

PRODUCT DATA SHEET

Sikadur[®]-32 IN

EPOXY RESIN BONDING AGENT

DESCRIPTION

Sikadur[®]-32 IN is a solvent-free, two component bonding agent, based on selected epoxy resins.

USES

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

Sikadur[®]-32 IN 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

- Easy to mix and apply
- Solvent free
- Unaffected by moisture
- Highly effective even on damp surface
- Workable at low temperatures
- High tensile strength

APPROVALS / STANDARDS

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

PRODUCT INFORMATION

Chemical Base	Epoxy Resin	
Packaging	Part A+B Prebatched Unit	3 kg x 2 sets
	Part A	2 kg plastic container
	Part B	1 kg plastic container
Colour	Part A	White
	Part B	Black
	Part A+B Mixed	Light Grey
Shelf Life	12 months from date of production	
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	Part A+B mixed: 1.55 ± 0.05 kg/L (at +27°C)	

TECHNICAL INFORMATION

Compressive Strength	<u>1 day</u>	<u>≥ 15 N/mm²</u>	(ASTM C579)
	<u>7 days</u>	<u>≥ 40 N/mm²</u>	
At curing temperature +30°C			
Tensile Strength in Flexure	≥ 30 N/mm ² (10 days / +30°C)		(EN 196)
Tensile Strength	≥ 18 N/mm ² (14 days / +30°C)		(ISO 527)
Tensile Adhesion Strength	≥ 10 N/mm ² (Concrete dry) (14 days / +30°C)		(ASTM C882)
Shrinkage	Hardens without shrinkage		

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 2 : 1 (by weight)		
Consumption	0.3 - 0.8 kg/m ² , depending on substrate condition		
Product Temperature	+10°C min / +40°C max.		
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	55 minutes (100 g mass at +27 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	55 minutes (100 g mass at +30°C)		(FIP 5.2)

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 blastcleaning and vacuum.

MIXING

Mix parts A+B together for at least 3 minutes with a mixing spindle attached to a slow speed electric drill (max. 600 rpm) until the material becomes smooth in consistency and a uniform grey colour. 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

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.

CLEANING OF TOOLS

Clean all tools and application equipment with Sika® Colma Cleaner immediately after use. Hardened / cured material can only be mechanically removed.

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 Safety Data Sheet (SDS) 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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