uniform moist mix is obtained. During the operations, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once (parts A+B+C) to ensure complete mixing. <b>Mix full units only.</b>								
<b>Mixing Tools</b>	Use a low speed electric stirrer (300-400 rpm) for mixing parts A and B. For preparation of the mortar mix use a pan type revolving mixer.								
<b>Application Method / Tools</b>	Prior to application, confirm substrate moisture content, r.h. and dew point.  If moisture content is > 10% pbw, Sikafloor® - EpoCem® can be applied as T.M.B. (temporary moisture barrier) system.  Pour the mixed Sikafloor®-20N PurCem® onto the substrate and spread evenly with a rake or screed box to the required thickness. Take care to spread newly mixed materials across the transition of previously applied mixes (wet edge), before the surface begins to set. Allow the mortar to stand for a few minutes to allow entrapped air to escape.  Finish the surface using a flat, round edge steel trowel.  A short pile roller can be used <i>once or twice</i> , and always in the same direction, to provide a more homogeneous finish to the surface. No excessive backrolling! Excessive backrolling or trowelling will bring up more resin to the surface, reducing the desired anti-lip surface texture which characterises this product.  As a second texture option, selected mineral aggregates can be broadcast on the wet surface and sealed with a top coat of 1 x Sikafloor®-31N PurCem® to lock in the aggregate. In this last case, allow a minimum of 36 hours cure period at 20°C before light traffic.  Flow check (ASTM C 230-90 / EN 1015-3)  Top internal diam: 70 mm Bottom internal diam.: 100 mm Height: 60 mm  Flow = 210 mm ± 10 mm								
<b>Cleaning of Tools</b>	Clean all tools and application equipment with Thinner C immediately after use. Hardened / cured material can only be mechanically removed.								
<b>Potlife</b>	<table border="1"> <thead> <tr> <th>Temperature</th> <th>Time</th> </tr> </thead> <tbody> <tr> <td>+10°C</td> <td>~ 35 - 40 minutes</td> </tr> <tr> <td>+20°C</td> <td>~ 18 - 22 minutes</td> </tr> <tr> <td>+30°C</td> <td>~ 10 - 15 minutes</td> </tr> </tbody> </table>	Temperature	Time	+10°C	~ 35 - 40 minutes	+20°C	~ 18 - 22 minutes	+30°C	~ 10 - 15 minutes
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**Waiting Time /  
Overcoating**

If you have primed, before applying Sikafloor®-20 N PurCem® on Sikafloor®-155 WN / Sikafloor®-80 Primer or Sikafloor®-156 or Sikafloor®-157 (all fully blinded), allow:

Substrate temperature	Waiting time	
	Minimum	Maximum
+10°C	24 hours	12 days
+20°C	12 hours	7 days
+30°C	6 hours	4 days

Always make sure primer is fully cured before application.

Before any subsequent application on Sikafloor®-20 N PurCem® allow:

Substrate temperature	Waiting time	
	Minimum	Maximum
+10°C	16 hours	72 hours
+20°C	8 hours	48 hours
+30°C	4 hours	24 hours

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

**Notes on Application /  
Limitations**

A retaining groove must be placed at exposed edges along of the application area (perimeter, joints, connections, plinths, columns, covings and drains / gullies) as indicated in the application details of the system data sheet, to prevent curling during curing. Width and depth must be twice the thickness of the floor finish.

Do not apply Sikafloor®-20N PurCem® on substrates where significant vapour pressure may occur.

Both Sikafloor®-20N PurCem® and Sika® Thinner C are flammable. NO NAKED FLAMES.

Always ensure good ventilation when using Sikafloor®-20 N PurCem® in a confined space.

Sikafloor®-20 N PurCem® shares the resin (part A) and hardener (part B) with Sikafloor®-21 PurCem®. Make sure the correct pack sizes of aggregate are used.

Freshly applied Sikafloor®-20 N PurCem® must be protected from damp, condensation and water for at least 24 hours.

Improved slip resistance can be obtained by broadcasting the surface with aggregate of suitable granulometry and back rolling with a short pile roller (1 - 2 passes only).

For the highest hygienic demands, a subsequent top coat of Sikafloor®-31 PurCem® may be required. This must be applied within 48 hours after the initial Sikafloor®-20 N PurCem® applications.

Always allow a minimum of 48 hours after product application prior to placing into service in contact with food stuffs.

**Curing Details****Applied Product ready  
for use**

Substrate temperature	Foot traffic	Light traffic	Full cure
+10°C	~ 24 hours	~ 36 hours	~ 7 days
+20°C	~ 12 hours	~ 18 hours	~ 5 days
+30°C	~ 8 hours	~ 15 hours	~ 3 - 4 days

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

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**Cleaning / Maintenance**

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**Methods**

To maintain the appearance of the floor after application, Sikafloor® -20N PurCem® must have all spillages removed immediately and must be regularly cleaned using rotary brushes, mechanical scrubbers, scrubber dryers, high pressure washers, wash and vacuum techniques, etc., using suitable detergents and waxes.

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**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.

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**Health and Safety Information**

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet 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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