



# Self-Leveling Floor Underlayment Cement

## 1. PRODUCT NAME

Akona<sup>®</sup> Self-Leveling Floor Underlayment Cement

## 2. MANUFACTURER

Bluestone Products<sup>™</sup>, a TCC Materials<sup>®</sup> company  
2025 Centre Pointe Blvd, Suite 300  
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## 3. PRODUCT DESCRIPTION

Akona<sup>®</sup> Self-Leveling Floor Underlayment Cement is a high-performance, polymer modified, self-leveling underlayment that provides a flat, extremely smooth, durable surface for finished floor covering installation. It is designed for the fast leveling of floors.

### Features and Benefits

- Provides a smooth surface
- Applications from 1/8–2 in. (3–51 mm) neat and up to 5 in. (127 mm) extended
- Walkable in 3–4 hours
- Accepts non-moisture sensitive tile and stone in 4 hours
- Install moisture sensitive floorcoverings in 16–24 hours
- Encapsulate radiant heat systems

### Uses

- Interior underlayment only
- Level and smooth on, above, or below grade surfaces including concrete, ceramic tile, quarry tile, terrazzo, metal, non-water soluble adhesive residue, and solid wood floors
- For other substrates contact TCC Materials<sup>®</sup>

## SAFETY

READ THE SAFETY DATA SHEET (SDS) BEFORE USING THIS PRODUCT. SDS information is available on our website: tccmaterials.com or contact TCC Materials<sup>®</sup> at 651-688-9116 (7:30 AM to 4:00 PM, M-F, Central US Time).

## CAUTIONS

Read complete cautionary information printed on product container prior to use.

This Product Data Sheet has been prepared in good faith on the basis of information available at the time of publication. It is intended to provide users with information about and guidelines for the proper use and application under normal environmental and working conditions. Because each project is different, TCC Materials<sup>®</sup> cannot be responsible for the consequences of variations in such conditions, or for unforeseen conditions.

## 4. TECHNICAL DATA

Typical Values • Akona Self-Leveling Floor Underlayment Cement	
Flow (ASTM C1708)	140-150 mm
Heal time	20 10 minutes
Final set time (ASTM C191)	25-30 minutes
Compressive Strength (ASTM C109)	
4 hours	> 1,500 psi
24 hours	> 2,500 psi
7 days	> 4,500 psi
28 days	> 5,500 psi
Flexural Strength (ASTM C348)	
24 hours	> 400 psi
28 days	> 600 psi
Length Change, Percentage (ASTM C157)	
28 days in water	< 0.01%
28 days in air	< -0.02%
Bond Strength, Tensile Pull Off, 28 Days (ASTM C1583)	
Concrete	> 300 psi
Ceramic tile	> 140 psi
Exterior grade plywood	> 75 psi

Greater than: > Greater than or equal to: ≥ Less than: < Less than or equal to: ≤

Note: Test results obtained under controlled laboratory conditions at 72°F (22°C) and 50% relative humidity. Reasonable variations can occur due to atmospheric and job site conditions.

### LEED<sup>®</sup> Eligibility<sup>1</sup>

- Regional Materials (MR-c5)
- Low-Emitting Materials (IEQ-c4.3)

### Packaging

50 lb. (22.7 kg.) bag

### Shelf Life

12 months from the date of manufacture when stored in the original, unopened container, away from moisture, under cool, dry conditions and out of direct sunlight.

## 5. INSTALLATION

### Preparation

Acclimate water and powder to room temperatures of 65°F–75°F (18°C–24°C) for a minimum of 24 hours prior to installation. Proper surface repair preparation is crucial to achieving a successful application. Restrict underlayment from moving to unwanted areas by creating small dams constructed of 1"x2" lumber edges wrapped with duct tape. Install expansion joints where underlayment cement meets retraining surfaces such as perimeter walls and sharp corners such as column bases, pedestals, supports, etc. using ¼ in. (6 mm) foam tape or caulking.

### Suitable Substrates (properly prepared) include:

- Concrete
- Cementitious backer units (CBU or cement board)
- APA rated exterior grade/exposure 1 plywood or OSB underlayment grade equivalent
- Cold rolled steel
- Existing ceramic tile

### Concrete Substrates

- Concrete must be fully cured (28 days minimum), free of efflorescence, and not subject to hydrostatic pressure or moisture condensation.
- All surfaces must be stable, solid, and structurally sound.
- Remove all unsound concrete, grease, oil, dirt, paint, sealers, curing compounds, waxes, old adhesive residue, gypsum based underlayments, old flooring, and any other foreign materials that will inhibit adhesion. Mechanical removal is recommended, chemicals often serve to drive them deeper into the concrete substrate.
- Maximum bond over a concrete substrate can be achieved by mechanically profiling the surface either by grinding, shot blasting, sand blasting, or scarifying to achieve an ICRI CSP3 to CSP5 standard. Structurally sound concrete that is porous, and has not been troweled smooth and flat may not require mechanical profiling. Typical applications that fall into this category include precast concrete floor panels, or concrete in new construction that is left unfinished in anticipation of receiving self-leveling underlayment.
- After cleaning and profiling, test for MVER (moisture vapor emission rate, reference ASTM F1869) and concrete substrate's relative humidity (RH, reference ASTM F2170). The requirements of the floor covering and floor adhesive manufacturers must be followed with respect to, but not limited to, levels of moisture.
- Repair deep areas, holes, and non-moving cracks with Feather Patch™ Pro or Feather Edge™ Pro prior to application of self-leveling and allow curing as recommended for the product.
- All surfaces require priming using a primer such as Level-Flo® Primer or Level-Flo® Primer Pro (see "Priming" section).

Note: It is the responsibility of the installer/applicator to ensure the suitability of the product for its intended use.

### Refer to:

ASTM D4259 [Abrading Concrete](#)

ACI 201.1R [Guide for Making a Conditions Survey of Concrete in Service](#)

ACI 224.1R93 [Causes and Repair of Cracks in Concrete Structure](#)

ICRI 03732 [Selecting and Specifying Concrete Surface Preparation for Sealers, Coatings, and Polymer Overlays](#)

### Adhesive and Cutback Residue Over Concrete

- Self-Leveling Floor Underlayment Cement may be installed over properly prepared cutback or adhesive residue that is on concrete only. All residues must be non-soluble when put in contact with water.
- Before proceeding, test the adhesive residue for water solubility. Water soluble adhesive must be removed mechanically to achieve a clean concrete surface.
- Cutback/adhesive residue must be scraped to as thin a layer as possible and no longer be tacky. Any residue must be sound and well bonded to the concrete surface.
- Use only Level-Flo® Primer Pro over the cutback/adhesive residue (see "Priming" section).

### Non-Porous Substrates

- Self-Leveling Floor Underlayment Cement may be installed over non-porous substrates such as epoxy coatings, cold rolled steel, existing ceramic tile, quarry tile, and burnished concrete.
- The substrate must be structurally sound and free from all contaminants such as dust, dirt, grease, and any foreign material that may inhibit adhesion.
- Prepare the surface removing all loose material. Use only Level-Flo® Primer Pro following the mixing instructions on the Primer Pro Technical Data Sheet. Vacuum thoroughly, removing all dust and other loose contaminants before applying the Level-Flo® Primer Pro .

### Wood Subfloors

- Residential and light commercial applications.
- Follow Tile Council of North America (TCNA) F185 installation method for cementitious self leveling underlayments over plywood.
- All wood subfloors must be structurally sound, securely fastened, and have a maximum deflection of L/360 for ceramic tile, or L/720 for stone (including live, dead, impact, and concentrated loads). The wood must be either ¾ in. (19 mm) tongue and groove, APA rated exterior grade/exposure 1 plywood or OSB underlayment grade equivalent.
- The surface must be clean, free from any contaminants that may act as bond breakers such as dirt, paint, wall compound, varnish, grease, oils, or wax. Refasten loose boards.
- Allow a ⅛ in. (3 mm) gap between sheets and fill with Feather Patch™ Pro or Feather Edge™ Pro. Also fill all nail holes or areas where flow could leak.
- Prime clean surface with Level-Flo® Primer (see "Priming" section).
- Securely fasten every 4–6 in. (10–15 cm) either galvanized metal lath or plastic lath designed for this purpose to the wood surface after priming, and prior to applying...

## Wood Subfloors (cont.)

...underlayment cement. Overlap lath edges by ¼ in. (6 mm) and secure using a minimum ⅜ in. (9.5 mm) staple with no gaps, keeping lath flat. Be sure to offset lath joints. To keep the job moving, it is helpful to prime first, then stand on the lath while fastening securely.

Substrate	Primer to Water Ratio	Coverage Sq. Ft. per Gallon
Porous concrete * (two coats may be required for highly porous substrates)	Level-Flo Primer Pro 1:1	330 Sq. Ft. / Gal (30.6 m <sup>2</sup> )
Plywood	Level-Flo Primer Pro 3:1	250 Sq. Ft. / Gal (23.2 m <sup>2</sup> )
Tile / Linoleum / Steel	Level-Flo Primer Pro Full Strength	140 Sq. Ft. / Gal (13 m <sup>2</sup> )

When using Self-Leveling Floor Underlayment Cement over lath, install no less than ¼ in. (6 mm) thickness of self-leveling above the surface of the lath.

Note: Before installing products the installer is responsible for ensuring that the wood subfloor is structurally sound and clean.

## Priming

\* Second coat is required on highly porous substrates if initial application is rapidly absorbed and dries in less than 1 hour. The second coat primer to water ratio is 1:3

- Level-Flo® Primer Pro must be applied over the entire substrate leaving no bare spots, puddles or excess primer. Apply with brush or roller on non-porous surfaces, or push broom on porous surfaces.
- Do not apply over standing water.
- For non-porous substrates, wood, and tight concrete use Level-Flo® Primer Pro.
- Allow the primer to dry to tacky translucent film with no milky wet spots, typically 1–3 hours. If the primer turns clear within 30 minutes of application the substrate is highly porous and requires a second coat. Primer/Primer Pro must be completely dry before installing Self-Leveling Floor Underlayment Cement
- Primer must be reapplied if not covered with Self-Leveling Floor Underlayment within 24 hours or if it becomes contaminated by other trades.

Note: Reference Level-Flo® Primer Pro for more information.

## Job Mockups

The manufacturer requires that when its products are used in any application or as part of any system that includes other manufacturers' products, the contractor and/or design professional shall test all the system components collectively for compatibility, performance and long-term intended use in accordance with pertinent and accepted industry standards prior to any construction. Written documentation of the tests

performed shall be satisfactory to the design professional and contractor. Test results must include the means and methods of application, products used, project-specific conditions being addressed, and standardized tests performed for each proposed system or variation.

## Mixing

### Bucket Mixing

1. In a clean 5 gal. container, add 5 qt. (4.73 L) of clean, cool, potable water. Next add the 50 lb. (22.7 kg) bag of powder, while mixing at full speed using a square mortar paddle mixing blade attached to a heavy-duty ½ in. drill (400–600 rpm). Measure water carefully, be accurate, **do not add extra water.**
2. Mix completely for a minimum of 2 minutes until lump free, adding no additional water. Avoid over watering, over mixing, or moving the mixer up and down during mixing as this will entrap air, lower the strength, and may cause cracking and/or pin-holing. The formation of a white film on the surface is an indication of over watering.
3. For larger jobs, to keep the job moving, it is recommended that multiple mixing containers be used simultaneously. This will allow one mixing container to be poured while the other is being mixed.
4. After use clean all mixing equipment thoroughly to avoid hardened product in subsequent batches.

### Barrel Mixing

1. Mix 2 bags of Self-Leveling Floor Underlayment Cement at a time.
2. In a clean 20–25 gal. container add 5 qt. (4.73 L) of clean, cool, potable water for EACH 50 lb. (22.7 kg) bag. Next add the Self-Leveling Floor Underlayment Cement, while mixing at full speed using an egg-beater mixing blade attached to a heavy-duty ½ in. drill (min. 650 rpm). **Do not add extra water.**
3. Mix completely for a minimum of 2 minutes until lump free, adding no additional water. Avoid over watering, over mixing, or moving the mixer up and down during mixing as this will entrap air, lower the strength, and may cause cracking and/or pin-holing. The formation of a white film on the surface is an indication of over watering.
4. To keep the job moving, it is recommended that multiple mixing drums be used simultaneously. This will allow one mixing container to be poured while the other is being mixed.
5. After use clean all mixing equipment thoroughly to avoid hardened product in subsequent batches.

## Application

Apply only to surfaces that are frost free and between 50°F–90° F (10°C–32°C) for 24 hours prior and 48 hours after application.

1. Close all windows, doors, and HVAC vents to minimize air flow. Divide the areas to permit continuous placement without cold joints.
2. Pour the blended Self-Leveling Floor Underlayment Cement across the floor in a uniform manner to achieve a flat floor and disperse with a gauge rake. Use cleated shoes to avoid leaving marks.

## Application (cont.)

3. To prevent ridges between batches, use a smoother tool and work a narrow dimension, best results are obtained pouring across the shorter distance in the room. Optimum results can be obtained by providing a continuous wet flow throughout the placement, always pouring into a wet edge.
4. Troweling is not recommended, do not overwork material once it is on the floor.
5. Self-Leveling Floor Underlayment Cement has a working time of  $\geq 20$  minutes at 70°F (21°C). Temperatures and humidity will affect flow, working time, and set time.
6. If a higher build-up is needed over the first pour, allow 24 hours drying time between pours and prime surface again with Level-Flo® Primer.
7. Self-Leveling Floor Underlayment Cement will not correct or compensate for a structurally defective substrate. Faults in the substrate can appear in the underlayment. The use of alkali resistant glass fabric or galvanized metal reinforcing (Federal Specification QQL101C) can be helpful in reducing reflective cracking.
8. Typically surfaces will accept foot traffic in 3 to 4 hours, non-moisture sensitive tile and stone in 4 hours, and resilient flooring after 16–24 hours at temperatures of 72°F (22°C).

## Increased Thickness

1. Self-Leveling Floor Underlayment Cement can be extended with aggregate for applications from 1½ in. up to 5 in. (38–127 mm). To extend, blend the Self-Leveling Floor Underlayment Cement with washed, dried, clean ¾ in. (10 mm) pea gravel.
2. Mix first with water then add 15 lb. (6.8 kg) of aggregate per 50 lb. (27.2 kg) bag of Underlayment, mixing until the aggregate is coated, then place.
3. Wet aggregate may cause over watering and the addition of aggregate will reduce the workability and may necessitate a finish coat to obtain a smooth surface finish.
4. Allow the extended layer to dry, normally 24–36 hours.
5. If applying a finish coat, prime the surface with Level-Flo® Primer mixed 1:1 with potable water per priming instructions outlined in the Level-Flo® Primer/Level-Flo® Primer Pro technical datasheet. Finish coat of Self-Leveling Floor Underlayment Cement can be applied after primer has dried.
6. Outgassing can occur when applying multiple lifts.
7. If capping is required, contact TCC Materials®.

## Application Over Radiant Heat Systems

- When radiant heat tube systems are embedded, tubing shall be covered a minimum of ¾ in. (19.1 mm) and installation shall comply with Section 1906.3 of the 2000 International Building Code® (IBC) or Section 1906.3 of the 1997 Uniform Building Code™ (UBC).
- When radiant heat cable systems are encapsulated, wires shall be covered a minimum of ¼ in. (6 mm) and installation shall comply with section RH140 of the Tile Council of North America (TCNA) Handbook.
- An anti-fracture membrane such as Waterproofing & Crack Isolation Membrane should be applied over the cured self-leveling underlayment prior to installation of ceramic tile or stone.

## Expansion and Control Joints

- Honor all existing expansion joints, control joints, and moving cracks through the Self-Leveling Floor Underlayment Cement. Failure to do so could result in delamination or cracking of Level-Flo®.

Note: When vinyl, wood, or other types of floor coverings are to be installed over Self-Leveling Floor Underlayment Cement, the requirements of the floor covering manufacturer are to be followed with respect to, but not limited to, levels of moisture.

## Refer to:

RFCI (Resilient Floor Covering Institute publication) MRP: Addressing Moisture Related Problems Relevant to Resilient Floor Coverings Installed Over Concrete

WFNA (National Wood Flooring Association) publication: Installing Hardwood Flooring, Rev 3/10/98

TCNA (Tile Council of North America) Handbook: Ceramic Tile Installation

American National Standard Specifications: Installation of Ceramic Tile

UBC (Uniform Building Code) 1997 Volume 1, Section 1906.3.10

## Limitations

- Do not use on exterior surfaces.
- Do not trowel or over work.
- Metal or plastic lath design for this purpose is required when going over wood subfloors, it is not needed over concrete surfaces.
- When using Self-Leveling Floor Underlayment Cement over lath, install no less than ¼ in. (6 mm) thickness of self-leveling above the lath surface.
- Do not use as a wearing surface. For a wearing surface, use a Wear Topping.
- Do not over-water, retemper, or add additional additives.
- Reapply primer if first application is allowed to dry past 24 hours or if the floor has become contaminated by traffic or other trades.
- Do not install over dimensionally unstable substrates such as gypsum, gypsum based patching compounds, particle board, luan, asbestos, or chip board.
- Do not install over old tacky or pressure sensitive adhesive residue, paints, sealers, curing compounds, old flooring, and other foreign material.
- Keep out of contact with aluminum or galvanized surfaces.
- Do not allow heavy or sharp metal objects to be dragged directly across the Self-Leveling Floor Underlayment Cement surface. Protect new surface from use until material is completely hard and set.
- For installations over other substrates, contact TCC Materials®.

## Curing

- Protect from excessive drying due to temperatures, air movement, and direct sunlight.
- The use of damp curing or the use of curing compounds is not recommended.
- Turn off all forced-air ventilation whenever possible for up to 24 hours after installation.

## Curing (cont.)

- Allow 14 days curing time before turning on in-floor radiant heating systems, and bring heat up slowly during the first usage.

Note: Self-Leveling Floor Underlayment Cement is not a wearing surface and should be protected from construction trade traffic until the final floor covering is applied.

## Cleaning

Use clean potable water to clean all tools immediately after use. Dried material must be mechanically removed. Use a waste water hardener (e.g. Conglez™ or similar product) for cementitious waste disposal.

## Coverage

Per 50 lb. (22.7 kg) bag

Nominal Thickness	Approximate Coverage
1/8 in. (3 mm)	50 sq. ft. (4.65 m <sup>2</sup> )
1/4 in. (6 mm)	25 sq. ft. (2.32 m <sup>2</sup> )
1/2 in. (12 mm)	12.5 sq. ft. (1.16 m <sup>2</sup> )

Note: Coverage will vary depending on the substrate type, surface texture, and application method.

## 6. AVAILABILITY

To locate products in your area, please contact:

Phone: 1.651.688.9116  
Email: info@tccmaterials.com

## 7. WARRANTY

Seller warrants that its product will conform to and perform in accordance with the product specifications. The foregoing warranty is in lieu of all other warranties, expressed or implied, including, but not limited to those concerning merchantability and fitness for a particular purpose. Because of the difficulty in ascertaining and measuring damages hereunder, it is agreed that Seller's liability to the Buyer shall not exceed the total amount billed and billable to the Buyer for the product hereunder.

## 8. MAINTENANCE

Not applicable.

## 9. TECHNICAL SERVICES

Technical Assistance:

Information is available by calling TCC Materials®  
(hours 7:30 AM to 4:00 PM, M-F, CST):

Phone: 1.651.688.9116

Email: info@tccmaterials.com

Web: tccmaterials.com

Technical and Safety Literature:

To acquire technical and safety literature, please visit our website at: tccmaterials.com.

## 10. FILING SYSTEM

Division 3 and Division 9

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Data Sheets are subject to change without notice. For the latest revision, check our website at tccmaterials.com



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