

PRODUCT DATA SHEET

Sikadur[®]-42 HES IN

3-part high performance pourable epoxy grout

DESCRIPTION

Sikadur[®]-42 HES IN is a 3-part, high-performance, high precision, pourable, and solvent-free moisture-tolerant epoxy grout which develops high early strength. It is suitable for many static or dynamic precision grouting applications. It has a layer thickness of 25 mm to 75 mm and an application temperature range of +10 °C to +35 °C.

USES

Sikadur[®]-42 HES IN may only be used by experienced professionals.

The Product is used for high-strength grouting and fixing of the following elements:

- Starter bars
- Anchors
- Tie rods
- Fasteners
- Crash barrier posts
- Fence and railing posts

The Product is used for precision under-grouting and bedding of the following elements:

- Machine bases, base plates for light and heavy machinery including heavy-impact and vibratory machinery, reciprocating engines, compressors, pumps and presses
- Bridge bearings
- Mechanical joints in road, bridges, deck, etc.

The Product is used for sleeper-less, direct rail fixing:

- Crane tracks
- Light rail and permanent way in tunnels
- Light rail and permanent way over bridges

The Product is used for repairing the following concrete elements:

- Spalled concrete structures
- Industrial floor slabs
- Hole and void filling
- Runways
- Hardstandings
- Car park decks

The Product is used for interior and exterior applications.

CHARACTERISTICS / ADVANTAGES

- High early strength
- Ready-to-mix, pre-batched units
- Good flowability
- Tolerant to substrates with high moisture content
- Good mechanical resistance
- Very low shrinkage
- Low coefficient of thermal expansion
- Good creep resistance
- Good resistance to vibration
- High reactivity for low temperature application (+10 °C)
- Impermeable to most liquids and water vapour

PRODUCT INFORMATION

Chemical base	Epoxy resin, selected fillers and aggregates	
Packaging	Part A+B+C pre-batched	26.5 kg
	Part A	4.5 kg container
	Part B	1.0 kg container
	Part C	21 kg bag

Shelf life	12 months from date of production
Storage conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +10 °C and +35 °C. Protect from direct sunlight.
Appearance / Colour	Concrete grey flowable paste
Density	~2.0 kg/L (Part A+B+C mixed, +30 °C)

TECHNICAL INFORMATION

Resistance to impact	12 J/m (Izod impact test)	(ASTM D256)										
Effective Bearing Area	> 85 %	(ASTM C1339)										
Compressive strength	<table border="1"> <thead> <tr> <th>Curing time, +30 °C</th> <th>Compressive strength</th> </tr> </thead> <tbody> <tr> <td>1 day</td> <td>~100 N/mm²</td> </tr> <tr> <td>3 days</td> <td>~110 N/mm²</td> </tr> <tr> <td>7 days</td> <td>~115 N/mm²</td> </tr> <tr> <td>28 days</td> <td>~120 N/mm²</td> </tr> </tbody> </table>	Curing time, +30 °C	Compressive strength	1 day	~100 N/mm ²	3 days	~110 N/mm ²	7 days	~115 N/mm ²	28 days	~120 N/mm ²	(ASTM C579)
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Modulus of elasticity in compression	~14 000 N/mm ² (+30 °C)	(ASTM C579)										
Flexural strength	~40 N/mm ² (7 days, +30 °C)	(EN 196)										
Modulus of elasticity in flexure	~14 000 N/mm ² (+30 °C)	(ASTM C580)										
Tensile strength	~20 N/mm ² (7 days, +30 °C)	(ASTM D638)										
Tensile adhesion strength	~20 N/mm ² (Slant Shear Bond Strength at 30 °C, 7 days) ~2 N/mm ² (Pull-Off Bond Strength at 30 °C, 7 days)	(ASTM C882) (EN 1542)										
Heat deflection temperature	+54 °C (7 days, +30 °C)	(ASTM D648)										
Shrinkage	Very low											
Coefficient of thermal expansion	1.9 × 10 ⁻⁵ /K	(ASTM D696)										
Water absorption	~0.05 %	(ASTM D570)										

APPLICATION INFORMATION

Consumption	~2.0 kg/m ² per mm thickness	
Layer thickness	Minimum	25 mm
	Maximum	75 mm per pour
Product temperature	Minimum	+20 °C
	Maximum	+30 °C
Ambient air temperature	Minimum	+10 °C
	Maximum	+35 °C
Mixing ratio	Part A : Part B : Part C = 4.5 : 1 : 21 (by weight)	
Dew point	Beware of condensation. Substrate temperature during application must be at least +3 °C above dew point.	
Substrate temperature	Minimum	+10 °C
	Maximum	+35 °C

Pot life begins when all parts have been mixed. It is shorter at high temperatures and longer at low temperatures. The greater the quantity mixed, the shorter the pot life. To obtain longer workability at high temperatures, the mixed adhesive may be divided into smaller quantities. Alternatively, if the application temperature is above +20 °C, chill parts A+B before mixing.

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.

FURTHER DOCUMENTS

Sika Method Statement : Sikadur Resin Grouts

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

CONCRETE

Concrete must be at least 28 days old. Substrates must be sound, clean, dry or matt damp but free of standing water. Substrates must be free of contaminants such as ice, dirt, oil, grease, coatings, laitance, efflorescence, surface treatments and loose friable material.

STEEL

Surfaces must be sound, clean, dry and free of contaminants such as dirt, oil, grease, coatings and loose friable material.

SUBSTRATE PREPARATION

IMPORTANT

Reduced adhesion due to surface contamination

Surface contaminants such as dust and loose material, including the contaminants generated during substrate preparation, can reduce the Product's performance.

1. Before applying the Product, clean thoroughly all substrate surfaces using vacuum or dust removal equipment.

CONCRETE

Suitable techniques for substrate preparation include the following:

- Abrasive blast cleaning
- High-pressure water blasting
- Needle gunning
- Scabbling
- Bush hammering
- Grinding

1. Prepare the substrate mechanically using a suitable technique.
2. Clean any pockets or holes for structural fixings to remove any debris.

The substrate has an open-textured, gripping surface profile.

STEEL

Suitable techniques for substrate preparation include the following:

- Abrasive blast cleaning
- High-pressure water-blasting
- Grinding

1. Prepare the substrate mechanically using a suitable technique.

The substrate has a bright metal finish with a surface profile to satisfy the necessary tensile adhesion strength requirement.

SHUTTER FORMWORK

Preconditions

Where formwork is to be used, all formwork must be of adequate strength, treated with release agent and sealed to prevent leakage.

1. Prepare the formwork to maintain a minimum 100 mm grout head to assist with placement.

Note: A grout box equipped with an inclined trough attached to the formwork will also improve the grout flow and reduce air voids.

MIXING

IMPORTANT

Poor workability and unfavourable handling time due to wrong mixing

When using multiple units during application, do not mix the following unit until the previous unit has been used.

1. IMPORTANT Mix full units only. Prior to mixing all parts, mix Part A (resin) briefly using a mixing spindle attached to a slow speed electric mixer (max. 300 rpm).
2. Add Part A to Part B (hardener) and mix Parts A+B continuously for at least 3 minutes until a uniformly coloured smooth consistency mix has been achieved.
3. While mixing Parts A + B, gradually add Part C (aggregate).
4. IMPORTANT Do not mix excessively. Mix until a uniform mix is achieved.

APPLICATION METHOD / TOOLS

IMPORTANT

Damage due to excessive long-term load

Sikadur® resins are formulated to have low creep under long-term load. However, due to the creep behaviour of all polymer materials under load, the long-

term structural design load must account for creep.

1. Ensure that the long-term structural design load is lower than 1/4 to 1/5 of the short-term failure load.
2. Consult a structural engineer for calculating the admissible load for the specific application.

GROUTING

1. **IMPORTANT** Maintain a 100 mm grout head to avoid trapping air. Pour the mixed grout into the prepared formwork ensuring continuous grout flow during the complete grouting operation.
2. Where formwork has been used for grouting base plates and machine bases, place sufficient epoxy grout in the formwork to rise slightly above the underside (3 mm) of the grouted base.

FLOWABLE REPAIR

1. Immediately after mixing, pour the mixed material into the formwork or repair area. Ensure a continuous flow.

ADDITIONAL LAYERS

1. Apply additional layers in successive pours once each layer has cooled and hardened sufficiently.

Note: The last layer of a multiple pour must be at least 40 mm.

CLEANING OF TOOLS

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

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

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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