

Sikafloor® 203

Medium Build Clear Epoxy Binder/Coating

Description	A two component, high solids, epoxy coating for medium to heavy mill thickness applications. Can be used as clear or with Epoxy Color Additive to achieve a variety of colors.
Where to Use	Designed for one coat application from 12 to 20 mils to concrete floors subjected to abrasion and/or chemical spills, where ease of cleaning, cosmetics and smoothness are a major consideration.
Advantages	<ul style="list-style-type: none"> ■ High Solids / Low Odor ■ Medium to High Build in one coat application ■ High gloss and good clarity/color retention ■ Excellent chemical and abrasion resistance ■ Wide range of colors with Sikafloor Epoxy Color Additive ■ Meets USDA requirements for incidental food contact
How to Use	
Surface Preparation	Surface must be clean, sound and dry. Remove dust, laitance, grease, curing compounds, bond inhibiting impregnations, waxes and any other contaminants. All projections, rough spots, etc should be dressed off to achieve a level surface prior to the application. Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by shot blasting or equivalent mechanical means (CSP-3 as per ICRI guidelines). Sweep and vacuum any remaining dirt and dust with a wet/dry vacuum. Removing residual dust will help ensure a tenacious bond between the primer and substrate. Whenever "shot-blasting" is utilized, be careful to leave concrete with a uniform texture. Over "blasting" will result in reduced coverage rates of the primer and/or subsequent topcoats. It is also possible that the texture of the "shot-blast" pattern may show through the last coat. This is known as "tracking". The compressive strength of the concrete substrate should be at least 3500 psi (24 MPa) at 28 days and at least 250 psi (1.7 MPa) in tension at the time of application of Sikafloor 203. For application to a newly installed epoxy flooring, make sure the surface has cured sufficiently and is 60°F or higher.
Priming	Sikafloor 107 Low Modulus, Low Viscosity Epoxy Primer should be applied at 160-320 sq. ft. (14.9 - 29.7 m ²) per gallon, over damp or dry concrete. Rough concrete surfaces will result in reduced coverage. Allow to cure (varies with temperature and humidity) until tack free and clear in appearance before applying subsequent coats.

Typical Data

Colors	Clear and other colors available with use of Epoxy Color Additive	
Coverage	Approximately 80-130 sq. ft. (7.4 - 12 m ²) at 12 to 20 mils w.f.t per gallon or 240-390 (22 - 36 m ²) sq. ft. per 3 gallon unit over primed, relatively smooth, dense concrete surfaces. Actual coverage will vary depending on the texture and porosity of the substrate.	
Recommended Film Thickness	20-12 mils/coat at 80-130 sq. ft. (22 - 36 m ²) per gallon:	
Pot Life @ 75°F (24° C)	30 minutes and 50% R.H. High temperature and high humidity will accelerate curing and reduce pot life.	
Cure Rate @ 75°F (24° C)	12 hrs.- Foot traffic 24 hrs - Light traffic 72 hrs.- Heavy traffic and/or chemical spillage	
Recoat Time @ 75°F (24° C)	From 12 to 24 hours. After 24 hours, screen before recoating.	
Shelf-Life	2 years in unopened container	
Typical Physical Properties:		
Hardness (Shore D)	ASTM D-2240	81-85
Bond Strength	ASTM D 4541	>400 psi (2.76 MPa)(100% concrete failure)
Tensile Strength	ASTM D 638	8100 psi (55.8 MPa)
Compressive Strength	ASTM D 695	11,700 psi (80.7 MPa)
Impact Resistance	ASTM D-2794	160 in-lbs. (18.1 N-m)
Abrasion Resistance	ASTM D-4060	30-40 mg loss
<i>(CS-17 wheel, 1000 cycles, 1000 gm load)</i>	Taber Abraser	
Flammability	ASTM D-635	Film is Self Extinguishing
Slip Resistance	Equivalent to ASTM D-2047	Passes
Above typical values based on cure @ 75°F (24 C)		
VOC (g/l)	ASTM D2369-07	26.7 g/l



Packaging: Sikafloor 203 is packaged in pre-proportioned 3 gallon kits for easy jobsite mixing as well as in 15 gallon and 165 gallon bulk kits. Each 3 gallon kit consists of one gallon of Part "H" Hardener in a one gallon can packed in a corrugated carton (two per carton) and two gallons of Part "R" Resin in a 5 gallon pail short filled to serve as the mixing vessel. Must order in multiples of two kits (6 gallons total), one carton containing two Part "H"s and two short filled pails of Part "R". A 15 gallon bulk kit consists of two full 5 gallon pails of Part "R" Resin and one full 5 gallon pail of Part "H" Hardener. A 165 gallon bulk kit consists of two full 55 gallon drums of Part "R" Resin and one full 55 gallon pail of Part "H" Hardener.

Product Shelf Life: 2 years in original unopened container under proper storage conditions. Store dry between 40° - 90°F (5° - 32°C).

Mixing	<p>For bulk packaging when not mixing full units each component must be pre-mixed separately to ensure product uniformity.</p> <p>It is important to remember that this coating has a limited pot life. Therefore it is recommended to check and make sure everything is in order before starting the mixing sequence.</p> <p>Color Additives: If color is desired, the appropriate Sikafloor Epoxy Color Additive is added to the "Color Base" Part "R" Resin at the rate of 1 quart per 3 mixed gallons for all colors except for white, yellow or bright red. These will require 2 quarts per batch. <i>Refer to the Epoxy Color Add Data Sheet for specific ratios. Mix at low speed for a minimum of two minutes.</i></p> <ol style="list-style-type: none"> Carefully empty the contents of the Part "H" Hardener entirely into the can of Part "R" Resin. The Part "R" container is oversized to allow for easy mixing (3 gallon kit only). For 15 and 165 gallon kits, add two parts Resin (Part R) and one part Hardener (Part H) by volume to a clean mixing container. Do not count Epoxy Color Additive in the volume ratio. Mix with a very low speed jiffy mixer, until completely blended. This will take about 2 to 3 minutes. Be careful not to introduce any air bubbles while mixing. Make sure the contents are completely mixed to avoid any weak or partially cured spots in coating. During the mixing operations, scrape down the sides and bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing. Mix only that quantity that can be used within its pot life.
Application	<ol style="list-style-type: none"> This product should be applied by first pouring a bead of material in the form of a ribbon on the surface to be coated. The material should not be left in the container as it will set faster thus reducing the pot life. Using a flat or notched squeegee, spread the poured material at a rate of approximately 80-130 sq. ft. (7.4 - 12 m²) per gallon. Apply as evenly as possible, working from left to right, and then back. Back roll using a high quality 3/8" nap roller. Roll with a porcupine or plastic loop roller after 10 minutes to remove excess bubbles.
Critical Recoat Time	<p>It is important to apply subsequent coats of this and other products within 12 to 24 hours (under normal curing conditions). If Sikafloor 203 is allowed to cure longer than the 24 hours before subsequent recoats, screening will be necessary. The floor surface should be screened to the effect that a uniform dullness is achieved. There should be no gloss present on the floor before applying the next coat.</p>
Limitations	<ul style="list-style-type: none"> ■ Minimum/Maximum substrate temperature: 60°F/85°F (15.5°C/30°C). ■ Maximum relative humidity: 85%. ■ Substrate temperature must be at least 5°F (3°C) above measured dew point. ■ Conduct quantitative anhydrous calcium chloride testing in accordance with ASTM-F1869. Maximum acceptable test result is 3 pounds per 1,000 ft² per 24 hours. Determine the surface moisture content by using an impedance moisture meter designed for use on concrete as detailed in ASTM E-1907. Acceptable test results shall be 4% by mass or less. If over, use Sikafloor EpoCem 81/82 or Sikafloor Vapor Block. ■ Do not use on exterior, on-grade substrates. ■ Freshly applied Sikafloor 203 should be protected from dampness, condensation and water for at least 24 hrs. ■ Do not thin this product. Addition of thinners will slow the cure and reduce the ultimate properties of this product. Critical recoat times will also be affected. ■ This product is not designed for exterior use, immersion, or any use where moisture can reach the underside of the resurfacer. ■ Will discolor over time when exposed to sunlight (UV) and under certain artificial lighting conditions. UV resistant, light stable topcoats are available where ultimate color/clarity retention is required.

Industrial Flooring

Caution	<p>COMPONENT R: WARNING - IRRITANT, SENSITIZER: Contains epoxy resins, Nonyl Phenol (CAS 25154-52-3). Eye irritant. May cause skin/respiratory irritation. Prolonged and/or repeated contact with skin may cause allergic reaction/sensitization. Deliberate concentration of vapors for purposes of inhalation is harmful and can be fatal. Harmful if swallowed. Strictly follow all use, handling and storage instructions.</p> <p>COMPONENT H: WARNING: CORROSIVE, SENSITIZER, IRRITANT. Contains amines (mixture). Contact with skin and eyes causes severe burns. Respiratory irritant. May cause eye/skin irritation. Possible skin sensitization/allergic reaction with prolonged or repeated exposure. Harmful if swallowed. Deliberate concentration of vapors for purposes of inhalation is harmful and can be fatal. Strictly follow all handling, use and storage instructions.</p>	
First Aid	<p>Eyes – Hold eyelids apart and flush thoroughly with water for 15 minutes. Skin – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. Inhalation – Remove to fresh air. Ingestion – Do not induce vomiting. Dilute with water. Contact physician. In all cases contact a physician immediately if symptoms persist.</p>	
Handling and Storage	<p>Wear protective equipment (gloves/safety glasses/clothing) to prevent contact with skin and eyes. Keep container closed in a cool dry place. Wash skin thoroughly with soap and water after use. Use with adequate, general and local, exhaust ventilation. In absence of adequate ventilation, use a properly fitted NIOSH respirator. Remove contaminated clothing. Launder before reuse.</p>	
Clean Up	<p>Avoid direct contact with eyes and skin. Wearing chemical resistant goggles/gloves/clothing, collect spill. Ventilate area. In absence of adequate ventilation, use properly fitted NIOSH respirator. Sweep up spill and place in closed container. Dispose of in accordance with applicable local, state and federal environmental regulations.</p>	
Additional Info	<p>Technical Data Sheets are updated periodically. To ensure the most current version is being used, visit Technical Resources on www.sikafloorusa.com. Proper material application is the responsibility of the user. Site visits made by Sika personnel are for making technical recommendations only and not for supervising or providing quality control. Before applying for protection against specific chemical environments, consult Chemical Resistance Guide or Sika Technical Service.</p>	
Trouble Shooting	Problem Observed	Possible Causes
	Fisheyes	Oil Contamination; Improper substrate cleaning; Mold Release Agents; Improper Mixing.
	Peeling From Substrate	Insufficient preparation process; Oil impregnation; Moisture in concrete.
	Peeling Between Coats	Past critical recoat time; Contamination between coats.
	Coating Soft, Dulling	Improper mixing; Use of thinner in product; Extreme weather conditions.
	Slow Cure	Low floor and ambient temperatures; Use of thinner in product; Improper mixing; Product applied too thin.
	Fast Cure	High floor and ambient temperatures.
	Bubbling	Excessive substrate outgassing due to rising temperatures; Working product past pot life; Improper mixing overworked the product.

KEEP CONTAINER TIGHTLY CLOSED • KEEP OUT OF REACH OF CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s). Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikacorp.com or by calling 800-933-7452.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Technical Data Sheet, product label and Material Safety Data Sheet which are available online at www.sikaconstruction.com or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Technical Data Sheet, product label and Material Safety Data Sheet prior to product use.

Sika warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Technical Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKASHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKASHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Visit our website at www.sikaconstruction.com

1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation
201 Polito Avenue
Lyndhurst, NJ 07071
Phone: 800-933-7452
Fax: 201-933-6225

Sika Canada Inc.
601 Delmar Avenue
Pointe Claire
Quebec H9R 4A9
Phone: 514-697-2610
Fax: 514-694-2792

Sika Mexicana S.A. de C.V.
Carretera Libre Celaya Km. 8.5
Fracc. Industrial Balvanera
Corregidora, Queretaro
C.P. 76920
Phone: 52 442 2385800
Fax: 52 442 2250537

