BUILDING TRUST

PRODUCT DATA SHEET

Sikafloor® Marine-504

Water-based, 2-component, polyurethane, clear, matt topcoat for internal decks

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		Sikafloor® Marine-504 (A)	Sikafloor® Marine-504 (B)
Chemical base		Acrylic dispersion	Isocyanate
Colour (CQP001-1)		White	Transparent
Density		1.1 kg/l	1.1 kg/l
	mixed (+ 5 % H_2O)	1.1 kg/l	
Solid content		57 %	
Mixing ratio	by weight (A:B)	80 : 20	
Application temperature	substrate / climate	10 – 30 °C [A, B]	
Pot-life	at 10 °C	50 minutes	
	at 20 °C	30 minutes	
	at 30 °C	20 minutes	
Shelf life		6 months [C]	12 months [C]

CQP = Corporate Quality Procedure
[A] Substrate must be 3 °C above dew point
[B] Maximum 80 % r. h.
[C] stored in sealed container in up-right position in a dry place between 5 and 30 °C, protected from direct sunlight

DESCRIPTION

Sikafloor® Marine-504 is a water-based, 2-component, polyurethane, clear, matt topcoat for internal decks. It is used as a component of the Sikafloor® Marine Deco systems.
Sikafloor® Marine-504 has been tested in accordance with the FTP Code system and approved in accordance with IMO Marine Equipment Directives.

PRODUCT BENEFITS

- Excellent working characteristics
- Very low VOC emission
- IMO approved
- Easy to clean

AREAS OF APPLICATION

Sikafloor® Marine-504 is designed as a component of the Sikafloor® Marine Deco systems for internal decks in ship and boat construction.
This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM
The curing of Sikafloor® Marine-504 takes place by a chemical reaction of the two components.
Higher temperatures speed up and lower temperatures slow down the curing process.

CHEMICAL RESISTANCE
For advice on chemical resistance contact the Technical Department of Sika Industry.

METHOD OF APPLICATION
Surface preparation
Dust, loose and friable material must be completely removed from all surfaces before application of the product, preferably by brush or vacuum. Ensure that substrates are clean, dry and free from all contaminants such as dirt, oil, grease, coatings and other surface treatments.

Mixing process
Prior to mixing both components, stir part A with a proper mixing paddle.
Add part B and start mixing. During this mixing process add 5 – 7 % of water and continuously mix for 3 minutes until a uniform mix has been achieved.
To ensure thorough mixing pour materials into another container and mix again for at least 1 minute.
Mix with mixing paddles not higher than 300 rpm's to minimize air entrapment.
After mixing wait 10 minutes before starting to work with Sikafloor® Marine-504.

Application
Prior to application confirm relative air humidity and dew point.
When starting to coat, make sure the coating rollers are well saturated with product.
After proper mixing the product is poured and spread out on the floor in respect of the coat weight. Note: Keep an eye on the pot life since the end of the pot-life is not visible.
Roll with a larger 50 cm roller in one direction cross the working direction to eliminate lapmarks.
Always consult the most current corresponding Application Manual.

Curing
Indications regarding curing details see table below.

Temperature	Foot traffic	Light traffic	Full cure
10 °C	36 hours	48 hours	6 days
20 °C	16 hours	24 hours	4 days
30 °C	12 hours	18 hours	3 days

Removal
Uncured Sikafloor® Marine-504 can be removed from tools and equipment with water. Once cured, the material can only be removed mechanically.
Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Application limits
Freshly applied Sikafloor® Marine-504 must be protected from damp, condensation and water for at least 5 days. Uncured material reacts in contact with water (foaming).

FURTHER INFORMATION
The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.
Copies of the following publications are available on request:
- Safety Data Sheets
- Application Manual Sikafloor® Marine-504

PACKAGING INFORMATION
Sikafloor® Marine-504 (A)

Pail	6 kg

Sikafloor® Marine-504 (B)

Pail	1.5 kg

BASIS OF PRODUCT DATA
All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION
For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER
The information, and, in particular, the recommendations relating to the application and enduse 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.