Note on English translation / Hinweise zur englischen Fassung
This is a translation of the product data sheet valid in Germany.
All stated details and properties are in compliance with the regulations of the German standards and building regulations. They are only applicable for the specified products, system components, application rules, and construction details in connection with the specifications of the respective certificates and approvals.
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Floor Systems

F417a.de

Product Data Sheet 2022-02

N 345 Form

Quick-drying, stable (sag resistant) floor equalization compound from 1 to 45 mm

Product description

N 345 Form is a factory-mixed dry mortar made of special cements, selected aggregates and additives to improve the application properties, ready to be mixed with water.

Cementitious mortar type CT-C50-F8 acc. to EN 13813.

Storage

Store the bags on wooden pallets in a cool and dry environment. Seal damaged and open bags airtight and use first. Can be stored for up to 9 months in the original unopened packaging.

Quality

In compliance with EN 13813, the product is subject to initial type testing and continuous factory production control and bears the CE marking.

Properties and added value

- Stable (sag resistant) levelling compound
- Also for ramps, inclines and tiered surfaces
- Can be applied in a single work step for a layer thickness of 1 to 20 mm
- Can be applied in a single work step for a layer thickness of 20 mm to 45 mm when sand is added
- Quickly ready to be layed
- Very low emission, EMICODE EC 1 PLUS
  For details see www.emicode.com/en
- Very quick hydraulic setting
- Suitable for use on heating screed
- For floors and walls
- For interiors

GEV-EMICODE EC 1 PLUS very low emission

Field of application

N 345 Form is used as a floor equalization compound for:

- Filling of holes and unevenness in cementitious and calcium sulphate screeds, plasters, concrete elements and masonry
- Filling of flaws, holes and cracks
- Levelling and repair of worn steps and damaged step edges
- Bedding of renovation mesh and floor profiles

The requirements of the DIN 18365 apply for floor covering work.

For further information refer to the technical brochures Knauf leveller and equalization compounds F42.de.

Application

Substrate and pretreatment

The maximum permissible moisture content of the substrate may not be exceeded.

Substrate	Maximum moisture content
Cementitious unheated	2.0 CM %
Cementitious heated	1.8 CM %
Calcium sulphate screed unheated	0.5 CM %
Calcium sulphate screed heated	0.5 CM %

The substrate must be firm, stable and free of cracks. Remove and roughen the surface of poorly consolidated and non-stable surface layers, extremely dense and smooth substrates and cement slurries.
Separating layers, e.g. dirt, dust, grease, oil, paint remnants etc. must be removed beforehand.
A primer coat is recommended.

Suitable primers

Cementitious and calcium sulphate based substrates:

- Estrichgrund screed primer
- Schnellgrund primer
- Spezialhaftgrund primer
- FE-Imprägnierung impregnation agent

Trial surfaces should be created in case of doubt or seek expert advice.

Mixing

Mix to a lump-free and application-ready consistence in a clean bucket with clean and cold water (5.75 l per 25 kg bag) using an agitator. A mixer with a speed of 600 RPM with a corkscrew, double-disk agitator or agitating basket is recommended.
If N 345 Form is set for larger layer thicknesses by the addition of silica sand, the quantity of added water should not be increased.

Application

Work in the mixed mortar with a filling knife, compress it and rub it down.

After the mortar has started to stiffen, it can be smoothed, scraped or sponged. Apply at least 1.5 mm on non-absorbent surfaces. Material that has already started to harden should not be mixed with additional water or stirred again.

Observe the technical description for the application of cementitious floor levelling compounds (TKB Technical Briefing Note 9 - Technical Specification and Installation of Floor Levelling Compounds).

Application temperature/climate

Do not apply at room or substrate temperatures below 10 °C and exceeding 30 °C. The best temperature range for application is between 15 °C and 25 °C.
High temperatures speed up the hardening time while low temperatures slow down the hardening process (take temperature of the mixing water into account as well).

Note	Cementitious layers tend to form cracks on soft or residual sticky substrates. Old adhesive remnants, soft or residual tacky layers must therefore be removed from old substrates before priming and filling. The compound layers should not be left exposed for extended periods as it will promote crack formation, e.g. through premature floor covering or priming of the compound layer depending on the system of the floor covering. The setting product should be protected against direct sunlight, draughts, frost, driving rain and temperatures that are too high (> 30 °C) or too low (< 10 °C).

Application time

The prepared floor equalization compound must be applied within about 10 minutes.

Cleaning

Clean containers, tools, etc. with clean water immediately after use. In the hardened state, only mechanical cleaning is possible.

Technical data

Description	Standard	Unit	N 345 Form
Reaction to fire	EN 13501-1	Class	A1/$A1_{fl}$ - non-combustible
Layer thickness ■ Without silica sand ■ With 30 % fire-dried silica sand added 0.7 – 1.2	–	 mm mm	 1 – 20 20 – 45
Layer thickness	–	mm	1 – 45
Hard enough for foot traffic after	–	h	approx. 0.5
Ready to cover at residual moisture (check with CCM tester) ■ For vapour-tight coverings ■ For vapour permeable coverings/tiles	–	 CM-% CM-%	 ≤ 2.5 ≤ 3.0
Ready for floor covering with (20 °C, 65 % relative humidity)	–	min	45
Strengths after 28 days ■ Compressive strength ■ Flexural strength	–	 N/mm² N/mm²	 > 50 > 8
Chair roll resistance from thickness	–	mm	2
Density ■ Mortar (wet) ■ Mortar (dry)	–	 kg/l kg/l	 approx. 1.9 approx. 1.8
Water quantity with agitator application (25 kg bag)	–	l	approx. 5.50
Application time ■ Pot life	–	 min	 approx. 10

The technical data refers to 20 °C and 50 % relative air humidity. Low temperatures delay setting, higher temperatures speed it up.

Material requirement and efficiency

Layer thickness	Consumption approx. in kg/m²
Per mm	1.5

Product range

Name	Application	Packaging unit	Material number	EAN
N 345 Form	25 kg	42 bags / pallet	00531162	4003982379955

Sustainability and environment

Short description	Unit	Value
Requirements of the German AgBB-scheme	–	fulfilled
Complies with the requirements of the French emission class	–	A+
Certificates	–	Emicode $EC1^{PLUS}$

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Observe safety data sheet!
For safety data sheets and CE marking see
pd.knauf.de

Videos for Knauf systems and products can be found under the following link:
youtube.com/knauf

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