

PRODUCT DATA SHEET

Sikadur[®]-32 LP

Epoxy resin Bonding Agent

DESCRIPTION

Sikadur[®]-32 LP is a solvent-free, two component bonding agent, based on selected epoxy resins. Complies with ASTM C 881-78 type II, Grade 2 Class B+C

USES

Sikadur[®]-32 LP may only be used by experienced professionals.

Sikadur[®]-32 LP provides a bond of far greater strength than the tensile strength of the concrete itself. Therefore it is suitable for use as a structural bonding agent for :

- New to existing concrete
- Mortar
- Steel, Iron

CHARACTERISTICS / ADVANTAGES

Sikadur[®]-32 LP has the following advantages:

- Easy to mix and apply
- Solvent free
- Excellent adhesion to most structural materials
- Unaffected by moisture
- Highly effective even on damp surface
- Workable at low temperatures
- High tensile strength
- Longer pot life

APPROVALS / STANDARDS

Conforms to ASTM C 881-78, Type II, Grade 2, Class B+C.

PRODUCT INFORMATION

Chemical Base	Epoxy resin
Packaging	30 kg (A+B) Prebatched Unit : Part A - 20 kg Plastic Container & Part B - 10 kg Plastic Container 6 kg (A+B) Prebatched Unit : Part A - 4 kg Plastic Container & Part B - 2 kg Plastic Container
Colour	Part A: White Part B: Dark gray Part (A+B) mixed: Light gray
Shelf Life	12 months from date of production if stored as per recommendation.
Storage Conditions	Store properly in original unopened, sealed and undamaged packaging, in dry conditions at temperatures between +5°C and +40°C. Protect from direct sunshine.
Density	1.70 kg/l (component A+B mixed) (at +27 °C)

TECHNICAL INFORMATION

Compressive Strength	≥ 55 MPa	7 days @ +30 °C	ASTM C881
Tensile Strength	$\sim 18-20$ MPa	14 days @ +30 °C	ISO 527
Shear Strength	≥ 10 MPa	14 days @ +30 °C	ASTM C882

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 2 : 1 by weight		
Consumption	$\sim 0.3-0.5$ kg/m ² , depending on substrate condition.		
Ambient Air Temperature	+25 °C min. / +40 °C max.		
Substrate Temperature	+25 °C min. / +40 °C max.		
Substrate Moisture Content	When applied to mat moisture concrete, brush the adhesive well into substrate.		
Pot Life	4 hours @ +30 °C		FIP 5.1
	The potlife begins when the resin and hardener are mixed. It is shorter at high temperatures and longer at low temperatures. The greater the quantity mixed, the shorter the potlife. To obtain longer workability at high temperatures, the mixed adhesive may be divided into portions. Another method is to chill parts A+B before mixing them (not below +5°C).		
Open Time	7 hours @ +30 °C		

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

Mortar and concrete must be older than 28 days (dependent on environment and strength). Verify the substrate strength (concrete, mortar).

The substrate surface (concrete, mortar) must be clean and free from frost standing water. Steel substrate must be de-rusted similar to Sa 2.5.

Concrete substrate must be sound and all loose particles must be removed.

SUBSTRATE PREPARATION

Concrete, mortar:

Substrates must be sound, dry, clean and free from laitance, ice, standing water, grease, oils, old surface treatments or coatings and all loosely adhering particles to achieve a laitance and contaminant free, open textured surface. Cement laitance must be removed and the surface to be treated must be mechanically roughened

Steel:

Must be cleaned and prepared thoroughly to an acceptable quality i.e. by blast cleaning and vacuum.

MIXING

The mixing process must be done only after the surface preparation. Sikadur®-32 LP A and B components already have the appropriate mixing ratio. First, mix Part A and B individually. The mixing could be done with low speed electrical mixer (600 rpm) with helical blades for 3 minutes, until the mixture becomes homogeneous grey colour without lumps. Be aware of

the product temperature while mixing to avoid excessive heating. Avoid aeration while mixing. Then, pour the whole mix into a clean container and stir again for approx. 1 more minute at low speed to keep air entrapment at a minimum. Mix only that quantity which can be used within its potlife.

APPLICATION METHOD / TOOLS

Apply the mixed Sikadur®-32 LP to the prepared surface by brush, roller, spray or with a trowel, and ensure uniform and complete coverage. On hardened concrete substrates mechanically prepared to receive fresh concrete, always apply by brush and work the material well into the substrate.

Place the fresh concrete whilst the Sikadur®-32 LP layer is still 'tacky'. If the material becomes glossy and loses tackiness, apply a fresh coat with additional Sikadur®-32 LP and proceed.

CLEANING OF TOOLS

The equipments and tools must be cleaned with solvent before the product hardening. After the hardening, the product can be removed only by mechanical means.

FURTHER DOCUMENTS

After mixing, apply directly to the prepared substrate by brush, roller or spray. On damp surfaces, ensure that it is well brushed in.

Pour new concrete within specified open time, as long as material is still tacky.

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety related data.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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September 2020, Version 02.01
020204030010000120