

Sikafloor®-381 AS

2-part epoxy coating, chemically highly resistant
and electrostatically conductive

Product Description

Sikafloor®-381 AS is a two part, electrostatically conductive self-smoothing, coloured epoxy resin with very high chemical resistance.

Uses

- Chemically highly resistant coating for concrete and screed surfaces in bund areas for the protection against water contaminating liquids (according to resistance table)
- Electrostatically conductive wearing layer for areas subject to chemical and mechanical exposure in production and storage facilities

Characteristics / Advantages

- Very high chemical resistance
- High mechanical resistance
- Impervious to liquids
- Abrasion resistant
- Electrostatically conductive
- Slip resistant surface possible

Test

Approval / Standards

Conforms to the requirements of DIN IEC 61340-4-1 (Internal Test)

Product Data

Form

Appearance / Colours

Resin - part A: coloured, liquid
Hardener - part B: transparent, liquid

Almost unlimited choice of colour shades.

Due to the nature of the carbon fibers providing the conductivity, it is not possible to achieve exact colour matching. With very bright colours (such as yellow and orange), this effect is increased. Under direct sun radiation there may be some discolouration and colour deviation, this has no influence on the function and performance of the coating.

Packaging

Part A: 21.25 kg containers
Part B: 3.75 kg containers
Part A+B: 25 kg ready to mix units

Bulk packaging:
Part A: 250 kg drums
Part B: 190 kg drums



Storage

Storage Conditions / Shelf-Life 24 months from date of production if stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5°C and +30°C.

Technical Data

Chemical Base Epoxy

Density Part A: ~ 1.77 kg/l (DIN EN ISO 2811-1)
Part B: ~ 1.04 kg/l
Mixed resin: ~ 1.6 kg/l
All Density values at +23°C.

Solid Content ~ 100% (by volume) / ~100% (by weight)

Electrostatic Behaviour Resistance to earth $R_E < 10^6 \Omega$ (IEC 61340-4-1; EN 1081)

Mechanical / Physical Properties

Compressive Strength > 80 N/mm² (14 days / +23°C) (EN 196-1)

Flexural Strength > 55 N/mm² (14 days / +23°C) (EN 196-1)

Bond Strength > 1.5 N/mm² (failure in concrete) (ISO 4624)

Shore D Hardness 82 (7 days / +23°C) (DIN 53 505)

Abrasion Resistance 40 mg (CS 10 wheel / 1000 g / 1000 cycles) (8 days / +23°C) (DIN 53 109) (Taber Abrader Test)

Resistance

Chemical Resistance Resistant to many chemicals. Please ask for a detailed chemical resistance table.

Thermal Resistance

Exposure*	Dry heat
Permanent	+50°C
Short-term max. 7 d	+80°C
Short-term max. 12 h	+100°C

Short-term moist/wet heat* up to +80°C where exposure is only occasional (i.e. during steam cleaning etc.)

*No simultaneous chemical and mechanical exposure.

System Information

System Structure

Self-smoothing system (horizontal areas):

Primer:	1 x Sikafloor®-156
Earthing connection:	Sikafloor® Earthing Kit
Conductive coat:	1 x Sikafloor®-220 W Conductive
Conductive wearing course:	1 x Sikafloor®-381 AS filled with quartz sand

Smooth wearing course (vertical areas):

Primer:	1 x Sikafloor®-156
Wearing course:	1 x Sikafloor®-381 AS + Extender T
Earthing connection:	Sikafloor® Earthing Kit
Conductive coat:	1 x Sikafloor®-220 W Conductive
Conductive wearing course:	1 x Sikafloor®-381 AS + Extender T

Broadcast system with slip resistance:

Primer:	1 x Sikafloor®-156
Earthing connection:	Sika® Earthing Kit
Conductive coat:	1 x Sikafloor®-220 W Conductive
Conductive wearing course:	1 x Sikafloor®-381 AS broadcast to excess with silicon carbide 0.5 - 1.0 mm
Seal coat:	1 x Sikafloor®-381 AS + 5 wt.-% Thinner C

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

Application Details

Consumption / Dosage

Coating System	Product	Consumption
Primer	Sikafloor®-156	0.3 - 0.5 kg/m ²
Levelling (optional)	Sikafloor®-156 mortar	Refer to PDS of Sikafloor®-156
Conductive coat	Sikafloor®-220 W Conductive	0.08 - 0.10 kg/m ²
Wearing course horizontal areas (Film thickness ~ 1.5 mm)	Sikafloor®-381 AS filled with quartz sand 0.1 - 0.3	2.5 kg/m ² Binder + quartz sand 10 - 15°C: without filling 15 - 20°C: 1 : 0.1 pbw (2.3 + 0.2 kg/m ²) 20 - 30°C: 1 : 0.2 pbw (2.1 + 0.4 kg/m ²)
Wearing course vertical areas (Film thickness ~ 1.5 mm)	Sikafloor®-381 AS + 2.5 - 4 wt.-% Extender T	2 x 1.25 kg/m ²
Broadcast system with slip resistance (Film thickness ~ 2.5 mm)	Sikafloor®-381 AS, broadcast to excess with silicon carbide 0.5 - 1.0 mm	1.6 kg/m ² Binder without filling
		Silicon Carbide 0.5 - 1.0 mm (5 - 6 kg/m ²)
Seal coat (on broadcast areas only)	Sikafloor®-381 AS + 5 wt.-% Thinner C	0.75 - 0.85 kg/m ²

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

Substrate Quality

The concrete substrate must be sound and of sufficient compressive strength (minimum 25 N/mm²) with a minimum pull off strength of 1.5 N/mm².

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	<p>Concrete substrates must be prepared mechanically using abrasive blast cleaning or scarifying equipment to remove cement laitance and achieve an open textured surface.</p> <p>Weak concrete must be removed and surface defects such as blowholes and voids must be fully exposed.</p> <p>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.</p> <p>The concrete or screed substrate has to be primed or levelled in order to achieve an even surface.</p> <p>High spots must be removed by e.g. grinding.</p> <p>All dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush and/or vacuum.</p>
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Application Conditions / Limitations

Substrate Temperature	+10°C min. / +30°C max.
Ambient Temperature	+10°C min. / +30°C max.
Substrate Moisture Content	<p>≤ 4% pbw moisture content.</p> <p>Test method: Sika[®]-Tramex meter, CM - measurement or Oven-dry-method.</p> <p>No rising moisture according to ASTM (Polyethylene-sheet).</p>
Relative Air Humidity	80% r.h. max.
Dew Point	<p>Beware of condensation!</p> <p>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.</p>

Application Instructions

Mixing	Part A : part B = 85 : 15 (by weight)
Mixing Time	<p>Prior to mixing, stir part A mechanically. When all of part B has been added to part A, mix continuously for 2 minutes until a uniform mix has been achieved.</p> <p>When parts A and B have been mixed, add the quartz sand 0.1 - 0.3 mm and mix for a further 2 minutes until a uniform mix has been achieved.</p> <p>To ensure thorough mixing pour materials into another container and mix again to achieve a consistent mix.</p> <p>Over mixing must be avoided to minimise air entrainment.</p>
Mixing Tools	Sikafloor [®] -381 AS must be thoroughly mixed using a low speed electric stirrer (300 - 400 rpm) or other suitable equipment.

Application Method / Tools

Prior to application, confirm substrate moisture content, relative humidity and dew point.

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

Levelling:

Rough surfaces need to be levelled first because varying thickness of the Sikafloor®-381 AS wearing course will influence the conductivity. Therefore use Sikafloor®-156 levelling mortar (see PDS).

Placing of earthing plates:

See below "Notes on Application / Limits".

Application of Sikafloor® conductive coat:

See PDS of Sikafloor®-220 W conductive.

Wearing course (horizontal areas):

Sikafloor®-381 AS is poured, spread evenly by means of a serrated trowel. Roll immediately in two directions with a spiked roller to ensure even thickness.

Wearing course (vertical areas):

The first layer of Sikafloor®-381 AS, mixed with 2.5 - 4 wt.-% Extender T, has to be applied by trowel. After placing of the earthing plates and application of the conductivity layer, apply the second layer of Sikafloor®-381 AS, mixed with 2.5 - 4 wt.-% Extender T, by trowel.

Wearing course with slip resistance:

Sikafloor®-381 AS is poured, spread evenly by means of a serrated trowel and the fresh layer is broadcasted to excess with silicon carbide 0.5 - 1.0 mm. After final drying the surplus silicon carbide must be swept off and the surface must be vacuumed. The seal coat (Sikafloor®-381 AS + 5 wt.-% Thinner C) has to be applied evenly by short-piled roller or squeegee.

Cleaning of Tools

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

Potlife

Temperatures	Time
+10°C	~ 60 minutes
+20°C	~ 30 minutes
+30°C	~ 15 minutes

Waiting Time / Overcoating

Before applying Sikafloor®-220 W Conductive on Sikafloor®-381 AS allow:

Substrate temperature	Minimum	Maximum
+10°C	48 hours	3 days
+20°C	24 hours	2 day
+30°C	12 hours	1 day

Before applying Sikafloor®-381 AS on Sikafloor®-156 allow:

Substrate temperature	Minimum	Maximum
+10°C	24 hours	4 days
+20°C	12 hours	2 days
+30°C	6 hours	1 day

Before applying Sikafloor®-381 AS on Sikafloor®-220 W Conductive allow:

Substrate temperature	Minimum	Maximum
+10°C	24 hours	7 days
+20°C	15 hours	5 days
+30°C	10 hours	4 days

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

Notes on Application / Limitations

This product may only be used by experienced professionals.

Do not apply Sikafloor®-381 AS on substrates with rising moisture.

Do not blind the primer.

Freshly applied Sikafloor®-381 AS must be protected from damp, condensation and water for at least 24 hours.

Avoid puddles on the surface with the primer.

Only start application of Sikafloor® conductive coat after the priming coat has dried tack-free all over. Otherwise there is a risk of wrinkling or impairing of the conductive properties.

Tools

Recommended supplier of tools:

PPW-Polyplan-Werkzeuge GmbH, Phone: +49 40/5597260, www.polyplan.com

Serrated trowel for smooth wearing layer:

e.g. Large-Surface Scrapper No. 565, Toothed blades No. 25

Layer thickness of wearing course: approx. 1.5 mm. Excessive thickness (more than 2.5 kg/m²) causes reduced conductivity.

Before the application of a conductive flooring system, a reference area has to be applied. This reference area must be assessed and accepted from the contractor/client. The desired result and method of conductivity measurement must be stated in the Specification and Method Statement. The number of conductivity measurements is strongly recommended to be as shown in the table below:

Applied floor area	Number of measurements
< 10 m ²	1 measurement / m ²
10 - 100 m ²	10 - 20 measurements
> 100 m ²	10 measurements / 100m ²

The measuring points must have a distance of at least 50 cm to the next measuring point. In case of a measurement lower/higher than required, an additional measurement has to be carried out within 50 cm of the point with the insufficient result.

If several measuring points (R_E) of the final floor are $> 1 \cdot 10^6 \Omega$ (in case of electrostatically conductive floorings (ECF)), but the walking test ($< 100 V$, IEC 61340-4-5, IEC 61340-5-1, ESD STM 07.2-1999) and/or the system test ($< 35 M \Omega$, IEC 61340-5-1) results are within the requirements, the total area is acceptable.

Placing of earthing plates:

If the Sikafloor® Earthing Kit conductor system (system of anchored brass-plates with stable earth connection) is applied, the instructions for use have to be followed exactly. Every earthing point is able to conduct 100 m². Ensure the longest distance of each point in the area is max. 10 m to the next earthing point. Clean the earthing spots carefully. For longer distances, additional earthing plates have to be placed. If site conditions do not allow placing of additional earthing points, longer distances ($> 10 m$) have to be bridged with copper tapes. The earthing spots have to be connected to the ring-mains. This work must be executed and approved by an electrical engineer and in accordance with any relevant regulations.

Numbers of earth connections:

Per room at least 2 earthing points. The optimum number of earth connections depends on the local conditions and should be specified with documents.

The incorrect assessment and treatment of cracks may lead to a reduced service life and reflective cracking - reducing or breaking conductivity.

For exact colour matching, ensure Sikafloor®-381 AS in each area is applied from the same control batch numbers.

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 CO₂ and H₂O water vapour, which may adversely affect the finish. For heating use only electric powered warm air blower systems.

Curing Details

Applied Product ready for use

Temperature	Foot traffic	Light traffic	Full cure
+10°C	~ 24 hours	~ 3 days	~ 10 days
+20°C	~ 18 hours	~ 2 days	~ 7 days
+30°C	~ 12 hours	~ 1 day	~ 5 days

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

Cleaning / Maintenance

Methods

To maintain the appearance of the floor after application, Sikafloor®-381 AS must have all spillages removed immediately and must be regularly cleaned using rotary brush, mechanical scrubbers, scrubber dryer, high pressure washer, wash and vacuum techniques etc using suitable detergents and waxes

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.

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.

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.

