

PRODUCT DATA SHEET

Sikadur[®]-32 Hi-Mod

HIGH-MODULUS, HIGH-STRENGTH, EPOXY BONDING/GROUTING ADHESIVE

DESCRIPTION

Sikadur[®]-32 Hi-Mod is a multi-purpose, 2-component, 100 % solids, moisture-tolerant structural epoxy adhesive. Suitable for use in hot and tropical climatic conditions.

USES

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

- Bond fresh, plastic concrete to hardened concrete and steel.
- Grout horizontal cracks in structural concrete and wood by gravity feed.
- Machinery and 'robotic' base-plate grout.
- Structural adhesive for concrete, masonry, metal, wood, etc

CHARACTERISTICS / ADVANTAGES

- High-strength bonding/grouting adhesive
- Tolerant to moisture before, during and after cure
- Excellent adhesion to most structural materials
- Convenient easy-to-mix ratio A:B = 1:1 by volume
- Easy-to-use for bonding/grouting applications
- Rapid gain to ultimate strengths

APPROVALS / CERTIFICATES

Sikadur[®]-32 Hi-Mod conforms to the current ASTM C-881 Types I, II, and V, Grade 2, Class C and AASHTO M-235 specifications.

PRODUCT INFORMATION

Composition	Epoxy resin		
Packaging	Standard unit: 7.07 kg		
	Component :A	Component :B	Component :A+B
	2.82 kg	4.25 kg	7.07 kg
	Bulk packaging: 568 kg		
	Component :A	Component :B	Component :A+B
	227 kg	341 kg	568 kg
Shelf life	2 years in original, unopened containers		
Storage conditions	Stored properly in original, unopened, sealed and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Protect from direct sunlight, heat and moisture.		
Viscosity	4000 – 5,000 cps.		(ASTM D445)
Water absorption	~0,21 % (7 days, 24 h immersion)		(ASTM D570)

TECHNICAL INFORMATION

Compressive strength	3 days (23 °C)	~60 N/mm ²	(ASTM C579)
	14 days (23 °C)	~86 N/mm ²	
*Material cured and tested at the temperatures indicated.			
Tensile strength in flexure	~57.5 N/mm ² (14 days, 23°C, 50 % R.H.)		(ASTM D790)
Tensile strength	~39 N/mm ² (23 °C, 50 % R.H.)		(ASTM D638)
Tensile strain at break	~2.2 %		(ASTM D638)
Tensile adhesion strength	14 days (moist cure, 23 °C, 50 % R.H.)	Plastic Concrete to Hardened Concrete	~18.5 N/mm ² (ASTM C882)
		Plastic Concrete to Steel	~13.5 N/mm ²
Heat deflection temperature	~50°C		(ASTM D648)

APPLICATION INFORMATION

Mixing ratio	Component 'A': Component 'B' = 1:1 by volume, 1:1.5 by weight	
Consumption	~1.41 kg/m ² per 1 mm of thickness. *This figure is theoretical and does not allow for any additional material due to surface porosity, surface profile, variations in level or wastage, etc.	
Ambient air temperature	+20°C min. / +40°C max.	
Dew point	Beware of condensation and dew point conditions. Substrate temperature during application must be at least 3°C above dew point.	
Substrate temperature	+20°C min. / +40°C max.	
Pot Life	Time	Product quantity
	~25 minutes	350 g
	~35 minutes	60 g
Contact time	Temperature	Time
	4 °C	15-16 hours
	23 °C	2 - 2.5 hours
	32 °C	1.5 - 2 hours

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes and any other contaminants.

SUBSTRATE PREPARATION

Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or other equivalent mechanical means. Steel - Should be cleaned and prepared thoroughly by blast cleaning or other equivalent mechanical means.

MIXING

Pre-mix each component. Proportion equal parts by volume of Component 'A' and Component 'B' into clean pail. Mix thoroughly for 3 minutes with the proper paddle on low-speed (400-600 rpm) drill until blend is a uniform color. Mix only that quantity that can be applied within its pot life.

APPLICATION METHOD / TOOLS

To bond fresh concrete to hardened concrete - Apply by brush, roller, broom or spray. Place fresh concrete while Sikadur®-32 Hi-Mod, is still tacky. If coating becomes glossy and loses tackiness, remove any surface contaminants then recoat with additional Sikadur®-32 Hi-Mod, and proceed.

To grout baseplates - Add up to 1 1/2 parts of oven-dried aggregate to 1 part of mixed Sikadur®-32 Hi-Mod, by volume. Place grout under baseplate.

Avoid contact with the underside of the plate. A 6 to 10 mm space should remain between the top of the grout and the bottom of the plate. Maximum thickness of grout per lift is 38 mm. If multiple lifts are needed, allow preceding layer to cool to touch before applying additional layer. The remaining 6 to 10 mm space should be filled with neat Sikadur®-32 Hi-Mod. Pour a sufficient quantity of neat epoxy to allow the level to rise slightly higher than the underside of the bearing plate. Please contact Sika Technical services department for more details

To gravity feed cracks - Pour neat material into V-notched crack. Continue placement until completely filled. Seal underside of slab prior to filling if cracks reflect through using Sikadur®-31 CF Slow.

CLEANING OF EQUIPMENT

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

IMPORTANT CONSIDERATIONS

- For spray applications, consult Sika Technical Service
- Use only oven-dry aggregate.
- Material is a vapor barrier after cure.
- For applications on exterior, on-grade substrates, consult Sika Technical Services
- Do not apply over wet, glistening surface.
- Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.

BASIS OF PRODUCT DATA

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

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.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets before using any products. 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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All products are supplied under a management system certified to conform to the requirements of the quality, environmental and occupational health & safety standards ISO 9001, ISO 14001 and OHSAS 18001.

Sikadur-32Hi-Mod-en-AE-(09-2020)-1-1.pdf

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September 2020, Version 01.01
020204030010000129

