

Sikadur® 330 US

High-modulus, high-strength, impregnating resin

Description	Sikadur® 330 is a two-component , solvent-free, moisture-tolerant, high strength, high modulus structural epoxy adhesive.
Where to Use	For use as an impregnating resin with the SikaWrap® Hex 106G, 113C, 117C, 230C and 430G Structural Strengthening Systems.
Advantages	<ul style="list-style-type: none"> ■ Long pot life. ■ Long open time. ■ Easy to mix. ■ 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® Systems. ■ High temperature resistance. ■ High abrasion and shock resistance. ■ Solvent-free, VOC compliant.
Coverage	First coat: 40-50 ft. ² /gal.; Additional coats: 100 ft. ² /gal.; Final coat: 160 ft. ² /gal.
Packaging	3.2 gal. kit / (2) two 1.25 gal. Component "A" pails, (2) two 0.35 gal. Component "B" pails

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years in original, unopened container.
Storage Conditions	Store dry at 40°-95°F (4°-35°C). Condition material to 65°-75°F (18°-24°C) before using.
Color	Light gray.
Mixing Ratio	Component 'A' : Component 'B' = 4 : 1 by weight
Consistency	Non-sag paste.
Pot Life	57 minutes (325 ml)
Tack Free Time	4-5 hours
Heat Deflection Temperature (ASTM D-648)	
7 day [fiber stress loading=264 psi (1.8 MPa)]	120°F (50°C)

Mechanical Properties

Compressive Properties (ASTM D-695), psi (MPa)

	40°F (4°C)	60°F (16°C)	73°F (23°C)	90°F (32°C)
8 hour	-	-	-	8,000 (55.2)
1 day	-	8,100 (55.8)	10,700 (73.7)	10,600 (73.1)
3 day	8,100 (55.8)	11,200 (77.2)	11,100 (76.5)	11,000 (75.8)
7 day	11,200 (77.2)	11,600 (80.0)	11,200 (77.2)	11,800 (81.3)
14 day	12,500 (86.2)	12,400 (85.5)	11,800 (81.3)	11,900 (82.0)

Tensile Strength (ASTM D-638)	7 day	4,900 psi (33.8 MPa)
Elongation @ Break (ASTM D-638)	7 day	1.2%
Flexural Strength (ASTM D-790)	7 day	8,800 psi (60.6 MPa)
Flexural Modulus (ASTM D-790)	7 day	5.06 x 10 ⁵ psi (3,489 MPa)

Construction



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How to Use

Surface Preparation

The concrete surface should be prepared to a minimum concrete surface profile (CSP-3) as defined by the ICRI-surface-profile chips. Localized out-of-plane variations, including form lines, should not exceed 1/32 in. (1 mm).

Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means (i.e. sandblasting). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.

Mixing

Pre-mix each component. Mix entire unit, do not batch. Pour contents of part B to part A. Mix thoroughly for 5 minutes with a 1/2 inch "Jiffy" mixer mounted on a rotary drill and set at a slow speed (400-600 rpm) until uniformly blended. Mix only that quantity that can be used within its pot life.

Application

Dry Lay-Up: When installing a SikaWrap® Hex fabric in the dry lay-up process apply the mixed Sikadur® 330 epoxy resin directly onto the substrate at a rate of 40-50 ft.²/gal. (0.95-1.18 m²/L). Coverage rate will depend on the actual surface profile. This equates to a thickness of approximately 32-40 mils. Carefully place the fabric into the applied resin with gloved hands and smooth out. Work out any irregularities or air pockets with a plastic laminating roller. Let the resin squeeze out between the rovings of the fabric. If more than one layer of fabric is required, apply additional Sikadur® 330 US at a rate of 100 ft.²/gal. (2.37 m²/L) and repeat as described above. This equates to a thickness of approximately 16 mils. Add a final layer of Sikadur® 330 US onto the exposed surface at a rate of 160 ft.²/gal. (3.79 m²/L). This equates to a thickness of approximately 10 mils.

Wet Lay-Up: When installing a SikaWrap® Hex fabric vertically or overhead in the wet lay-up process, mixed Sikadur® 330 can be applied to the substrate as a primer/tack coat to prevent the impregnated fabric from sliding down the concrete. Due to its mixed viscosity, do not use Sikadur® 330 US with an automatic fabric saturating device. Consult the SikaWrap® Hex fabric technical data sheet for information on saturating/impregnating fabric in a wet lay-up installation.

Limitations

- Minimum age of concrete is 21-28 days, depending on curing and drying conditions.
- All repairs required to achieve a level surface must be performed prior to application.
- Do not apply or cure Sikadur® 330 US in direct sunlight.
- Minimum substrate temperature 40°F (4°C). Maximum application temperature 95°C (35°C)
- Do not thin with solvents.
- Material is a vapor barrier after cure.
- Do not encapsulate saturated concrete in areas of freezing and thawing.
- Color of Sikadur 330 US may alter due to variations in lighting and/or UV exposure.
- Due to its mixed viscosity, do not use Sikadur 330 US with an automatic saturating device. Fabric must be saturated/impregnated manually when the wet lay-up process is used.
- At low temperatures and/or high relative humidity, a slight oily residue (blush) may form on the surface of the cured epoxy. If an additional layer of fabric, or a coating is to be applied onto the cured epoxy. This residue must first be removed to ensure adequate bond. The residue can be removed with either a solvent wipe (e.g. MEK) or with water and detergent. In both cases, the surface should be wiped dry prior to application of the next layer or coating.
- Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.

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