

## PRODUCT DATA SHEET

# Sikadur® Hex-300

HIGH-MODULUS, HIGH-STRENGTH, 2-PART EPOXY IMPREGNATING RESIN USED WITH SIKAWRAP STRUCTURAL STRENGTHENING SYSTEMS

### DESCRIPTION

Sikadur® Hex-300 is a two-component 100% solids, moisture-tolerant, high strength, high modulus epoxy. Sikadur® Hex-300 is an unfilled primer or impregnation resin with an extra-long pot life and a slow curing speed. Sikadur® Hex-300 is compliant with the 2012 and 2009 International Building Codes (IBC) and the 1997 Uniform Building Code (UBC) per ICC-ES Evaluation Report ESR- 3288.

### USES

Sikadur® Hex-300 may only be used by experienced professionals.

- Impregnating resin for SikaWrap® fabric reinforcement for the wet application.
- Primer resin for the wet application system.
- Used as a seal coat and impregnating resin for horizontal and vertical applications.

### FEATURES

- Easy mix and application by trowel and impregnation roller
- Manufactured for manual or mechanical saturation methods
- High mechanical properties
- Extra-long pot life
- Tolerant of moisture before, during and after cure
- High strength, high modulus adhesive
- Excellent adhesion to concrete, masonry metals, wood and most structural materials
- Fully compatible and developed specifically for the SikaWrap® System
- High temperature resistance
- High abrasion and shock resistance
- Solvent-free, VOC compliant

### CERTIFICATES AND TEST REPORTS

- 2009 & 2012 International Building Codes (IBC)
- 1997 Uniform Building Code (UBC) per ICC-ES Evaluation Report ESR-3288.

### PRODUCT INFORMATION

<b>Packaging</b>	15 lt kits
<b>Shelf life</b>	24 months from date of production if stored properly in original, unopened and undamaged sealed packaging
<b>Storage conditions</b>	Store in original, unopened, sealed and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Protect from direct sunlight.
<b>Colour</b>	Component A: light-yellow to amber liquid Component B: pale yellow to clear liquid Components A + B mixed: light-yellow to clear liquid
<b>Density</b>	1.16 kg/l (component A+B mixed) (at +23 °C)

Viscosity	Temperature		Viscosity
	+15 °C		~2,000 cps
	+23 °C		~700 cps
	+40 °C		~200 cps

## SYSTEM INFORMATION

<b>System structure</b>	Substrate primer - Sikadur®-330 / Sikadur® Hex-300. Impregnating/laminating resin - Sikadur® Hex-300. Structural strengthening fabric - SikaWrap® type to suit requirements.
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## TECHNICAL INFORMATION

Compressive strength	4 °C	23 °C	32 °C	(ASTM D-695)	
	3 days	-	~55 MPa		-
	7 days	~7.0 MPa	~75 MPa		>80 MPa
	28 days	-	~80 MPa		-

*Material cured and tested at the temperatures indicated and 50 % R.H.*

<b>Modulus of elasticity in compression</b>	2,620 MPa (7 days)	+23°C, 50%R.H
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<b>Modulus of elasticity in flexure</b>	~ 3,500 MPa (+23 °C, 50 % R.H) ~ 4,130 MPa (+60 °C, 50 % R.H, post cured min. 48hrs)	(ASTM D-790)
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<b>Tensile strength</b>	~41 MPa (+23 °C, 50 % R.H) ~70 MPa (+23 °C, 50 % R.H, post cured min. 48hrs)	(ASTM D-638)
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<b>Modulus of elasticity in tension</b>	~ 3,500 N/mm2 (7 days at +23 °C)	(ISO 527)
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<b>Tensile strain at break</b>	3.2 % (+23 °C, 50 % R.H) 4.8 % (+60 °C, 50 % R.H, post cured min. 48hrs)	(ASTM D-638)
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<b>Service temperature</b>	-40 to +45 °C
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Glass transition temperature	Curing time	Curing temp	TG	(EN 12614)
	30 days	+30 °C	+53 °C	

Heat deflection temperature	Curing time	Curing temp	HDT	(ASTM D 648)
	7 days	+15 °C	+43 °C	
	7 days	+23 °C	+49 °C	
	3 days	+40 °C	+60 °C	
	7 days	+40 °C	+66 °C	

## APPLICATION INFORMATION

<b>Mixing ratio</b>	Mix entire unit, do not batch down
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<b>Consumption</b>	See the "Method Statement for SikaWrap® manual wet application" Ref. 850 41 03 and the "Method Statement for SikaWrap® saturator machine wet application" Ref 850 41 04. Guide: 0.4–1.0 kg/m2.
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<b>Ambient air temperature</b>	+15 °C min. / +40 °C max.
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<b>Dew point</b>	Beware of condensation. Substrate temperature during application must be at least 3 °C above dew point.
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<b>Substrate moisture content</b>	< 4 % pbw
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**Pot Life**

Temperature	Potlife	Open time
+15 °C	~6 hours	~3 hours
+23 °C	~4 hours	–
+40 °C	~90 minutes	~60 minutes

(EN ISO 9514)

The potlife 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 potlife. To obtain longer workability at high temperatures, the mixed adhesive may be divided into portions. Another method is to chill components A+B before mixing them (not below +5 °C).

**Curing time**

~ 12–14 hours

(Tack Free)

**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**

This product may only be used by experienced professionals.

Sikadur® Hex-300 must be protected from rain for at least 24 hours after application. Ensure placement of fabric and laminating with roller takes place within open time.

For application in cold or hot conditions, pre-condition material for 24 hours in temperature controlled storage facilities to improve mixing, application and pot life limits.

For further information on over coating, number of layers or creep, please consult a structural engineer for calculations and see also the "Method Statement for SikaWrap® manual wet application" Ref 850 41 03 and the "Method Statement for SikaWrap® saturator machine wet application" Ref 850 41 04.

Sikadur® resins are formulated to have low creep under permanent loading. However due to the creep behaviour 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 20-25% of the failure load. Please consult a structural engineer for load calculations for your specific application.

**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.

**APPLICATION INSTRUCTIONS****SUBSTRATE QUALITY**

The substrate must be sound and of sufficient tensile strength to provide a minimum pull off strength of 1.5 N/mm<sup>2</sup> or as per the requirements of the design specification ACI 440.2R, AS5100.8:2017 or Vic Roads Spec Section 688: 2018 .

See also the "Method Statement for SikaWrap® manual wet application" Ref 850 41 03 and the "Method Statement for SikaWrap® saturator machine wet ap-

plication" Ref 850 41 04.

**SUBSTRATE PREPARATION**

See the "Method Statement for SikaWrap® manual wet application" Ref 850 41 03 and the "Method Statement for SikaWrap® saturator machine wet application" Ref 850 41 04.

**MIXING**

Pre-batched units:

Mix components A+B together for at least 3 minutes at low speed. 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.

Bulk packing, not pre-batched:

Add the components in the correct proportions into a suitable mixing pail and stir correctly using an electric low speed mixer as above for pre-batched units.

**APPLICATION METHOD / TOOLS**

See the "Method Statement for SikaWrap® manual wet application" Ref 850 41 03 and the "Method Statement for SikaWrap® saturator machine wet application" Ref 850 41 04.

**CLEANING OF EQUIPMENT**

Clean all equipment immediately with Sika® Colma Cleaner. Cured material can only be removed mechanically.

**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

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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