

# PRODUCT DATA SHEET

## Sikadur<sup>®</sup>-32

Epoxy Based structural bonding primer/ adhesive for bonding new to old concrete.

### DESCRIPTION

Sikadur<sup>®</sup>-32 is a multi-purpose structural epoxy adhesive, with medium viscosity (fluid), two component, for bonding new concrete on old concrete, metal sheets on concrete and use in general anchoring. Eventhough the product has a fluid consistency, it is not self-leveling.

### USES

Sikadur<sup>®</sup>-32 may only be used by experienced professionals.

- Bonding new concrete on old concrete structures
- Structural support fastening
- Cable anchoring
- Bonding precast structural elements
- Construction joints (bonding)
- Fastening of elements, ex. roof drainage pipes and others, horizontally
- Edges repairs, cracks and superficial imperfections on architectural concrete structure

### CHARACTERISTICS / ADVANTAGES

- Easy to apply, fluid, allows the application on horizontal and vertical surfaces (except under beams and slabs)
- Fast curing
- Excellent adherence on concrete, mortar, wood, stone, ceramic, metal and other construction substrates.
- Waterproof (after curing)
- High mechanical properties (tensile and compressive strengths)
- High chemical resistance (oils, grease, etc)

### PRODUCT INFORMATION

<b>Composition</b>	Epoxy resin		
<b>Packaging</b>	Available in 3lt & 18lt kits (A + B)		
<b>Colour</b>	Light grey		
<b>Shelf life</b>	36 months after production date when properly stored.		
<b>Storage conditions</b>	Store in original and sealed packing, in temperatures between +5°C and +35°C. Protect from direct sun light and frost.		
<b>Density</b>	~1,5 kg/l (A+B) (23°C)		
<b>Compressive strength</b>	1 day	60 MPa (23°C; 50% r.h.)	(ASTM D 695)
	7 day	80 MPa (23°C; 50% r.h.)	

<b>Tensile strength in flexure</b>	7 days: ~ 50 MPa (ASTM C 580)	
<b>Tensile adhesion strength</b>	Concrete:	18,4 MPa (14 days) (ASTM C 882)
	Concrete:	3,80 MPa (7 days) - concrete fail Pull Off Test
	Steel:	~ 12 MPa (3 days) Pull Off Test
	Steel bar anchoring pull-of strength in concrete class H25 (Fe A63 - 42H, diam. 12 mm, L=180 mm): >14.000 kgf.	
<b>Service temperature</b>	Min +10°C / Máx +60°C	
<b>Mixing ratio</b>	A : B = 2 : 1 (in weight)	
<b>Consumption</b>	Sikadur®-32 (A + B): 1,50 kg/m <sup>2</sup> per mm of thickness	
<b>Ambient air temperature</b>	Min. +10°C / Máx. +60°C	
<b>Pot Life</b>	1 kg: 45 minutes (23°C)	
<b>Curing time</b>	Initial curing time: 24 hours	
	Final curing time: 7 days	

## SUBSTRATE QUALITY

The surface must be dry, clean, free of contaminants, coatings, dust, oil, grease, formwork release agent, weak concrete layer, steel corrosion, etc.

## MIXING

The mixing process must be done only after the surface preparation. Sikadur®-32 A and B components already have the appropriate mixing ratio. First, mix components A and B individually. The mixing could be done with low speed electrical mixer (400 a 500 rpm) with helical blades for 3 minutes or manually for 5 minutes, until the mixture becomes homogeneous without lumps. Be aware of the product temperature while mixing to avoid excessive heating.

## APPLICATION METHOD / TOOLS

The application should be done with a spatula, brush or similar, filling all the voids and pores. One layer of 1 to 2 mm thickness is enough to promote adherence. Do not dilute the product.

## CLEANING OF EQUIPMENT

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.

## 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.

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## 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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