



**Product Data Sheet**  
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Sikalastic 641 Lo-VOC Roofing System

# Sikalastic® 641 Lo-VOC Roofing System

Single component fully reinforced Lo-VOC, low-odor system with fiberglass or polyester reinforcement

Construction

<b>Description</b>	Sikalastic 641 Lo-VOC roofing systems combine cold applied, aliphatic, single component, moisture-triggered polyurethane resins with fiberglass mat or polyester fleece reinforcement to create a seamless membrane and flashing system. System components are: Sika or Sikalastic Primer - Select primer per substrate material in accordance with Priming Guide Sikalastic 641 Lo-VOC - Resin used for all systems with polyester fleece reinforcement Sika Reemat Premium - Chopped strand fiberglass mat Sika Fleece 120, 140, 170 - Non-woven, needle-punched polyester fleece in various weights
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>■ Sikalastic RoofPro 10, 15, 20 and 25 year systems, including Sikalastic RoofPro Built Up, Direct, Plaza Deck/ PMA, and Vegetated systems for both new construction and refurbishment</li> <li>■ Ideal for roofs displaying complex details and geometry or when accessibility is limited</li> <li>■ Effective and cost efficient life cycle extension of existing roofs</li> <li>■ Highly reflective Sikalastic 641 Lo-VOC in White (RAL 9016) suitable for cool roofs and solar roof assemblies.</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Proven technology with over 25 year track record</li> <li>■ Single component - no mixing and ready to use</li> <li>■ Fully reinforced with highly conformable Sika Reemat or Sika Fleece</li> <li>■ Moisture triggered chemistry that is rapidly weatherproof after application</li> <li>■ Low odor formulation</li> <li>■ Highly elastic and crack bridging</li> <li>■ Seamless and fully adhered</li> <li>■ Vapor permeable</li> <li>■ UV resistant and non-yellowing</li> <li>■ Abrasion and chemical resistant</li> </ul>
<b>Approvals</b>	<ul style="list-style-type: none"> <li>■ FM Approval Standard 4470 for Class 1 Roof Covers - Pending</li> <li>■ Meets ASTM D7311-07: Standard Specification for Liquid-Applied, Single-Pack, Moisture-Triggered, Aliphatic Polyurethane Roofing Membrane.</li> </ul>
<b>Coverage</b>	See Application Below
<b>Packaging</b>	5 gal. pails
<b>Cure Mechanism</b>	Moisture triggered
<b>Chemical Resistance</b>	Strong resistance to a wide range of reagents, including paraffin, gasoline, fuel oil, white spirit, acid rain, detergents and moderate solutions of acids and alkalis. Some low molecular weight alcohols can soften the material. Contact Technical Service for specific recommendations.

### Typical Data (Material and curing conditions @ 73°F and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

<b>Shelf Life</b>	12 months in original, unopened and undamaged sealed containers
<b>Storage Conditions</b>	Store dry at 35-77°F (2-25°C).
<b>Product Conditioning</b>	Condition material to 50-77°F (10-25°C) before using for ease of application.
<b>Colors 641 Lo-VOC:</b>	White, Pearl Gray, Steel Gray, Mushroom, Copper Green; custom colors available with minimum order
<b>Chemical Base</b>	Single component, moisture-triggered, aliphatic polyurethane
<b>Density (all values at +23 degrees C)</b>	
641 Lo-VOC	11.9 lbs/gal (1.43 kg/l)
<b>Solids Content</b>	
641 Lo-VOC	89.0 % by volume /92 % by weight
<b>Flash Point</b>	
641 Lo-VOC	199°F (93°C)
<b>VOC</b>	
641 Lo-VOC	38 g/L (1.43 kg/L)
<b>Service Temperature</b>	-22 to 176°F (-30 to 80°C) intermittent
<b>641 Lo-VOC White (RAL 9016)</b>	
<b>Solar Reflectance (Initial)</b>	0.88 (ASTM C1549)
<b>SRI (Solar Reflectance Index - Initial)</b>	110 (ASTM E1980)

Physical Properties – Typical Values	ASTM Test Method	RoofPro 20	RoofPro 20
Reinforcement	----	Reemat Premium	Sika Fleece 140
Breaking Strength, psi	D751 Proc. B	1030	900
Elongation to Break, %	D751	21	82
Tear Strength, lbf/in	D624	300	200
Static Puncture Resistance	D5602	>55 lbf	>55 lbf

Note: Data for other RoofPro assemblies available upon request



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**How to Use**

**Surface Preparation** See Application below

**Application**

**Substrate Evaluation**

**Concrete and cementitious substrates**

New concrete shall be allowed to cure a minimum of 28 days. Concrete shall have a minimum compressive strength of 20.7 MPa (3000 psi) and exhibit a minimum tensile bond strength of 1.4 MPa (200 psi). Moist or sheet curing methods should be used, as opposed to the use of curing compounds, which may interfere with the bond of the membrane. Inspect the concrete, including upstands, and all areas should be hammer tested. Concrete must be suitably finished, preferably by wood float or steel pan. A power float finish is acceptable where the surface is prepared to avoid laitance (a tamped finish is not acceptable). The surface finish must be uniform and free from defects such as laitance, voids or honeycombing.

**Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free, and shall be properly secured to the structure. Loose, damaged, or contaminated boards shall be removed and replaced.

**Brick and stone**

Mortar joints must be sound and preferably flush pointed.

**Asphalt**

Asphalt contains volatiles which can cause bleeding and slight non-detrimental staining. The asphalt must be carefully assessed for moisture and/or air entrapment, grade and surface finish.

**Bituminous felt**

Ensure that bituminous felt is firmly adhered or mechanically fixed to the substrate. Bituminous felt shall not contain badly degraded areas.

**Bituminous coatings**

Bituminous coatings shall not have sticky or mobile surfaces, volatile mastic coatings, or old coal tar coatings.

**Metals**

Metals must be in sound condition.

**Wooden substrates**

Plywood and timber based roof decks must be in good condition, firmly adhered and mechanically fixed. All plywood should be identified as conforming to PS 1 for construction and industrial plywood by grade, APA (American Plywood Association) trademark, or equivalent. For maximum smoothness, EXT Type APA, Grade A-C should be used, and the "A" side should be positioned to receive the Sikalastic resin.

Plywood decks to receive resin directly shall be at least 1/2 inch thick and attached and supported according to APA guidelines, using only non-rusting screw, spiral or coated nail type fasteners. A good practice would be to recess or counter sink fasteners 1/8 to 1/4 inch and fill with Sikaflex sealant. Suitable edge support to prevent differential deflection between panels shall be provided. Panel edges shall be tongue and groove or supported on solid blocking. Space panels 1/8 to 3/16 inch at panel ends.

**Paints and coatings**

Ensure the existing material is sound and firmly adhered.

**Existing Sikalastic RoofPro System**

The existing Sikalastic RoofPro System shall be soundly adhered to the substrate.

**Surface Preparation**

**Concrete and cementitious substrates**

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 (CSP 3-5 per ICRI guidelines). Loose friable material and weak concrete must be completely removed and surface defects such as blowholes and voids must be fully exposed. The amount of embedment coat required may increase over rough or highly porous surfaces.

Repairs to the substrate, filling of joints, blowholes/voids and surface levelling must be carried out. Consult Sika for product recommendations based on project requirements. High spots must be removed by grinding or similar method.

Outgassing is a naturally occurring phenomenon of concrete that can produce pinholes in liquid applied materials. The concrete must be carefully assessed for moisture content, air entrapment, and surface finish prior to any roofing work. Particular requirements for priming must also be considered. Installing the primer and membrane either when the concrete temperature is falling or stable can reduce outgassing. It is generally beneficial, therefore, to apply the primer and embedment coat in the late afternoon or evening.

**Gypsum and Cement based sheathing**

Sheathing boards shall be clean, dry and dust free. Secure loose boards if in sound condition. Damaged or contaminated boards shall be removed and replaced.



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## **Brick and stone**

Power wash and use biodegradable non-sudsing detergent with clean water rinse as required.

## **Asphalt**

Power wash and use biodegradable non-sudsing detergent with clean water rinse as required. All major cracks should be sealed to allow continuity of the Sikalastic RoofPro system.

## **Bituminous felt**

Power wash and use biodegradable non-sudsing detergent with clean water rinse as required. Treat blisters by star cutting and removing any underlying water. Allow to dry and re-adhere using suitable adhesive.

## **Bituminous coatings**

Remove any loose or degraded coatings.

## **Metals**

Ferrous metals should be thoroughly cleaned by grinding or blast cleaning prior to priming (SSPC-SP3 to near-white metal) .

Non-ferrous metals are prepared by removing any deposits of dust and oxidation and abrading to bright metal. Wire brushing can be used for soft metal such as lead. The surface must be clean and free from grease which, if present, must be removed with a solvent wipe or wash with detergent, rinse and dry.

## **Wooden substrates**

Timber and timber based roof decks require additional reinforcement such as the installation of plywood, approved insulation or cover board. Small timber protrusions and suitable decks may be treated directly, provided that the timber is of exterior quality, e.g. plywood. Fill joints flush with Sikaflex sealant.

## **Paints/Coatings**

Remove any loose or degraded coatings. Ensure the surface is clean and free from grease.

## **Sikaplan®/Sarnafil® membranes**

Clean membranes with Sarna Cleaner (PVC membranes) and Sarnafil® T Clean (FPO membranes) prior to application of primer.

## **Existing Sikalastic RoofPro Systems**

Clean the membrane using a water jet at approximately 140bar (2000 psi) and biodegradable non-sudsing detergent with clean water rinse. Allow to dry.

## **Application**

### **Priming**

Refer to Priming Guide to select primer for properly evaluated and prepared substrate. Refer to separate primer Product Data Sheet for application methods, coverage rates, cure times and recoat windows. Always allow primer to cure thoroughly before applying detail or base resin layer.

### **Sikalastic RoofPro Priming Guide**

Substrate	Remark	CONCRETE PRIMER	DTE EPOXY Primer	Bonding Primer	EP PRIMER/ SEALER	Consult Sika
CONCRETE	(1)	▲	▲	▲	▲	
LIGHTWEIGHT STRUCTURAL CONCRETE	(1)		▲			▲
GYPHUM BASED ROOF BOARDS		▲		▲		
BRICK, STONE	(3)			▲		▲
<b>BITUMINOUS SUBSTRATE</b>						
-asphalt, bituminous felts, bituminous coatings, granulated or smooth SBS & APP cap sheets	(2,3)				▲	
<b>SINGLE PLY ROOFING MEMBRANES</b>						
-HYPALON, TPO, EPDM, PVC	(3)					▲
ROOF TILES (UNGLAZED)	(3,4)			▲		▲
POLYESTER (GLASS FIBER REINFORCED)	(3)			▲		▲
POLYURETHANE FOAM- sprayed or slab stock				▲	▲	
<b>METALS</b>						
-aluminum, galvanized, cast iron, copper, lead, brass, stainless steel, steel, zinc	(3)				▲	

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<b>PRE-COATED METAL</b>	<b>(3)</b>					<b>▲</b>
<b>PAINTS</b>						
- paints & coatings	<b>(3)</b>			<b>▲</b>		
- aluminized solar reflective coatings	<b>(3)</b>				<b>▲</b>	
<b>WOOD - TIMBER &amp; PLYWOOD</b>	<b>(5)</b>			<b>▲</b>	<b>▲</b>	<b>▲</b>

- (1) New cementitious substrates must be Portland base and be cured min. 14 days.
- (2) The presence of volatiles may cause discoloration of Sikalastic if not properly primed.
- (3) Surface evaluation and field adhesion testing.
- (4) Glazed tile consult Sika.
- (5) Pressure treated lumber consult Sika

**Detailing**

**Non-structural cracks up to 1/16 inch** - Detail application not necessary. Apply embedment/base resin layer per below.

**Non-structural cracks between 1/16 inch and 1/4 inch** - Rout and seal with Sikaflex sealant. Apply 40-45 mil resin layer embedded with 3 inch Sika Flexitape Heavy centered over crack. Apply embedment/base resin layer per below.

**Cracks and joints between 1/4 inch and 1 inch** - Rout and seal with Sikaflex sealant. Apply bond breaker tape sufficient to span width of crack or joint followed by 40-45 mil resin layer embedded with 6 inch Sika Flexitape Heavy centered over crack or joint. Apply embedment/base resin layer by terminating Sika Reemat or Sika Fleece at edges of crack or joint overlapping Sika Flexitape Heavy a minimum of 2 inches on both sides.

**Joints greater than 1 inch** - Treat as expansion joint. Consult Sika for recommendations.

**Metal, plywood and existing bituminous or single-ply seams** - Apply 40-45 mil resin layer embedded with 3 or 6 inch Sika Flexitape Heavy centered over seam. Apply embedment resin layer per below.

**Transitions between dissimilar materials** - Apply 40-45 mil resin layer embedded with Sika Flexitape Heavy centered over edge. Apply embedment resin layer per below.

**Embedment/Base Resin Layer with Sika Reemat Reinforcement**

Mixing not required. Apply Sikalastic 641 Lo-VOC per RoofPro System Guide at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should be backrolled prior to embedding Sika Reemat. Place Sika Reemat in wet base resin layer overlapping seams a minimum of 2 inches (place frayed edge over cut edge of roll) and apply wet roller to topside to saturate completely. After approximately 5 minutes the binder will begin to dissolve allowing the fiber strands to conform to irregular surfaces. Do not over work once the fibers have conformed to the substrate. Allow to cure 12 hours at 70 degrees F and 50% RH or until tack free before top resin layer. Keep clean and dry and apply top resin layer within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

**Top Resin Layer with Sika Reemat Reinforcement**

Mixing not required. Apply Sikalastic 641 Lo-VOC at the coverage rate in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Material can also be squeegee or spray applied, in which case it should also be backrolled. In the case of RoofPro 25 allow the first top resin layer to cure 12 hours at 70 degrees F and 50% RH or until tack free before applying second top resin layer. On top of the complete RoofPro system additional resin layers may be applied with aggregate for slip resistance - consult Sika for recommendations. Keep clean and dry and apply additional resin layers within 7 days. If window is exceeded clean with non-sudsing detergent and clean water rinse, and allow to dry prior to application of Sika Reactivation Primer.

Sikalastic RoofPro 641 Lo-VOC System Guide with Sika Reemat				
	RoofPro 10	RoofPro 15	RoofPro 20	RoofPro 25
Substrates	Concrete or cementitious, metals, woods, single-ply or bituminous, stone			
Primer	Required - see Substrate Priming Guide			
Detailing	Sika Flexitape Heavy centered over seams, transitions and properly treated cracks and joints			
Reinforcement	Sika Reemat Standard	Sika Reemat Premium embedded in base resin layer over entire surface		
Sikalastic 641 Lo-VOC Base Layer	30 mils wet - 53 sf/gal.	50 mils wet - 32 sf/gal.	50 mils wet - 32 sf/gal.	50 mils wet - 32 sf/gal.
Sikalastic 641 Lo-VOC Top Layer	30 mils wet - 53 sf/gal.	20 mils wet - 80 sf/gal.	30 mils wet - 53 sf/gal.	23 mils wet - 69 sf/gal.
Sikalastic 641 Lo-VOC Top Layer				23 mils wet - 69 sf/gal.
Total Film Thickness	53mils dry	62 mils dry	71 mils dry	85 mils dry

NOTE: Coverage rates provided are optimal - coverage rates will vary depending on temperature, surface roughness, porosity, and application technique.

**Wet on Wet Application with Sika Fleece Reinforcement**

Mixing not required. To primed substrate apply two-thirds of the Sikalastic 641 Lo-VOC specified in the RoofPro System Guide with a 1/2 inch nap phenolic resin core roller. Immediately place specified Sika Fleece into wet resin overlapping seams a minimum of 3" along the edge and 6" end-to-end. Apply wet roller to topside with light pressure to saturate fleece from bottom and ensure air pockets are completely removed. Immediately apply all of remaining one-third of Sikalastic 641 Lo-VOC resin specified in the RoofPro System Guide to ensure even and complete fleece saturation from topside and uniform texture.

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Sikalastic RoofPro 641 Lo-VOC System Guide with Sika Fleece			
	RoofPro 15	RoofPro 20	RoofPro 25
Substrates	Concrete or cementitious, metals, woods, single-ply or bituminous, stone		
Primer	Required - see Substrate Priming Guide		
Detailing	Sika Flexitape Heavy centered over seams, transistions and properly treated cracks and joints		
Reinforcement	Sika Fleece 120 (US)	Sika Fleece 140 (US)	Sika Fleece 170 (US)
Sikalastic 641 Lo-VOC	70 mils wet - 25 sf/gal.	80 mils wet - 20 sf/gal.	95 mils wet- 16 sf/gal.
Total Film Thickness	62 mils dry	71 mils dry	84 mils dry
NOTE: Coverage rates provided are optimal - coverage rates will vary depending on temperature, surface roughness, porosity, and application techniques.			

<b>Tooling &amp; Finishing</b>	See Above
<b>Removal</b>	Remove liquid resin immediately with dry cloth. Once cured, resin can only be removed by mechanical means.
<b>Over Painting</b>	See Above.

<b>Limitations</b>	<ul style="list-style-type: none"> <li>■ To avoid dew point conditions during application, relative humidity must be no more than 95% and substrate temperature must be at least 5°F (3°C) above measured dew point temperatures.</li> <li>■ Minimum ambient and substrate temperature during application and curing of material is 36 degrees F (2°C); maximum is 95°F (35°C). Surface temperatures must be no higher than 140°F (60°C). Frequent monitoring of ambient and substrate temperature should always be done when applying polyurethane resins. Note that low temperatures and low humidity will slow down the cure, and high temperatures and high humidity will accelerate it.</li> <li>■ Do not apply on substrates with moisture content greater than 4% by weight, measured by Tramex Concrete Moisture Encounter meter.</li> <li>■ Minimum age of concrete must be 28 days depending on curing and drying conditions.</li> <li>■ Do not thin with solvents.</li> <li>■ Do not store materials outdoors exposed to sunlight and moisture for prolonged periods.</li> <li>■ Do not apply to substrate surfaces where moisture vapor transmission will occur during application and cure. This condition may be checked using ASTM D 4263 (Polyethylene sheet method).</li> <li>■ Substrate must be dry prior to application. Do not apply to a frosted, wet or damp surface. Allow sufficient time for the substrate to dry after rain or inclement weather, as there is the potential for bonding problems.</li> <li>■ On substrates likely to exhibit outgassing apply during falling ambient and substrate temperature. If applied during rising temperature pinholing or blistering may occur.</li> <li>■ Use sunglasses with UV filter when applying highly reflective Sikalastic 641 Lo-VOC White (RAL 9016).</li> <li>■ Do not use for indoor applications unless sufficient air flow and ventilation are provided to prevent odors and/or vapors from leaving the immediate work area.</li> <li>■ Precautions should be taken to prevent odors and/or vapors from entering the building/structure, including but not limited to turning off and sealing air intake vents or other means of ingress for odors and/or vapors into the building/structure during product application and cure.</li> <li>■ Not recommended for direct exposure to heavy or frequent foot traffic.</li> <li>■ Do not apply cementitious products, such as tile mortar directly onto Sikalastic 641 Lo-VOC. See Sikalastic 624 WP Product Data Sheet.</li> <li>■ Any repairs required to achieve a level surface must be performed prior to application (consult a Sika representative for guidance on various product solutions). Surface irregularities may reflect through the cured system.</li> <li>■ When applying over existing coatings or membranes compatibility and adhesion testing and subsequent approval by Technical Services is required.</li> <li>■ Opening to traffic prior to cure may result in loss of aggregate or permanent staining and subsequent premature failure.</li> <li>■ On grade concrete decks should not be covered with Sikalastic RoofPro membrane systems.</li> <li>■ Unvented metal pan, split/sandwich slab with encapsulated membrane and/or insulation, cinder fill decks, and lightweight insulating concrete deck overlays should not be covered with Sikalastic RoofPro systems without additional deck evaluation and subsequent approval by Technical Services.</li> <li>■ Do not subject to continuous immersion.</li> <li>■ Not recommended for use over ceramic tile.</li> </ul>
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# Construction

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