

PRODUCT DATA SHEET

Sikafloor®-324 TH

Tough-elastic, a two-component polyurethane floor coating

DESCRIPTION

Sikafloor®-324 TH is a 2-part polyurethane, coloured, tough-elastic crack bridging resin based floor coating. It provides a hard-wearing, seamless, chemical resistant, low maintenance, gloss finish

USES

Sikafloor®-324 TH may only be used by experienced professionals.
Sikafloor®-324 TH is used as a self-smoothing and slip resistant wearing layer on concrete and cementitious screed substrates

FEATURES

- Flexible and tough elastic
- Good mechanical resistance
- Optional surface profiles slip resistant or smooth
- Easy to apply
- Easy to clean and low maintenance
- Low sensitivity to moisture during application

PRODUCT INFORMATION

Composition	Solvent-free polyurethane
Packaging	Container Part A 7.30 kg Container Part B 2.70 kg Container Part A + Part B 10 kg ready to mix units
Appearance and colour	Part A Colored, liquid Part B Brown Cured appearance Gloss finish
Shelf life	12 months from date of production
Storage conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to the packaging and the current Safety Data Sheet for information on safe handling and storage.
Density	Part A 1.1-1.3 kg/l Part B 1.2-1.3 kg/l Mixed Product 1.2 kg/l (unfilled) and 1.6 kg/l (filled 1:0.5 with quartz sand 0.1-0.3 mm)
Solid content	100 %

TECHNICAL INFORMATION

Shore D Hardness	Cured 7 days at +23 °C	55	(ASTM D2240-05)
Abrasion resistance	Cured 7 days at +23 °C	30 mg (H22 /1000 cycles)	(ASTM D4060)
Tensile strength	13.5 N/mm ²		(ASTM D2370)
Tensile adhesion strength	1.5 N/mm ² (failure in concrete)		(ASTM C4541)
Elongation at break	Tested at +23 °C	60%	(ASTM D2370)

APPLICATION INFORMATION

Mixing ratio	Part A : Part B (by weight)	73:21								
Consumption	Filled Unfilled	1.8 kg/m ² per mm thickness ~0.5 kg/m ² (~0.5 mm thickness)								
Ambient air temperature	Maximum Minimum	+30 °C +10 °C								
Relative air humidity	Maximum	75-80 % r.h.								
Dew point	Beware of condensation. The substrate and uncured applied product must be at least +3 °C above dew point to reduce the risk of condensation on the surface of the applied product.									
Substrate temperature	Maximum Minimum	+30 °C +10 °C								
Substrate moisture content	Refer to the individual primer Product Data Sheet.									
Pot Life	+10 °C +20 °C +30 °C	40 minutes 30 minutes 20 minutes								
Waiting time to overcoating	Before overcoating Sikafloor®-324 TH, allow: <table><tr><th>Temperature</th><th>Minimum</th><th>Maximum</th></tr><tr><td>+30 °C</td><td>6 hours</td><td>24 hours</td></tr></table> Note: Times are approximate and will be affected by changing ambient conditions, particularly temperature and relative humidity.		Temperature	Minimum	Maximum	+30 °C	6 hours	24 hours		
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Applied product ready for use	<table><tr><th>Temperature</th><th>Foot traffic</th><th>Light traffic</th><th>Full cure</th></tr><tr><td>+30 °C</td><td>~16 hours</td><td>~24 hours</td><td>~5 days</td></tr></table> Note: Times are approximate and will be affected by changing ambient conditions, particularly temperature and relative humidity.	Temperature	Foot traffic	Light traffic	Full cure	+30 °C	~16 hours	~24 hours	~5 days	
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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 DOCUMENTATION

Refer to the following method statements:

- Sika Method Statement — Evaluation and preparation of surfaces for flooring systems
- Sika Method Statement — Sikafloor® mixing and application

APPLICATION INSTRUCTIONS

EQUIPMENT

MIXING EQUIPMENT

- Electric double-paddle mixer (> 700 W, 300 rpm to 400 rpm)

APPLICATION EQUIPMENT

- Pin leveller
- Trowels, including serrated
- Spiked roller

SUBSTRATE QUALITY

IMPORTANT

Reduced service life due to incorrect treatment of cracks

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

1. For static cracks, ensure the width is suitable for overcoating with Sikafloor®-324 TH.
2. For dynamic cracks, ensure the movement is within the movement capacity of Sikafloor®-324 TH.

TREATMENT OF JOINTS AND CRACKS

Construction joints and existing static surface cracks in substrate require pre-treating before full layer application.

Use Sikadur® or Sikafloor® resins.

SUBSTRATE CONDITION

- Cementitious substrates must be structurally sound and of sufficient compressive strength (minimum 25 N/mm²) with a minimum tensile strength of 1.5 N/mm²
- Substrates must be clean, dry and free of contaminants such as dirt, oil, grease, coatings, laitance, surface treatments and loose friable material.

Maximum slope gradient

Note: Do not apply on substrates with a slope > 1 % gradient.

SUBSTRATE PREPARATION

MECHANICAL SUBSTRATE PREPARATION IMPORTANT

Surface defects due to voids in the substrate

Voids and blow holes in the substrate will weaken the surface and damage the covering Product if not repaired during the preparation process.

1. Fully expose blow holes and voids during surface preparation to identify the required repairs.
2. Remove weak cementitious substrates.
3. Prepare cementitious substrates mechanically using abrasive blast cleaning, abrasive planing or scarifying equipment to remove cement laitance.
4. Before applying thin layer resins, remove high spots by grinding.
5. Before applying the Product, remove all dust, loose and friable material from the application surface with an industrial vacuuming equipment.
6. Level the surface or fill cracks, blow holes and voids with products from the Sikafloor®, Sikadur® and Sikagard® range of materials.

For additional information on products for leveling and repairing defects, contact Sika® Technical Services.

SUBSTRATE PREPARATION OF NON-CEMENTITIOUS SUBSTRATES

For information on substrate preparation of non-cementitious substrates, contact Sika® Technical Services.

MIXING

1. Mix part A until a uniform colour and mix has been achieved.
2. Add Part B (hardener) to Part A.
3. **IMPORTANT** Do not mix excessively. Mix Part A + B continuously for ~2 minutes until a uniformly coloured mix is achieved.
4. Add the quartz sand and mix for a further 2 minutes until a uniform mix has been achieved.
5. To ensure thorough mixing, pour materials into another container and mix again to achieve a smooth and uniform mix.
6. During the final mixing stage, scrape down the sides and bottom of the mixing container with a flat or straight edge trowel at least once to ensure complete mixing.
7. Leave the Product to stand for 3 minutes before application.

Note: adding quartz sand is optional depending on the

selected system (filled or unfilled)

APPLICATION

IMPORTANT

Strictly follow installation procedures

Strictly follow installation procedures as defined in Method Statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

IMPORTANT

Protect from moisture

After application, protect the Product from damp, condensation and direct water contact for at least 24 hours.

IMPORTANT

Foaming due to water contact of uncured material

Uncured material reacts with water of any kind, which leads to foaming.

1. During the application, wear head and wrist bands to avoid sweat falling onto the uncured material.

IMPORTANT

No application on rising moisture

Do not apply on substrates with rising moisture.

IMPORTANT

Damaged finish due to heating with fossil fuel heaters

Fossil fuel heaters powered by gas, oil or paraffin produce large quantities of both carbon dioxide and water vapour, which may adversely affect the finish.

1. For temporary heating, use only electrically powered warm air blower systems. Do not use gas, oil, paraffin or other fossil fuel heaters.

IMPORTANT

Indentations in resin due to high temperature combined with high point loading

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

Exact colour matching

Note: For exact colour matching, ensure the Product in each area is applied from the same control batch number.

Degradation of the Product due to UV exposure

Note: In smooth applications with sun light exposure use Sikafloor®-3570 or Sikafloor®-305 W as seal coat.

SELF-SMOOTHING WEARING LAYER

1. Pour the mixed Product onto the substrate. For the consumption, refer to Application Information.
2. Apply the Product evenly over the surface with a serrated trowel.
3. To achieve a smooth finish, smooth the surface with the flat side of a trowel.
4. Back roll the surface in two directions at right angles with a steel spike roller.

SLIP-RESISTANT BROADCAST LAYER

1. Pour the mixed Product onto the prepared substrate.
2. Apply the Product evenly over the surface with a trowel.
3. Back-roll the surface in two directions at right angles with a spike roller.
4. Allow the product to cure for 15 minutes. Note: Times are temperature dependant. Times given are for +20 °C.
5. Broadcast the surface with quartz sand or silicon carbide, lightly at first, then to excess. Note: The aggregate is dependant on the system build-up. Refer

- to the relevant System Data Sheet.
6. Allow the surface to become tack-free.
 7. Remove all loose sand with industrial vacuuming equipment.

CLEANING OF EQUIPMENT

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

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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Product Data Sheet

Sikafloor®-324 TH
July 2026, Version 01.01
020812040020264269

Sikafloor-324TH-en-TH-(07-2026)-1-1.pdf