

PRODUCT DATA SHEET

Sikadur[®]-31 Normal

STRUCTURAL EPOXY ADHESIVE FOR GLUING OF VARIOUS BUILDING MATERIALS

DESCRIPTION

It is an epoxy adhesive of two components, with paste consistency, to bond all type of construction elements. Adhere to dry or wet absorbent surfaces or dry metal surfaces.

USES

Sikadur[®]-31 Normal may only be used by experienced professionals.

- For the gluing of elements such as: prefabricated, beams, stairs, railings, etc.
- For the fixing of prefabricated facade elements and the assembly of concrete elements (piles, porticoes, etc.).
- To make batches among the most diverse construction materials such as: concrete, asbestos-cement, brick, stoneware, ceramics, steel, aluminum, wood, glass, etc.
- As a high resistance to abrasion in the repair and protection of hydraulic structures such as: dumps, canals, loading tunnels, etc.

PRODUCT INFORMATION

Packaging	Unit: 6.0 kg and Unit: 30 kg
Colour	Grey
Shelf life	36 months (3) years from its date of production.
Storage conditions	Store in its original container tightly closed, in a cool place and indoors. Transport with normal precautions for chemicals.
Density	1,90 kg/l ± 0,05 kg/l a 20°C
Consistency	Soft paste, does not drain
Compressive Strength	1 day 35 MPa 7 days 55 MPa (AS 1478.2)

CHARACTERISTICS / ADVANTAGES

- It has high mechanical resistance.
- Adhere on dry wet or metallic absorbent surfaces.
- Easy to apply, even on vertical surfaces and overhead.
- Do not drain applied in thicknesses up to 2 cm.
- No contraction.
- Moderate chemical resistance.

APPROVALS / CERTIFICATES

Compliant Standards ASTM C 881-02, Type I, Grade 3, Class B and C. Drinking Water Approvals: Water Regulations Advisory Scheme (WRAS), England, Report No. 5460. Center de Recherche et de Control des Eaux Paris (CRECEP). France, Report No. C-95-M3965 and 603583. Technical Office of Studies and Controls, Spain. Report No. 4002.

Service Temperature	Substrate temperature: • Minimum: 5°C • Maximum: 40°C
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APPLICATION INFORMATION

Mixing Ratio	By weight and by volume A: B = 2: 1
Consumption	Approximately 1.7 kg/m ² per mm of thickness.
Substrate Temperature	Low: 5°C High: 40°C
Pot Life	Normal version (Approx. Times) 2 kg
	10°C 85 min
	20°C 45 min
	30°C 25 min

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

Concrete, asbestos cement, stone, brick, stoneware: Surface must be clean, free of loose parts, contamination of oils, dust, heater residue, cementitious grout or other foreign matter.

The surface may be dry or wet but free of settling. The age of the concrete or mortar elements must be at least 28 days.

MIXING

Shake each component separately. The two components have different colors to facilitate control over the homogeneity of the mixture. Pour Component B completely over Component A and mix with a low resolution drill (maximum 400 rpm) or manually until a uniform color mixture is obtained.

Component A exposed to low storage temperatures (less than 8°C) may harden, but will recover its original condition with light heating (leaving it exposed to the sun or by friction of the same material by mixing it).

APPLICATION METHOD / TOOLS

The application is made with spatula, flat or directly with the gloved hand. The product is applied on one of the two sides and pressed until a perfect paste is obtained. In case of application to damp absorbent surfaces, the product should be strongly rubbed onto the surface with the gloved hand. Wash hands with soap and water after application. The tools are cleaned with Colma Solvent Epoxy when the product is still fresh. The hardened product must only be removed by mechanical means.

CLEANING OF EQUIPMENT

Sand jet, water jet, grateful metal, polisher.

- Steel, iron, aluminum: Free from contamination of fats, oils, oxidation lime scale.

The surface must be dry and should not be fogged by

condensation.

Sand jet, pressurized water jet. (Clean to commercial grade in accordance with the standards of the American Standard SSPC-SP6).

Note: The application must be carried out immediately after the metal surface has been cleaned.

- Ceramics, glass: Free from contamination of fats, oils and dries.

Sand, wash and dry the ceramic or glass surface.

IMPORTANT CONSIDERATIONS

Sikadur®-31 Normal contains hardeners which are harmful before the final curing of the product. The ambient temperature during application must be at least 3°C above the dew point.

Welding should not be applied to metallic elements glued with the epoxy adhesive, as the maximum permissible service temperature of the adhesive will probably be exceeded, with softening or damage of the adhesive and failure of the adhesive.

In the case of segmented bridges depending on the construction system employed, the use of type VI or type VII adhesive according to ASTM C 881 as Sikadur 31 SBA may be required. Consult the Technical Department.

The service temperature of the glue system must be below the deflection temperature (HDT) of the adhesive.

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.

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

Keep out of reach of children. Wear rubber gloves and goggles for handling, apply in ventilated areas and change contaminated clothing.

Refer to Material Safety Data Sheet from Sika Technical Department.

DIRECTIVE 2004/42/CE LIMITATION OF EMISSIONS OF VOC

< 70

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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Product Data Sheet

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