

**Product Data Sheet**  
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Sikadur®-32 LP

# Sikadur®-32 LP

## Epoxy resin bonding agent

### Product Description

Sikadur®-32 LP is a solvent-free, two component bonding agent, based on selected epoxy resins. Complies with ASTM C 881-78 type II, Grade 2 Class B+C

### Uses

Sikadur®-32 LP 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
- Excellent adhesion to most structural materials
- Unaffected by moisture
- Highly effective even on damp surface
- Workable at low temperatures
- High tensile strength
- Longer pot life

### Tests

**Approval / Standards** Conforms to ASTM C 881-78, Type II, Grade 2, Class B+C.

### Product Data

#### Form

**Colours**  
Part A: white  
Part B: black  
Part A+B mixed: light grey

**Packaging**  
30 kg (A+B) Pre batched unit  
Part A: 20 kg plastic container  
Part B: 10 kg plastic container  
6 kg (A+B) Pre batched unit  
Part A: 4 kg plastic container  
Part B: 2 kg plastic container

#### Storage

**Storage Conditions / Shelf Life** 12 months from date of production if stored properly in original unopened, sealed and undamaged packaging, in dry conditions at temperatures between +5°C and +40°C. Protect from direct sunshine.

#### Technical Data

**Chemical Base** Epoxy resin.

**Density** 1.70 kg/l (part A+B mixed) (at +27°C)

Construction



<b>Change of Volume</b>	Shrinkage / Creep: Hardens without shrinkage.
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## Mechanical / Physical Properties

<b>Compressive Strength</b>	(According to ASTM C 881)	
	Curing time	+30°C
	7 days	≥ 55 N/mm <sup>2</sup>

<b>Flexural Strength</b>	(According to IS 9162-1979)	
	Curing time	+30°C
	10 days	30 - 35 N/mm <sup>2</sup>

<b>Tensile Strength</b>	(According to ISO 527)	
	Curing time	+30°C
	14 days	18 - 20 N/mm <sup>2</sup>

<b>Bond Strength</b>	(According to ASTM C 882)			
	Curing time	Temperature	Substrate	Bond strength
	14 days	+30°C	Concrete dry	≥ 10 N/mm <sup>2</sup> *

**Strength Development** Confirm the strength development by producing cubes on site and testing them for compressive and flexural strength.

## System Information

### Application Details

**Substrate Quality** Mortar and concrete (old one) must be hardened (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, 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 blast cleaning and vacuum.

### Application Conditions / Limitations

<b>Substrate Temperature</b>	+25°C min. / +40°C max.
<b>Ambient Temperature</b>	+25°C min. / +40°C max.
<b>Material Temperature</b>	Sikadur <sup>®</sup> -32 LP must be at a temperature of between +10°C and +40°C for application.
<b>Substrate Humidity</b>	When applied to mat moisture concrete, brush the adhesive well into substrate.

## Application Instructions

**Mixing** Part A : Part B = 2 : 1 (by weight)

**Mixing Time**



Pre-batched units

Pre-stir each component before mixing. Mix parts A+B together for at least 3 minutes with a mixing spindle attached to a slow speed electric drill (max. 500 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 pot life.

**Application Conditions / Limitations**

After mixing, apply directly to the prepared substrate by brush, roller or spray. On damp surfaces, ensure that it is well brushed in.

When applying as a repair mortar uses some formwork.

Pour new concrete within specified open time, as long as material is still tacky.

**Coverage**

0.3 – 0.5 kg/m<sup>2</sup>, depending on substrate condition

**Cleaning of Tools**

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

**Pot life**

(According to FIP 5.1)

Temperature	Sikadur®-32 LP
30°C	4 hours

The pot life 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 pot life. 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**

Temperature	Sikadur®-32 LP
30°C	7 hrs

**Notes**

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.

**Health and Safety Information**

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

**Legal Notes**

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