

PRODUCT DATA SHEET

Sikadur®-32+

2-part structural epoxy adhesive for bonding, fixing and anchoring with sustainable benefits

DESCRIPTION

Sikadur®-32+ is a moisture tolerant, structural, 2-part adhesive, based on a combination of epoxy resins and special fillers, designed for use at temperatures between +10 °C and +30 °C.

USES

The Product is used as a structural adhesive for bonding the following:

- Fresh concrete to hardened concrete
- Concrete elements
- Hard natural stone
- Ceramics and fibre cement
- Mortar, bricks, masonry and render
- Iron and steel
- Wood

The Product is used as an adhesive for fixing and anchoring the following:

- Small anchors
- Fasteners
- Railway fasteners

The Product is used as a primer for the Sika® Icosit® KC System:

- On prepared dry and mat damp concrete surfaces
- On prepared metal surfaces

FEATURES

- Application temperature range +10 °C to +30 °C
- Suitable for dry and damp concrete substrates
- Easy to mix and apply
- Very good adhesion to a range of construction materials
- Hardens without shrinkage
- Different coloured parts (for mixing control)
- No primer needed
- High initial and ultimate mechanical strength
- Impermeable to liquids and water vapour
- Good chemical resistance

SUSTAINABILITY

- Contributes towards satisfying Materials and Resources (MR) Credit: Building product disclosure and optimization — Environmental Product Declarations under LEED® v4
- Contributes towards satisfying Materials and Resources (MR) Credit: Building Product Disclosure and Optimization — Material Ingredients under LEED® v4
- Environmental Product Declaration (EPD) in accordance with EN 15804. EPD independently verified by Institut für Bauen und Umwelt e.V. (IBU)

CERTIFICATES AND TEST REPORTS

- CE marking and declaration of performance based on EN 1504-4:2004 Products and systems for the protection and repair of concrete structures — Structural bonding
- CE marking and declaration of performance based on EN 1504-6:2004 Products and systems for the protection and repair of concrete structures — Anchoring reinforcing steel bar

PRODUCT INFORMATION

Product declaration	EN 1504-4: Structural bonding EN 1504-6: Anchoring	
Composition	Epoxy resin	
Packaging	Pre-batched unit Part A + Part B	8 ×1.0 kg container in carton boxes
	Pre-batched unit Part A + Part B	4.5 kg container
	Part A	7.5 kg container
	Part B	15 kg container
	Refer to the current price list for available packaging variations.	
Shelf life	24 months from date of production	
Storage conditions	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging. Refer to the current Safety Data Sheet for information on safe handling and storage.	
Colour	Part A	Light grey
	Part B	Dark grey
	Parts A+B mixed	Concrete grey
Density	Mixed resin at +23 °C.	(1.5 ± 0.1) kg/l

TECHNICAL INFORMATION

Compressive strength	61 N/mm ²			(EN 12190)	
	Curing time	+10 °C	+23 °C	+30 °C	(ASTM D695)
	1 day	5 N/mm ²	35 N/mm ²	-	
	3 days	40 N/mm ²	42 N/mm ²	55 N/mm ²	
	7 days	45 N/mm ²	48 N/mm ²	60 N/mm ²	
	14 days	51 N/mm ²	52 N/mm ²	-	
Modulus of elasticity in compression	Cured 14 days at +23 °C	3300 N/mm ²		(ASTM D695)	
		5000 N/mm ²		(EN 13412)	
Flexural-strength	Curing time	+10 °C	+23 °C	+30 °C	(EN ISO 178)
	1 day	10 N/mm ²	18 N/mm ²	-	
	3 days	35 N/mm ²	37 N/mm ²	-	
	7 days	40 N/mm ²	40 N/mm ²	35 N/mm ²	
	14 days	42 N/mm ²	42 N/mm ²	-	
Modulus of elasticity in flexure	Cured 14 days at +23 °C	3700 N/mm ²		(EN ISO 178)	
Tensile strength	Curing time	+10 °C	+23 °C	+30 °C	(EN ISO 527-2)
	1 day	10 N/mm ²	16 N/mm ²	-	
	3 days	28 N/mm ²	30 N/mm ²	-	
	7 days	34 N/mm ²	35 N/mm ²	-	
	14 days	36 N/mm ²	37 N/mm ²	-	
Modulus of elasticity in tension	Cured 14 days at +23 °C	3800 N/mm ²		(EN ISO 527-2)	
Tensile strain at break	Cured 14 days at +23 °C	(1.4 ± 0.1) %		(EN ISO 527-2)	
Shear strength	11 MPa			(EN 12615)	

Tensile adhesion strength	<u>Pull-Out Resistance</u>	<u>≤ 0.60 mm at load of 75 kN</u>		(EN 1881)	
	<u>Pull-Out railway applications</u>	<u>No damage at 60 kN</u>		(EN 13146-10)	
	<u>Fastening systems</u>	<u>100 kN</u>			
	<u>Bond or adhesion strength</u>	<u>Pass</u>		(EN 12636)	
	Curing time	Substrate	Curing temperature	Adhesion strength	(EN 12188; EN 1542; EN ISO 4624)
	<u>7 days</u>	<u>Concrete dry</u>	<u>+10 °C</u>	<u>> 3 N/mm² 100% concrete failure</u>	
	<u>7 days</u>	<u>Concrete moist</u>	<u>+10 °C</u>	<u>> 3 N/mm² 100% concrete failure</u>	
<u>7 days</u>	<u>Steel</u>	<u>+25 °C</u>	<u>15 N/mm²</u>		
Creep	<u>Durability/Creep under tensile loads</u>	<u>≤ 0.6 mm at load of 50 kN after 3 months</u>		(EN 1544)	
Shrinkage	<u>< 0.1 %</u>			(EN 12617-1)	
Coefficient of thermal expansion	<u>(8.7 × 10⁻⁵ ± 0.1 × 10⁻⁵) 1/K linear expansion between +23 °C and +60 °C</u>			(EN 1770)	
Electrical resistivity	<u>4.3 GΩ</u>			(EN 50122-2)	
Glass transition temperature	<u>+64 °C</u>			(EN 12614)	
Heat deflection temperature	Curing time	Curing temperature	HDT	(ASTM D648)	
	<u>7 days</u>	<u>+23 °C</u>	<u>+47 °C</u>		
Thermal compatibility	<u>Durability</u>	<u>Pass</u>		(EN 13733)	
Resistance to moisture	<u>Sensitivity to water</u>	<u>Pass</u>		(EN 12636)	
Reaction to fire	<u>Class C-s1,d0</u>			(EN 13501-1)	
	<u>Class B_{FL}-s1</u>				

APPLICATION INFORMATION

Mixing ratio	Part A : Part B	1 : 2 by weight or volume																											
Consumption	<p>1.5 kg/m² per mm of thickness, if used as a continuous layer. 0.7 kg/m² –1.0 kg/m² is the quantity normally needed for bonding wet fresh concrete to hardened prepared concrete. For small anchors or fasteners (consumption in grams per hole):</p> <table border="1"> <thead> <tr> <th>Hole/ Re- bar Dia- meter</th> <th>50 mm depth</th> <th>80 mm depth</th> <th>100 mm depth</th> <th>120 mm depth</th> <th>150 mm depth</th> </tr> </thead> <tbody> <tr> <td>10 mm / 6 mm</td> <td>3.8 g</td> <td>6.0 g</td> <td>7.5 g</td> <td>9.0 g</td> <td>11.3 g</td> </tr> <tr> <td>12 mm / 8 mm</td> <td>4.7 g</td> <td>7.5 g</td> <td>9.4 g</td> <td>11.3 g</td> <td>14.1 g</td> </tr> <tr> <td>14 mm / 10 mm</td> <td>5.7 g</td> <td>9.0 g</td> <td>11.3 g</td> <td>13.6 g</td> <td>17.0 g</td> </tr> </tbody> </table>					Hole/ Re- bar Dia- meter	50 mm depth	80 mm depth	100 mm depth	120 mm depth	150 mm depth	10 mm / 6 mm	3.8 g	6.0 g	7.5 g	9.0 g	11.3 g	12 mm / 8 mm	4.7 g	7.5 g	9.4 g	11.3 g	14.1 g	14 mm / 10 mm	5.7 g	9.0 g	11.3 g	13.6 g	17.0 g
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	<p>Note: Consumption data is theoretical and does not allow for any additional material due to surface porosity, surface profile, variations in level, wastage or any other variations. Apply product to a test area to calculate the exact consumption for the specific substrate conditions and proposed application equipment.</p>																												
Layer thickness	Maximum	1 mm																											
Sag flow	Non-sag up to 1 mm thickness on vertical surfaces				(EN 1799)																								
Material temperature	Maximum	+30 °C																											
	Minimum	+10 °C																											
Ambient air temperature	Maximum	+30 °C																											
	Minimum	+10 °C																											
Dew point	<p>Beware of condensation. Steel substrate temperature during application must be at least +3 °C above dew point.</p>																												
Substrate temperature	Maximum	+30 °C																											
	Minimum	+10 °C																											
Pot Life	Temperature	Pot Life (200g)	(ISO 9514)																										
	+10 °C	120 min																											
	+23 °C	45 min																											
	+30 °C	35 min																											
	<p>The potlife begins when Parts A+B 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 smaller quantities. Another method is to chill Parts A+B before mixing (not below +5 °C).</p>																												
Open Time	Temperature	Open Time	(EN 12189)																										
	+10 °C	150 min																											
	+23 °C	90 min																											
	+30 °C	60 min																											

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.

IMPORTANT CONSIDERATIONS

- Sikadur® resins are formulated to have low creep under permanent loading. However, due to the creep behavior of all polymer materials under load, the long term structural design load must account for creep. Generally the long term structural design load must be lower than 20 % to 25 % of the failure load. A structural engineer must be consulted for load calculations for the specific application.

ECOLOGY, HEALTH AND SAFETY

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

CONCRETE, MASONRY, MORTAR OR STONE

Concrete and mortar must be at least 28 days old. Substrates must be sound, clean, dry or matt damp with no standing water. Substrates must also be free from contamination 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 all contaminants such as dirt, oil, grease, coatings and loose friable material.

WOOD

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

CERAMICS OR GLASS

IMPORTANT

Siliconised surfaces

The Product will not adhere to substrates with a siliconised surface.

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

SUBSTRATE PREPARATION

IMPORTANT

Reduced adhesion performance

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

1. Thoroughly clean all substrate surfaces before application of the Product by vacuum or dust removal equipment.

CONCRETE, MASONRY, MORTAR OR STONE

Suitable techniques for substrate preparation include the following:

- Abrasive blast cleaning
- Needle gunning
- Light scabbling
- Bush hammering
- Grinding

1. Prepare the substrate mechanically using a suitable technique.

The substrate has an open textured gripping surface profile.

STEEL

Suitable techniques for substrate preparation include the following:

- Abrasive blast cleaning
- Rotating wire brush
- 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.

WOOD

1. Prepare the substrate by planing, sanding or using other suitable equipment.

CERAMICS OR GLASS

1. Prepare the substrate by sanding or using other suitable equipment.

MIXING

IMPORTANT

Maintaining workability and handling time.

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

PRE-BATCHED UNITS

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. IMPORTANT Do not over mix. To ensure thorough mixing pour materials into a clean container and mix again for approximately 1 minute. Mixing time for A+B = 4 minutes.

APPLICATION

IMPORTANT

Provide temporary support for heavy components positioned vertically or overhead

BONDING APPLICATIONS

1. **IMPORTANT** On damp prepared concrete substrates, always apply by brush and work the Product well into the substrate. Apply the mixed the Product to the prepared substrate by brush, roller, spray or trowel ensuring uniform and complete coverage.
2. For optimum adhesion, apply the adhesive to both substrates that require bonding.
3. For bonding wet fresh concrete to hardened prepared concrete, place the concrete whilst the resin layer is still tacky. Note If the product becomes glossy and loses tackiness, apply another coat and proceed to place concrete.

ANCHORING APPLICATIONS

1. For small anchors or fasteners, clean the hole thoroughly with a special round steel brush and with compressed air (minimum pressure 6 bar), starting from the bottom.
2. Once the hole is completely clean and free of any loose particles or dust, pour the Product in the hole, avoiding entrapping air.
3. Insert the anchor or fastener with a rotary motion within the adhesive open time. Note Some of the adhesive must flow out of the hole.
4. During the resin hardening time the anchor must not be moved or loaded

SIKA® ICOSIT® KC SYSTEM APPLICATIONS

For information on the application of Sikadur®-32+ in conjunction with a Sika® Icosit® KC system, refer to the relevant product Method Statement or contact Sika Technical Service for advice.

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.

LEGAL NOTES

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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PRODUCT DATA SHEET

Sikadur®-32+

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