



# METHOD STATEMENT

## SIKALASTIC®-632 R

SIKA LIMITED (VIETNAM)

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BUILDING TRUST



## I. SCOPE

This method statement describes the step by step application of 1-component component, liquid applied, rapid cure, pure polyurethane roof waterproofing membrane for exposed roof.

## II. PRODUCTS DESCRIPTION

Sikalastic®-632 R is a rapid cure, one component, moisture-triggered, pure polyurethane, liquid applied membrane based on unique i-Cure® technology.

### Uses

Exposed or concealed waterproofing membrane on flat or pitched roofs both for new construction and refurbishment of old roofs.

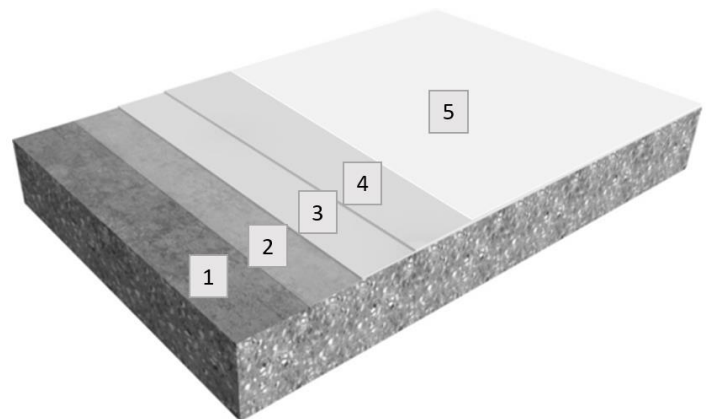
### Characteristics/ Advantages

- 1 component pure polyurethane, easy to apply
- 1 material for horizontal / vertical areas
- 1 hour early rain resistant
- High UV resistant performance with top coat
- High solid content

## III. SYSTEM BUILD-UP

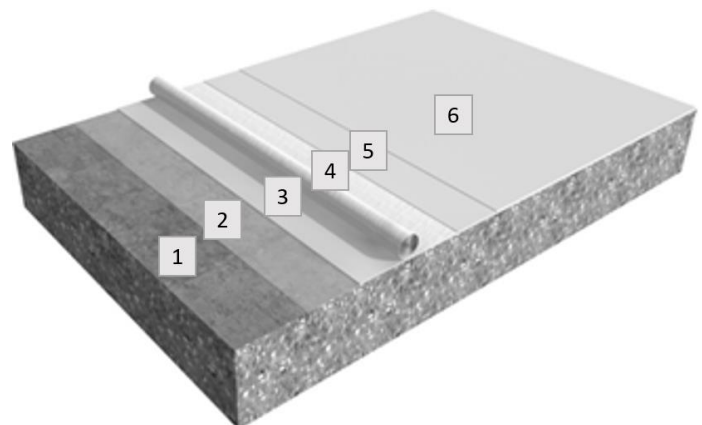
### A. COATING SYSTEM

1. Substrate
2. Primer: Sikalastic® U-Primer (~ 0.2 kg/m<sup>2</sup>)
3. 1<sup>st</sup> coat: Sikalastic® 632R (0.7~1.1 kg/m<sup>2</sup>)
4. 2<sup>nd</sup> coat: Sikalastic®-632R (0.7~1.1 kg/m<sup>2</sup>)
5. Top-coat: Sikalastic® U-Coating (~0.2 kg/m<sup>2</sup>)



### B. WATERPROOFING SYSTEM

1. Substrate
2. Primer: Sikalastic® U-Primer (~ 0.2 kg/m<sup>2</sup>)
3. 1<sup>st</sup> coat: Sikalastic® 632R (0.9~1.2 kg/m<sup>2</sup>)
4. Fully reinforced with Sikalastic® Reemat Premium
5. 2<sup>nd</sup> coat: Sikalastic® 632R (0.9~1.2 kg/m<sup>2</sup>)
6. Top-coat: Sikalastic® U-Coating (~0.2 kg/m<sup>2</sup>)



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## IV. APPLICATION

### 1. Substrate preparation

- **Substrate quality**

New concrete should be cured for at least 28 days and should have a pull off strength  $\geq 1.5$  N/mm<sup>2</sup> (supported by test on site). Inspect the concrete, including upstands, all areas should be hammer tested. Concrete must be suitably finished by wood float or steel pan. The surface finish must be uniform and free from defects such as laitance, voids or honeycombing.

- **Substrate preparation**

- Check that the construction and substrate are in good condition.
- Check that the surface is dry and substrate humidity is maximum 4% without emitting dampness.
- Substrate Temperature +10°C min. / + 40°C max.
- Ambient Temperature +10°C min. / + 40°C max.
- Relative Humidity <85%
- Dew Point - Beware of condensation! The substrate and uncured membrane must be at least 3°C above the dew point to reduce the risk of condensation. Condensation may affect adhesion and could affect appearance.
- Cementitious or mineral based substrates must be prepared mechanically using abrasive blast cleaning or scarifying equipment to remove cement laitance and to achieve an open textured surface. Loose friable material and weak concrete must be completely removed and surface defects such as blowholes and voids must be fully exposed. High spots must be removed by e.g. grinding. Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out using appropriate products from the Sikaflex®, Sikafloor®, Sikadur® and Sikagard® range of materials.
- Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in subsequently applied coatings. Primer is used to block outgassing avoiding pin holing.

### 2. Application

- **Application primer Sikalastic® U-Primer**

Application of primer Sikalastic® U-Primer at consumption of approx. 0.2 kg/m<sup>2</sup> on to the prepared and conditioned substrate by brush, roller or airless spraying machine.

Waiting time / over coating of Sikalastic® U-Primer

Ambient conditions	Minimum waiting time	Maximum waiting time <sup>(*)</sup>
+20°C / 55% R.H	4 hrs (and touch dry)	24 hrs
+30°C / 85% R.H	2 hrs (and touch dry)	24 hrs

Note: times are approximate and will be affected by the substrate temperature.

\*After 24 hrs the surface must be re-primed prior to the application of Sikalastic®-632 R.

Damageable areas (handrails etc.) should be protected with tape or plastic wrapping.

- **Application Sikalastic®-632 R**

- Application of Sikalastic®-632 R by brush, roller or airless spraying machine.
- Prior the application of Sikalastic®-632 R the priming coat Sikalastic® U-Primer must have cured tack-free.
- Waiting time / over coating of Sikalastic® 632R

Ambient conditions	Minimum waiting time	Maximum waiting time*
+20°C / 55 % r.h.	4 hours	2 days
+30°C / 85 % r.h.	2 hours	2 days

\* After 2 days the surface must be cleaned and re-primed prior to the application of another layer of Sikalastic®-632R.

#### • Application Sikalastic® U-Coating

- Sikalastic® U-Coating is supplied in the correct proportions of component A (resin) and component B (hardener). Pour component B into the container of component A and ensure that container B is emptied completely. To achieve a homogeneous mix, both components must be thoroughly mixed with a mixing device at about 300 rev/min
- Sikalastic® U-Coating is applied by spreading the material with a flat squeegee and finish by back rolling at consumption of approx. 0.2 kg/m<sup>2</sup>
- Waiting time / over coating of Sikalastic® U-Coating

Substrate temperature	Touch dry	Full cure
+10°C	8 Hours	6 days
+20°C	6 Hours	4 days
+30°C	5 Hours	3 days
+40 °C	3 Hours	2 days

- Note: times are approximate and will be affected by the substrate temperature.
- Damageable areas (handrails etc.) should be protected with tape or plastic wrapping.

#### **DETAILING:**

- Always begin the installation with the details prior to the installation of the horizontal areas. Follow same process of reinforced system.

#### **APPLICATION OF COATING SYSTEM:**

- Apply the first layer of Sikalastic®-632 R maintaining a wet edge to ensure a seamless membrane.
- Once the first layer has cured enough (see further down overcoating time window) apply the second layer of Sikalastic®-632 R.

#### **APPLICATION OF REINFORCED SYSTEM:**

- Apply the first layer of Sikalastic®-632 R maintaining a wet edge to ensure a seamless membrane.
- Roll-in the reinforcement Sikalastic® Premium and overlap by minimum 5 cm. The roller may require only a little bit of extra material to keep wetted but no further significant material is added at this stage.
- Once the first layer has cured enough (refer to overcoating time window) apply the top layer of Sikalastic®-632 R.

Overcoating Sikalastic®-632 R

Ambient conditions	Minimum waiting time	Maximum waiting time (*)
+20°C / 55% R. H	4 hrs	2 days
+30°C / 85% R. H	2 hrs	2 days

Notes: times are approximate and will be affected by the layer thickness, the substrate temperature.

(\*) after 2 days the surface must be cleaned and primed prior to the application of another layer of Sikalastic®-632 R.

### 3. Notes on Application / Limitations

- Do not apply Sikalastic®-632 R on substrates with rising moisture.
- Do not dilute Sikalastic®-632 R with any solvent.
- Sikalastic®-632 R is not suitable for permanent water immersion and for inverted roof structures (with thermal insulation placed directly on to the Sikalastic®-632 R).
- Ponding water test can be conducted on Sikalastic®-632 R after 24 hours, within a maximum test duration of 48 hours. After 48 hours water needs to be removed.
- On substrates likely to exhibit outgassing, apply during falling ambient and substrate temperatures. If applied during rising temperatures “pin holing” may occur from rising air.
- Do not use Sikalastic®-632 R for indoor applications.
- Do not apply Sikalastic®-632 R close to the air intake vent of running air conditioning unit.
- ALWAYS use the fully reinforced system on top of existing asphalt/bitumen sheet roofs and for light maintenance foot traffic roofs.
- Volatile bituminous materials may stain and or soften when overcoated with Sikalastic®-632 R. Low melting point bituminous materials may need priming.
- Whilst Sikalastic®-632 R is resistant to most commonly encountered atmospheric pollutants, proprietary cleaning solutions and environmental spoilage. Contact Sika Technical Service team in case of specific chemical resistance requirements.

Please refer to relevant PDS for more information.

### DISCLAIMER

*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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