



PRODUCT DATA SHEET

Sika® Level-325

CEMENTITIOUS, SELF-LEVELING UNDERLAYMENT FOR INTERIOR AND EXTERIOR

PRODUCT DESCRIPTION

Sika® Level-325 is a one-component, durable and versatile cementitious underlayment for interior and exterior concrete and cementitious substrates. It can be applied manually or by pump to produce a self-smoothing, rapid-setting and flat substrate prior to the application of a final floor finish. Typical application thickness is 1/8" up to 1-1/2" (3 up to 38 mm).

USES

- Concrete
- Cement substrates
- Rapid drying cement screed systems
- OSB/Plywood only suitable for flexible coverings
- Ceramic tiles, terrazzo or natural stones

CHARACTERISTICS / ADVANTAGES

- Self-leveling
- Levels new and renovates old floors
- For interior and exterior use
- Manual or pumpable applications
- Excellent underlay for all type of residential and commercial flooring
- Compatible with subfloor heating systems
- Easy installations
- High strength
- Low shrinkage
- Can accept caster wheel loading if the thickness is greater than 1/8" (3.2 mm)
- No MVER (Moisture Vapor Emission Rate) limits on well prepared concrete

PRODUCT INFORMATION

Chemical Base	Cement-based, polymer-modified binder system and fillers
Packaging	55 lb (24.9 kg) bag
Appearance / Color	Gray powder
Shelf Life	12 months from date of production if stored properly in original, unopened and undamaged sealed packaging
Storage Conditions	Store dry at 41–86 °F (5–30 °C) Protect from moisture. If damp, discard material

TECHNICAL INFORMATION

Compressive Strength	1 day	2,000 psi (14 MPa)	(ASTM C-109)
	7 days	3,500 psi (24 MPa)	73 °F (23 °C)
	28 days	5,300 psi (37 MPa)	50 % R.H.
Flexural Strength	28 days	1,500 psi (10 MPa)	(ASTM C-293) 73 °F (23 °C) 50 % R.H.
Tensile Adhesion Strength	3 days at 1/8"	500 psi (3.4 MPa)	(ASTM C-1583)
Thermal Resistance	Suitable for use with underfloor heating systems		

APPLICATION INFORMATION

Mixing Ratio	4.75 qts (4.5 L)		
Fresh Mortar Density	133 lb/ft ³ (2.1 kg/l)	(ASTM C-138)	
Coverage	26 ft ² at 1/4" (2.3 m ² at 6 mm) per bag (Coverage figures do not include allowance for surface profile and porosity or material waste)		
Layer Thickness		Min.	Max.
	Neat	1/8" (3 mm)	1-1/2" (38 mm)
	Extended	1/4" (6 mm)	3" (76 mm)
	*2" (50 mm) in localized area		
Product Temperature	65–75 °F (18–24 °C)		
Ambient Air Temperature	41–86 °F (5–30 °C)		
	Note: When using water based adhesives on the finished product the best results will be achieved at ambient and substrate temperatures between 59 and 77 °F (15–25 °C).		
Relative Air Humidity	< 75 %		
	Note: The substrate and uncured product applied on the floor, must be at least 5 °F above dew point to reduce the risk of condensation, blooming or cement laitance forming on the surface.		
Substrate Temperature	41–86 °F (5–30 °C)		
Pot Life	~ 15-20 minutes		
	As the temperature will affect the pot life, application temperature: ▪ Above 73 °F (23 °C) will reduce the pot life and the working time. ▪ Below 73 °F (23 °C) will extend the pot life and the working time.		
Set Time	70–90 minutes	(ASTM C-266)	
Final Set Time	80–110 minutes	(ASTM C-266)	
Waiting / Recoat Times	Walk-on time: 4 hours		
	Suitable for overcoating with:		
	Non moisture sensitive floor covering	4 hours	
	Moisture sensitive floor covering	24 hours up to 3/8" (9.5 mm)*	

*Mat test (ASTM D-4263) above 3/8" (9.5 mm)
The actual times will be affected by changing substrate and ambient conditions, particularly the temperature and relative humidity, plus the thickness of the material applied. When overcoating Sika® Level-325 always ensure the moisture content has achieved the required value for the subsequent floor finish adhesive / product being used, as the necessary waiting time will vary (with the application thickness and ambient humidity). Also please refer to the floor finish / adhesive PDS.

APPLICATION INSTRUCTIONS

All substrate must be dry, stable, sound and free of all contaminants such as grease, oil, paint, wax, dust, curing and sealing compounds that will interfere with the penetration the primer and the adhesion of Sika® Level-325.

SURFACE PREPARATION

Careful consideration should be given to the selection of the method of mechanical surface preparation and the timing of application of primer and underlayment. Immediately following mechanical preparation on some excessively porous substrates, outgassing will increase for a short period of time (approx. 48 hours) until equilibrium in slab vapor pressure and the ambient environment is reached.

- **Concrete & Cement Substrates:** Prepare concrete, cement and dense substrates, including ceramic, quarry and vinyl tiles by mechanical means, such as shot blasting, sandblasting, water-jetting, scarifying, or other appropriate methods, to achieve an open-textured surface. Weak surfaces should be removed. All cracks and holes should be similarly filled to prevent seepage. Repair with Sika® Level SkimCoat or SikaQuick® mortar prior to priming and leveling. The compressive strength of the concrete substrate should be at least 2,900 psi (20 MPa) at 28 days with a minimum tensile strength of 200 psi (1.4 MPa).
- **Cutback Adhesive:** Old water-soluble adhesives should be removed completely. Old water-resistant adhesives should be mechanically removed. The complete mechanical removal of cutback (i.e. grinding, sanding and blasting) can be hazardous as old cutback adhesive may contain asbestos. Do not sand or grind adhesive residue. Harmful dust may result. Inhalation of asbestos dust may cause asbestosis or other serious bodily harm. Please consult the adhesive manufacturer and all applicable government agencies for rules and regulations concerning the removal of flooring and adhesives that contain asbestos. Prime remaining adhesive residues accordingly.
- **OSB/Plywood Subfloors:** Where installing Sika® Level-325 over wooden subfloors, ensure that the subfloor consists of at least two layers of exterior grade plywood, a minimum of 1-1/4" (32 mm) thickness and meets, as a minimum, the deflection parameters of L/360 (live and dead loads taken into consideration). The OSB/ plywood must then be suitably secured, bonded and prepared to a contaminant free and sound condition. Consult the manufacturer of the final floor covering with regard to the deflection requirements of the floor finish system.

PRIMING

- Prime standard absorbent substrates such as concrete and cement with Sika® Level-01 Primer Plus (1:3).
- Prime non-absorbent, smooth, sound substrates such as ceramic tiles and old water-resistant adhesive residues (removed as much as possible) with Sika® Level-02 EZ Primer.
- Where substrate moisture exceeds the maximum allowed (3 lb per 1,000 ft³) then application of Sika® MB or Sika® MB Redline may be used to suppress residual moisture.
- Refer to the respective PDS for complete and detailed instructions on the usage of each Primer.

MIXING

- Pour 4.75 qts (4.5 L) of cool potable water (~ 70 °F, 21.1 °C) into a suitably sized and clean mixing container, using a calibrated measuring jug, or similar, to ensure strict control of the water content (do not over-water). If available water is not at this temperature, then consideration should be given to cooling/heating the water.
- Add Sika® Level-325 to the water, while slowly mixing, adding the complete contents of the bag.
- Mix with a high-speed drill (> 650 rpm) and an egg beater style mixing paddle to blend water and powder for approximately 3 minutes, until a lump-free and uniform mix has been produced.
- Do not overmix or allow the paddle to rise above the level of material as this will introduce and entrap air into the mix, potentially shortening the working life or causing pin-holing in the underlayment.
- Let the mixed material stand until the majority of air bubbles have dispersed.

APPLICATION

- Pour the mix and spread using a smoothing trowel. Even surfaces are easily achieved using a pin leveler. It's not recommended to remove troweling defects or to level more than once.
- If a second layer of leveling compound has to be applied, prime the first layer with Sika® Level-01 Primer Plus (1:1) when the first layer is walkable. The maximum layer thickness must not be exceeded in case of two layer applications and the second layer must not exceed the layer thickness of the first layer.
- Protect curing Sika® Level-325 layers from high ambient temperatures, direct sunlight and ensure an adequate air circulation.
- Sika® Level-325 does not provide an aesthetic finish.
- Sika® Level-325 can be coated or sealed only.
- Always install an adequate number of properly located test areas, to include the finish flooring.
- As floor coverings vary, always contact and rely upon the floor covering manufacturer for specific directions such as maximum allowable moisture content, adhesive selection, and intended end use of the

product.

EXTENSION WITH AGGREGATES

- For applications greater than 1-1/2" (38 mm) in depth, add 3/8" (9.5 mm) coarse aggregate.
- The aggregate must be non-reactive (reference ASTM C-1260, C-227 and C-289), clean, well graded, Saturated Surface Dry (SSD), have low absorption and high density, and comply with ASTM C-33 size number 8 per Table 2.
- Pre-washed 3/8" (9.5 mm) pea-gravel can be pre-placed onto the primed area being leveled at no more than 1/3 of the total placement depth. Pour the material over the aggregate and rake to ensure proper consolidation around the aggregate and a proper bond with the substrate. Applicator must be aware that the aggregate can cause voids in the underlayment if not filled correctly.
- Variations in aggregate may result in different strengths and flow.
- The addition rate is 25 lb. (11.4 kg) of aggregate per bag. It is approximately 2.0 gal. (7.6 L) by loose volume of aggregates.
- The final 1/8-1/4" (3.2-6.3 mm) layer should be neat to allow for a smooth finished floor.
- Do not add more water.

PUMPING

- Over large areas, application by conventional piston, rotor-stator or underlayment type pumps is more appropriate.
- Thoroughly spike roll in two directions (90 °) to remove installation marks and any entrapped air, but avoid overworking.
- Consult Sika® Technical Service for recommendations.

CLEANING OF TOOLS

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

LIMITATIONS

- Do not apply onto based, chipboard, particle board, hardboard, metal or dimensionally unstable substrates.
- Protect from excessive heat and moving air by turning off radiant heating and forced air ventilation for 24 hours before installation and while the underlayment is curing.
- Protect newly applied Sika® Level-325 from condensation and water for at least 24 hours.
- Prevent contaminants, dust and dirt from coming into contact with the underlayment for at least 4 hours and do not expose to rolling dynamic loads for 2 days (at 73 °F, 23 °C, 50 % R.H.).
- If high point loads (e.g. hospitals, etc.) are expected, laying on top of old coatings is not recommended.

- All cement based products have the potential for cracking. Cracking, such as hair line cracking cannot be considered as a product defect.
- For adhesives other than SikaBond®, a test application is recommended prior use.
- This product is not a vapor barrier and will allow free passage of moisture.
- As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sika® MB.

BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

OTHER RESTRICTIONS

See Legal Disclaimer.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

0 g/L

(EPA Method 24)

LEGAL DISCLAIMER

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

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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