ARDEX K 520™
Self-Leveling Concrete Topping

A blend of Portland cement and other hydraulic cements
Resurface indoor concrete and certain non-porous surfaces
Walk on in 2 - 3 hours, seal in as little as 24 hours
Polish in as little as 24 hours
Use for interior floors only
ARDEX K 520™
Self-Leveling Concrete Topping

Description and Usage
ARDEX K 520™ is a self-leveling, topping for fast-track resurfacing, smoothing or leveling of indoor concrete and certain non-porous surfaces. ARDEX K 520 can be installed up to 1" (25 mm) thick neat and up to 3" (7.5 cm) thick with the addition of appropriate aggregate (see Technical Data section for minimum installation thicknesses by application). Use ARDEX K 520 in warehouses, utility rooms and light manufacturing areas to provide a hard, flat, smooth surface that can be sealed. Also use over concrete and terrazzo substrates in areas that require a polished surface. Sealing or polishing can proceed in as little as 24 hours.

Substrate Preparation
All substrates must be solid, thoroughly clean and free of oil, wax, grease, asphalt, latex and gypsum compounds, curing compounds, sealers and any contaminant that might act as a bond breaker. Acid etching, adhesive removers, solvents and sweeping compounds are not acceptable means for cleaning the substrate. Sanding equipment is not an effective method to remove curing and sealing compounds. For more detailed information on substrate preparation, please refer to the ARDEX Substrate Preparation Technical Data Sheet at www.ardexamericas.com.

Concrete
Mechanically clean down to a sound, solid substrate by shot blasting or similar. Overwatered, frozen or otherwise weak concrete surfaces must also be cleaned down to sound, solid concrete by mechanical methods. The concrete surface must have a minimum ICRI Concrete Surface Profile of 3 (CSP #3). Any additional preparation required to achieve this must likewise be mechanical.

Non-Absorbent Substrates
Mechanically abrade non-absorbent substrates, such as terrazzo and ceramic and stone tiles, to create a bonding surface. Note that ARDEX K 520 can be used as a polished topping over concrete and terrazzo substrates only.

Joints and Moving Cracks
Under no circumstances should ARDEX K 520 be installed over any joints or any moving cracks. All existing expansion joints, isolation joints, construction joints and control joints (saw cuts), as well as all moving cracks, must be honored up through the topping by installing a flexible sealing compound specifically designed for use in moving joints, such as ARDEX ARDISEAL™ RAPID PLUS. Failure to do so may result in cracking and/or disbonding of the topping. Even the slightest amount of movement in a control joint will cause the ARDEX K 520 to show a hairline crack in a pattern reflective of the joint.

ARDEX cannot be responsible for problems that arise from joints, existing cracks or new cracks that may develop after the system has been installed.

Dormant Cracks
Before proceeding with the installation, all dormant cracks greater than 1/32" (0.7 mm) wide must be prefilled with a fully rigid, high-modulus, 100% solids material, such as ARDEX ARDIFIX™. Please note that the repair material must be sand broadcast to refusal while still fresh and allowed to cure fully prior to removing all excess sand and proceeding with the installation.

The filling of dormant cracks as described above is recommended to help prevent the cracks from showing through the topping. However, should movement occur, cracks will reappear.
**Thickness of Application**

ARDEX K 520 can be installed from 1/4" (6 mm) up to 1" (25 mm) over large areas neat and up to 3" (7.5 cm) with the addition of proper aggregate. ARDEX K 520 also can be tapered to meet existing elevations. Install at a minimum thickness of 3/8" (9.5 mm) if being used as a polished topping.

For areas with thicknesses greater than 1" (2.5 cm), mix ARDEX K 520 with washed and well-graded 1/8" - 3/8" (3 - 9.5 mm) pea gravel. Please note that the aggregate size must not exceed 1/3 the depth of the pour. Mix the ARDEX K 520 with water first, and then add 1 part aggregate by volume, mixing until the aggregate is completely coated. Do not use sand. If the aggregate is wet, reduce the amount of water to avoid overwatering.

The addition of aggregate will diminish the workability of the product and make it necessary to install a neat coat to obtain a smooth surface. Allow the initial application to dry for 12 - 16 hours, and then prime this layer with ARDEX EP 2000 with sand broadcast in accordance with the technical data sheet. Allow the primer to dry for a minimum of 16 hours, then broom sweep and vacuum the surface to remove all loose sand prior to installing the neat coat of ARDEX K 520.

**Wear Surface**

The surface of ARDEX K 520 always must be protected from oil, salt, water and surface wear by applying a suitable protection system, such as a concrete sealer or paint. ARDEX recommends the use of ARDEX CG™ Concrete Guard to seal ARDEX K 520 that will be exposed to normal foot traffic. Sealing with ARDEX CG can proceed after 24 hours under standard conditions of 70°F/21°C and 50% RH. Traffic can proceed as soon as the ARDEX CG has dried to ARDEX recommendations. For ARDEX CG installation instructions, please refer to the ARDEX CG technical data sheet.

For areas to receive heavier traffic, as well as areas such as restaurants and food courts, sealing should be done using an appropriate wear protection coating. As the performance of coating systems varies greatly, the installer is responsible for assessing the suitability of these coatings. If a waterborne sealer is to be applied at a thickness not-to-exceed a total of 20 mils (500 microns), the coating can be applied to the surface of the ARDEX K 520 after 24 hours at 70°F (21°C). When using a solvent-borne or 100% solids coating applied at a total thickness of 20 mils (500 microns) or less, the ARDEX K 520 must cure for a minimum of 48 hours at 70°F (21°C). When the total application thickness will exceed 20 mils (500 microns), the ARDEX K 520 must cure 7 days at 70°F (21°C), and the surface of the ARDEX K 520 must be shot blasted prior to the protection layer being installed.

Traffic can proceed as soon as the sealer / coating has cured in accordance with manufacturer recommendations. Drying time is a function of job site temperature and humidity conditions and the installation thickness. Low substrate temperatures and/or high ambient humidity will extend the drying time. Adequate ventilation and heat will aid drying. Forced drying can dry the surface of the underlayment prematurely and is not recommended.

If ARDEX K 520 is to receive a high-build epoxy, please contact the ARDEX Technical Service Department.

**Cracking**

ARDEX K 520 is formulated as a highly durable, nonstructural wear surface. As such, it is important to note that no one can predict with 100% accuracy the appearance of cracking in a nonstructural topping.

While there can be several causes for cracking, it must first be understood that the installation of thin layers of non-structural toppings are not capable of restraining movement in the structural slab, which could lead to reflective cracking. Conditions most likely to lead to crack telegraphing include deflection of a concrete slab; vibration of a concrete slab, such as that due to truck traffic and subways in metropolitan areas; swaying or “racking” of substrates in high rise buildings due to wind; existing cracks in the substrate; control joints or saw cuts; expansion joints; abutment of dissimilar substrates; embedded metal ductwork and/or small cracks off of the corners of metal inserts, such as electrical boxes or vents in the floor. While priming with ARDEX EP 2000 is the best way to minimize the possibility of reflective cracking, cracks may telegraph up into the surface in any area that exhibits movement. We know of no method to prevent this telegraphing from occurring.

Additionally, certain jobsite conditions can lead to hairline cracking, also known as “map cracking” or “crazing.” Hairline cracking, while aesthetically unpleasant, typically does not affect the overall performance of the topping. The most common cause of hairline cracking is excessively rapid moisture evaporation from the topping during cure, which tends to happen when ambient humidity in the space is very low and/or air rapidly moves over the surface of the topping. Hairline cracking can also occur when there is even slight movement or deflection in the existing substrate. If cracking occurs, we recommend sounding the affected areas to ensure that the topping is well-bonded to the substrate. So long as the topping is well-bonded, its overall performance will not be affected.

**Notes**

FOR PROFESSIONAL USE ONLY.

ARDEX K 520 wear surfaces are intended for foot traffic, moderate, rubber-wheeled forklift traffic and similar uses. Excessive service conditions, such as steel- or hard plastic-wheeled traffic or dragging heavy metal equipment or loaded pallets with protruding nails over the floor, will cause gouging and indentations. ARDEX K 520 is not a resurfacing topping for heavy-duty manufacturing areas or industrial floors or for chemical environments requiring customized industrial toppings. As with any floor covering (wood, soft natural stone, marble, etc.), allowances must be made for scratches or abrasion that occur due to moving or sliding furniture or fixtures over the surface. Keeping the floor surface clean and free of dirt or other contaminants also will help to minimize scratching and abrasion due to foot traffic.

This product is intended for interior use over dry substrates only. Do not use in areas of constant water exposure or in areas exposed to permanent or intermittent substrate moisture, as this may jeopardize the performance of the topping and sealer. This product is not a vapor barrier and will allow free passage of moisture. Follow the directives of the sealer manufacturer regarding the maximum allowable substrate moisture content, and test the substrate prior to installing ARDEX K 520. Where substrate moisture exceeds the maximum allowed, ARDEX recommends the use of an appropriate ARDEX MC™ Moisture Control System. For further information, please refer to the ARDEX technical data sheets.

ARDEX K 520 wear surfaces are not intended to be perfectly homogeneous in appearance. The physical act of spreading and smoothing will result in optical variations in the appearance of the floor even though it is very flat. The aesthetic appearance that is created is subject to possible technical and artistic tolerances. Variations in the overall finished appearance are an intended effect and should be expected.
Technical Data According To ARDEX Quality Standards

Physical properties are typical values and not specifications. All data based on a partial, in-lab mix. Mixing and testing completed at 70°F / 21°C and in accordance with ASTM C1708, where applicable.

Mixing Ratio: 5 quarts (4.73 L) of water per 50 lb. (22.7 kg) bag

Coverage:
- 25 sq. ft. per bag at 1/4” (2.4 sq. m at 6 mm)
- 16.7 sq. ft. per bag at 3/8” (1.6 sq. m at 9.5 mm)
- 12.5 sq. ft. per bag at 1/2” (1.2 sq. m at 12 mm)

Flow time: 10 minutes

Compressive strength (ASTM C109/mod – air cure only): 6,000 psi (420 kg/cm²) at 28 days

Flexural strength (ASTM C348): 1,200 psi (84 kg/cm²) at 28 days

Walkable: 2 - 3 hours

Min. Cure Time prior to coating:
- Waterborne: 24 hours
- Solvent-borne and 100% solids (less than 20 mils/0.5 mm): 48 hours
- High build polymer coating (greater than 20 mils/0.5 mm): 7 days

VOC: 0

Packaging: 50 lb. (22.7 kg) net weight bag

Storage:
- Store in a cool, dry area. Do not leave bags exposed to sun.

Shelf life: 1 year, if unopened

Warranty: ARDEX Engineered Cements Standard Limited Warranty applies.

Made in the USA.

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