

# PRODUCT DATA SHEET

## Sikafloor®-619

### Low viscosity epoxy impregnation

#### DESCRIPTION

Sikafloor®-619 is a two part very low viscosity, solvent containing epoxy impregnation material. When brushed or rolled over cured concrete, Sikafloor®-619 impregnates the concrete to provide a surface with increased hardness and resistance to moisture penetration.

#### USES

Sikafloor®-619 may only be used by experienced professionals.

Sikafloor®-619 can be used as a sealer and surface hardener for cementitious floors/surface in:

- Plant rooms
- Warehouse and workshop floors

#### CHARACTERISTICS / ADVANTAGES

- Easy to mix
- Low viscosity for deep penetration (viscosity close to that of water)
- Fast application
- Reduces dusting and thus, easier cleaning of slabs
- Increased resistance to abrasion and mild chemicals
- Enhanced resistance to oils, gasoline, kerosene and staining from spillage.
- Increased impermeability of concrete and reduces rate of penetration of waterborne contaminants such as chlorides
- Sikafloor®-619 is not a coating, therefore it will not peel or flake off

#### PRODUCT INFORMATION

<b>Chemical Base</b>	Epoxy		
<b>Packaging</b>	Part A	10 L	
	Part B	10 L	
	Part A + Part B	20 L set	
<b>Shelf Life</b>	24 months from the date of production if stored properly in original, unopened and undamaged sealed packaging		
<b>Storage Conditions</b>	Store properly in dry conditions at temperatures between between +5 °C and +30 °C. Keep away from direct sunlight.		
<b>Density</b>	Part A + B	0.94–0.96 kg/l (at +28 °C)	(ASTM D 1475)
<b>Viscosity</b>	Part A + B	40–90 cps (at +28 °C)	(ASTM D 2196)

#### TECHNICAL INFORMATION

<b>Tensile Adhesion Strength</b>	> 1.5 N/mm <sup>2</sup> (failure at concrete)	(ASTM C 1583)
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## APPLICATION INFORMATION

<b>Mixing Ratio</b>	Part A : Part B = 1 : 1 (by volume)			
<b>Consumption</b>	Porous concrete	min. 3 coats	~0.2 Litre/m <sup>2</sup> /coat	
	Normal concrete and dense concrete	min. 2 coats	~0.2 Litre/m <sup>2</sup> /coat	
<b>Relative Air Humidity</b>	80 % max.			
<b>Dew Point</b>	Beware of condensation! The substrate must be at least 3 °C above the dew point to reduce the risk of condensation.			
<b>Pot Life</b>	~60 minutes (at +28 °C) At higher temperature the pot life is reduced.			
<b>Waiting Time / Overcoating</b>	<b>Temperature</b>	<b>Minimum</b>	<b>Maximum</b>	
	+16 °C	10 hours	36 hours	
	+24 °C	6 hours	24 hours	
	+32 °C	4 hours	18 hours	
<b>Applied Product Ready for Use</b>	At +25 °C:			
	<b>Tack free</b>	<b>Foot traffic</b>	<b>Light traffic</b>	<b>Full cure</b>
	2–6 hours	24 hours	3 days	5–7 days

## 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.

## 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.

## LIMITATIONS

- Do not thin Sikafloor®-619
- Application at temperatures below +5 °C is not recommended
- Sikafloor®-619 is flammable and contains volatile solvents. It is essential that during application, the area is well ventilated to prevent the build-up of solvent fumes. The use of ventilation fans is highly recommended.
- In closed areas, the use of ventilation fans is mandatory.
- Paintwork and plastic fittings should be protected
- Finished surface is slightly glossy
- Relative Humidity at time of application must not exceed 80 %
- Deteriorating, disintegrating or poor concrete surface cannot be made good with this application alone
- Flash point of Sikafloor®-619 is between +25 °C to +28 °C

## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY / PRE-TREATMENT

The concrete substrate must be sound and of sufficient compressive strength (min. 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, oils, grease, coatings, surface treatments, etc. All dust, loose and friable material must be completely removed from all surfaces before application of Sikafloor®-619, preferably by vacuum. Concrete substrates must be prepared mechanically using abrasive blast cleaning or grinding to remove cement laitance and achieve an open textured surface. High spots must be grinded down.

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 can be carried out using appropriate products from Sikafloor®, Sikadur® and Sikagard® range of materials.

If in doubt, apply a test area first.

### MIXING

Pour Part B into the Part A container and mix both liquid thoroughly for one minute using a mixing paddle attached to an electric stirrer (< 500 rpm), until a fully homogeneous mix has been achieved. Decant the whole mix into another container and mix for another 30 seconds. Sikafloor®-619 is now ready to be applied.

## APPLICATION

### Horizontal Surface

Pour and spread Sikafloor®-619 evenly onto the prepared substrate by means of a squeegee and then backroll (cross-wise) using a short-piled roller. Avoid the formation of puddles. Apply as much material as the surface will absorb without leaving any excess material on the surface. The correct application rate will depend very much on the porosity of the concrete and should be determined on a small test area prior to large scale application.

The second coat shall be applied in the same way. For the waiting time between coats please refer to the overcoating table. A third coat may be necessary to give the required in-surface seal on porous substrates but on typical good quality dense concrete, two coats will normally be adequate.

It is important that the area is well ventilated to allow sufficient evaporation of the solvent, particularly at low application temperatures.

### Vertical Surface

Sikafloor®-619 can be applied using a brush or roller.

## CLEANING OF TOOLS

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

## MAINTENANCE

### CLEANING

Clean regularly using a single or double headed rotary scubber drier with alkaline detergent.

## 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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November 2020, Version 02.01

020811020010000025