

PRODUCT DATA SHEET

Sikadur®-30 Colle

EPOXY ADHESIVE FOR RIGID SEALING AND BONDING

DESCRIPTION

Sikadur®-30 Colle is a 2-component, epoxy resin-based, thixotropic structural adhesive. Low moisture sensitivity and high adhesion to most substrates. It has high mechanical strength and is used for bonding structural reinforcement and structural strengthening using steel or Sika® CarboDur® plates.

USES

Sikadur®-30 Colle may only be used by experienced professionals.

- A thixotropic adhesive that caters for irregularities in the substrate, while ensuring a perfect, fast seal and bond.
- Reinforcement of structures with bonded sheet metal or composite materials (Sika® CarboDur®).
- Bonding of all prefabricated concrete elements (bridge segments, etc.).
- Bonding elements to even smooth supports (brackets, stair treads, sidewalk curbs).
- Bonding tiles, metal plates or parts, etc.
- Bonding hardened concrete to hardened concrete.
- Resurfacing, reprofiling or levelling.
- Sealing (floor, wall or ceiling).
- Rigid bonding of narrow joints.

FEATURES

- Very strong adhesion to most substrates: concrete, mortar, stone, brick, fibre cement, steel (other substrates on request).
- Impermeable to liquids and water vapour
- High resistance to common chemical agents at ambient temperature: slightly concentrated acids, bases, salts and brines, very pure water, wastewater, oils and fuels.
- Applicable on underside.
- Hardens quickly.
- High mechanical resistance.
- Easy to mix and apply.
- Complies with NF P18870 as a class 1 structural bonding product.

CERTIFICATES AND TEST REPORTS

- Complies with the requirements of NF EN 1504-4 (structural bonding).
- Technical Approval n°3/16-875 - Sika® CarboDur® process.
- IBMB, TU Braunschweig, test report no. 1871/0054, 1994: Approval of Sikadur®-30 epoxy adhesive.
- IBMB, TU Braunschweig, test report no. 1734/6434, 1995: Testing of Sikadur®-41 epoxy mortar in combination with Sikadur®-30 epoxy adhesive for bonding steel plates.

PRODUCT INFORMATION

Packaging	1,2 kg (Comp A = 0.9+Comp B= 0.3)	pre-batched kit, box of 8 kits x 1.2 kg
	6 kg (Comp A = 4,5+Comp B =1.5)	pre-batched kit
Colour	Composant A :	white
	Composant B :	black
	Part A+B mixed	light grey
Shelf life	24 months from date of production	
Storage conditions	Store in original, unopened and undamaged packaging in dry conditions at	

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temperatures between +5 °C and +30 °C. Protect from direct sunlight.

Density	Comp A	1.65 kg/l ± 0.1 kg/l	+ 23°C
	Comp B	1.65 kg/l ± 0.1 kg/l	+23°C
	Comp A+B	1.65 kg/l ± 0.1 kg/l	+23°C
	(Raw density of mixture)		
Compressive strength	Delays	Curing temperature	
		+10 °C	+35 °C
	12 hours	-	80 - 90 N/mm2
	1 day	50 – 60 N/mm2	85 – 95 N/mm2
	3 days	65 – 75 N/mm2	85 – 95 N/mm2
	7 days	70 – 80 N/mm2	85 – 95 N/mm2
Modulus of elasticity in compression	~ 9600 MPa (at + 23°C)		(ASTM D 695)
Tensile strength	Delays	Curing temperature + 15°C	Curing temperature + 35°C (NF EN ISO 527-3)
	1 day	~ 20 MPa	~ 26 MPa
	3 days	~ 23 MPa	~ 27 MPa
	7 days	~ 26 MPa	~ 29 MPa
Modulus of elasticity in tension	~ 11200 MPa (at + 23°C)		(ISO 527)
Shrinkage	0.04 %		
Coefficient of thermal expansion	coefficient W:9× 10-5 per °C (temperature range -10 °C to +40 °C)		

APPLICATION INFORMATION

Mixing ratio	Comp A : Comp B = 3 : 1 by weight or volume.		
Consumption	Per 1 m ² and mm thickness: 1.8 kg A/B mixture		
Layer thickness	Maximum layer thickness per working pass 3 cm		
Material temperature	Sikadur®-30 Colle must be applied at temperatures between +8 °C and +35 °C.		
Ambient air temperature	+ 8°C min. / + 35°C max.		
Dew point	Beware of condensation. Substrate temperature during application must be at least +3 °C above dew point.		
Substrate temperature	+ 8°C min. / + 35°C max.		
Substrate moisture content	Max. 4%		
	When the substrate is slightly damp (without a film of water on the surface), brush the adhesive into the substrate.		
Pot Life	Temperature	Potlife	Open Time (IFP: International Federation of Prestressing)
	+ 8°C	~ 120 minutes	~ 150 minutes
	+ 20°C	~ 90 minutes	~ 110 minutes
	+ 35°C	~ 20 minutes	~ 50 minutes
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).			

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.

FURTHER DOCUMENTATION

Sika® CarboDur® System:

For details of how to install Sika® CarboDur® plates using Sikadur®-30 Colle, please refer to the Sika® CarboDur® Product DataSheet & Method Statement and CSTB technical approval no. 3/16-875.

IMPORTANT CONSIDERATIONS

Sikadur® resins are formulated to have low creep under permanent loading. However, due to the creep behavior 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.

A structural engineer must be consulted for load calculations for the specific application.

ECOLOGY, HEALTH AND SAFETY

Pour obtenir des informations et des conseils sur la manipulation, le stockage et l'élimination en toute sécurité des produits chimiques, les utilisateurs doivent consulter la fiche de données de sécurité (FDS) la plus récente contenant les données physiques, écologiques, toxicologiques et autres données relatives à la sécurité.

SUBSTRATE PREPARATION

Substrates must be clean and sound, and in particular free of laitance, loose parts, traces of grease, oil, rust, etc. Clean them very carefully by sandblasting or mechanical preparation. Avoid wet preparation. Concrete and mortar must be at least 28 days old and have a surface cohesion of at least 1.5 MPa.

MIXING

IMPORTANT

Avoid over mixing to minimise air entrainment.

Note: Use a spiral paddle in an electric single (Pre-batched unit) or double paddle mixer (Bulk container) at a maximum speed of 300 rpm.

Pre-batched unit:

1. Mix Part A (resin) for ~30 seconds.
2. Add Part B (hardener) to Part A.
3. Mix Part A+B continuously for ~3 minutes until a uniformly smooth, coloured mix is achieved.
4. To ensure thorough mixing, pour materials into another clean container and mix again to achieve a smooth and uniform mix.

Bulk container:

Note: Mix only the quantity which can be used within its pot life.

Add both parts in the correct proportion into a suitable clean, dry container and mix in the same way as for the pre-batched unit.

APPLICATION METHOD / TOOLS

Apply Sikadur®-30 Colle to the substrate with a spatula to obtain a coat approximately 1 mm thick. On slightly damp substrates, make sure Sikadur®-30 Colle penetrates the substrate well. Bonding should be carried

out while the adhesive is still tacky.

CLEANING OF EQUIPMENT

Clean material with Sikadur® Cleaner immediately after use, before the resin has cured. Once cured, the resin can only be mechanically removed.

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.

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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