

Sikadur[®]-32 Normal

High performance epoxy tie coat for concrete screeds and toppings

Positioning Description	Sikadur [®] -32 Normal is a solvent free epoxy resin bonding agent. It has been designed to enable the bonding of freshly mixed concrete or mortar to hardened concrete or structural materials.
Uses	<ul style="list-style-type: none">• Sikadur[®]-32 Normal provides a bond far greater than the tensile strength of concrete itself. Therefore it is suitable for use wherever structural bonding of new to existing concrete is carried out.• Sikadur[®]-32 Normal can also be used for bonding concrete and mortar to other substrates such as steel, iron, fibre cement sheeting, cured epoxy coatings, timber, brick and block work.• Typical applications for Sikadur[®]-32 Normal are:<ul style="list-style-type: none">• Bonding of new concrete screeds to existing floors.• Bonding of plaster toppings and overlays to existing substrates.• Bonding new concrete to old at construction joints.• Bonding of tile bedding mortars to existing substrates.
Advantages	<ul style="list-style-type: none">• Can be applied to dry or damp surfaces.• Easy to apply, solvent free.• Excellent adhesion to most building substrates.• Prevents curling problems that arise from unbonded thin slabs and toppings.• High tensile and flexural strengths.
Approvals / Standards	Tested in accordance with BS6319. Complies with ASTM C881-78, Type Grade 2, Class B & C.
Product Data	
Type	Solvent free epoxy resin liquid.
Colours	Component A = White Component B = Grey Grey/Beige colour when mixed.
Packaging	Supplied in 0.87 litre (1.2kg), 3 litre and 18 litre containers.
Storage & Shelf Life	Three (3) years in unopened original containers when stored in cool dry conditions between 5°C and 25°C.
Technical Data	
Density:	Approx. 1.4kg/litre.
Service temp:	< 70°C
Application temp:	5°C to 30°C
Shrinkage:	Negligible
Compressive strength:	60 - 70MPa approx. (at 20°C)
Flexural strength:	28 - 35MPa approx.
Tensile strength:	18 - 20MPa approx.
Elastic modulus:	2.0GPa approx.
Bond strength:	Sandblasted Steel = approx. 20MPa Sandblasted Concrete = 3.5MPa (concrete failure)
Pot life (3 litre mix): (Approx.)	5°C 10°C 20°C 30°C 120 mins 50 mins 30 mins 15 mins



Open time:	20°C= 60 minutes approx. 30°C= 30 minutes approx.
Coverage rate:	1 litre = 1 - 3.5m ² depending on surface porosity and conditions. Temperature will also affect coverage, as Sikadur [®] -32 Normal thickens when temperature falls.

Application Conditions

Surface Preparation	<p><i>Mineral Substrates:</i></p> <ul style="list-style-type: none"> All surfaces must be clean, free from standing water and all loosely adhering particles or any surface contaminants such as dirt, oil, dust, grease, etc. All cement laitance should be removed by scabbling, sandblasting, etc. The minimum preparation for new concrete is treatment with a 10% hydrochloric acid solution. Old and contaminated concrete must be scabbled or blast cleaned to a depth that removes all contamination. If in doubt adhesion pull off tests should be carried out. Minimum pull off strength should be 1.5MPa. <p><i>Iron Steel:</i></p> <ul style="list-style-type: none"> All paints, films, oils and Sikadur[®]-32 Normal immediately after blasting is complete to prevent rust from recurring.
Mixing	<ul style="list-style-type: none"> Add the entire contents of Component B to Component A. Using a Sika mixing paddle attached to a low speed electric drill (max. 500 rpm), mix together until a smooth streak free consistency is achieved. Part batching of Sikadur[®]-32 Normal is not recommended unless strict measurement of components, in accordance with the mix ratio of the factory proportioned pack, is observed and adhered to.
Application	<ul style="list-style-type: none"> Apply a thin and uniform layer of Sikadur[®]-32 Normal to the prepared surface using a brush, roller or notched trowel. Ensure that the product is worked well into the substrate. This is particularly important on damp surfaces. The fresh concrete or mortar must be applied while the Sikadur[®]-32 Normal is still 'tacky' (i.e. within its open time). If the surface is no longer 'tacky', bond will not be achieved. Another coat must be applied within 24 hours.
Cleaning	<ul style="list-style-type: none"> Clean all tools and equipment immediately after use with Sika Thinner C. Cured Sikadur[®]-32 Normal can only be removed mechanically. It is recommended that protective gloves and clothing be worn during application, however uncured Sikadur[®]-32 Normal may be removed from skin with warm soapy water.
Important Notes	<ul style="list-style-type: none"> Do not apply Sikadur[®]-32 Normal to surfaces with standing water on them. Sikadur[®]-32 Normal will not cure at temperatures below 5°C. Do not dilute Sikadur[®]-32 Normal with any form of solvent. Lower substrate and ambient temperatures during storage and application will increase material consumption due to a rise in viscosity. If the Sikadur[®]-32 Normal has exceeded its open time ('tackiness') another coat must be applied within 24 hours. After 24 hours the surface must be mechanically abraded then washed clean with Sika Thinner C. Allow to dry before recoating.
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.
Local Restrictions	Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

Safety Instructions

Protective Measures	<ul style="list-style-type: none"> To avoid rare allergic reactions, we recommend the use of protective gloves. Change soiled work clothes and wash hands before breaks and after finishing work. Local regulations as well as health and safety advice on packaging labels must be observed.
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Transportation Class	Sikadur®-32 Normal, Component B has a dangerous goods classification for transportation: Haz. Class 8, UN No. 1759, Haz. Chem. 2X, Packing Group III.
Important Notes	Residues of material must be removed according to local regulations. Fully cured material can be disposed of as household waste under agreement with the responsible local authorities. Detailed health and safety information as well as detailed precautionary measures e.g. physical, toxicological and ecological data can be obtained from the safety data sheet.

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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