



PRODUCT DATA SHEET

Sika AnchorFix®-3030

Epoxy high performance chemical anchoring adhesive

PRODUCT DESCRIPTION

Sika AnchorFix®-3030 is an epoxy resin based, 2-part, thixotropic, high performance anchoring adhesive for anchoring threaded rods and reinforcing bars in both cracked and un-cracked concrete dry or damp concrete.

WHERE TO USE

Sika AnchorFix®-3030 may only be used by experienced professionals.

Anchoring adhesive for fixing of non-expanding anchors in the following:

Structural work

- Rebar / steel reinforcement anchoring in new and refurbishment works
- Threaded rods
- Bolts and special fastening / fixing systems

Metalwork, carpentry

- Handrails, balustrades and supports
- Railings
- Window and door frames

Substrates

- Concrete (cracked and un-cracked)
- Hollow and solid masonry
- Wood
- Natural and reconstituted stone
- Solid rock

Suitable for use as a "pick proof" sealant in secure or holding suites and similar facilities (horizontal use only).

CHARACTERISTICS / ADVANTAGES

- Long open Time
- Can be used in damp concrete
- High load capacity
- Seismic tested (design categories A to F and C1 & C2)
- Suitable for contact with drinking water
- Styrene-free
- Good adhesion to substrate
- Shrinkage-free hardening
- Low emissions
- Low wastage

ENVIRONMENTAL INFORMATION

- Conformity with LEED®v4 IEQ Credit: Low-Emitting Materials.

APPROVALS / CERTIFICATES

- ICC-ES Evaluation Report, ESR-4778: approved for cracked and uncracked concrete.
- ANSI/NSF Standard 61 approved for contact with potable water by IAPMO-R&T.
- Ministère des Transports du Québec (MTQ) approved.
- Waiting to be approved by the Ministry of Transportation of Ontario (MTO) and the British Columbia Ministry of Transportation (BC MoT).

PRODUCT INFORMATION

CSC MasterFormat®	CSC Master Format™ 03 64 23 EPOXY INJECTION GROUTING	
Composition / Manufacturing	Epoxy resin	
Packaging	385 mL dual cartridge	12 cartridges per box Pallet: 70 boxes with 840 cartridges
	585 mL dual cartridge	12 cartridges per box Pallet: 44 boxes with 528 cartridges
Shelf Life	24 months from date of production	
Storage Conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +10 °C and +25 °C (+50 °F and +77 °F). Always refer to packaging.	
Colour	Part A	Off white
	Part B	Grey
	A+B mixed	Light grey
Density	A+B mixed	1,5 kg/L
Volatile organic compound (VOC) content	2 g/L	

TECHNICAL INFORMATION

Compressive Strength	95 MPa / 13 779 psi (7 days, +20 °C / +68 °F)	(ASTM D 695)
Tensile Strength in Flexure	45 MPa / 6 527 psi (7 days, +20 °C / +68 °F)	(ASTM D 790)
Tensile Strength	23 MPa / 3 335 psi (7 days, +20 °C / +68 °F)	(ASTM D 638)
Modulus of Elasticity in Tension	5 500 MPa / 797 708 psi (7 days, +20 °C / +68 °F)	(ASTM D 638)
Service Temperature	Long term	-40 °C min. to +50 °C max. (ETAG 001, Part 5) (-40 °F min. to +122 °F max.)
	Short term (1–2 hours)	+70 °C (+128 °F)

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 3 : 1 by volume
Layer Thickness	~8 mm max
Sag Flow	Non-sag, including overhead
Product Temperature	+10 °C min. to +40 °C max. (+50 °F min. to +104 °F max.)
Ambient Air Temperature	+5 °C min. to +40 °C max. (+41 °F min. to +104 °F max.)
Dew Point	Beware of condensation. Substrate temperature during application must be at least +3 °C above dew point.
Substrate Temperature	+5 °C min. to +40 °C max. (+41 °F min. to +104 °F max.)

Curing Time

Temperature	Open time - T _{gel}	Curing time - T _{cur}
+35 °C to +40 °C (+95 °F to +104 °F)	6 minutes	2 hours
+30 °C to +35 °C (+86 °F to +95 °F)	8 minutes	4 hours
+25 °C to +30 °C (+77 °F to +86 °F)	12 minutes	6 hours
+20 °C to +25 °C (+68 °F to +77 °F)	18 minutes	8 hours
+15 °C to +20 °C (+59 °F to +68 °F)	25 minutes	12 hours
+10 °C to +15 °C (+50 °F to +59 °F)	40 minutes	18 hours
+5 °C to +10 °C* (+41 °F to +50 °F)	150 minutes	24 hours
+5 °C* (+41 °F)	300 minutes	24 hours

* Minimum cartridge temperature: +10 °C (+50 °F)

BASIS OF PRODUCT DATA

Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.

OTHER DOCUMENTS

- For specific information on design refer to: Technical Documentation Sika Sika AnchorFix®-3030 870 43 18

LIMITATIONS

- Natural / reconstituted stone and solid rock properties vary particular with regard to strength, composition and porosity. For each application, the suitability of Sika AnchorFix®-3030 must be tested for bond strength, surface staining and discoloration by first applying the product to a sample area before full project application.

ENVIRONMENT, HEALTH & SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

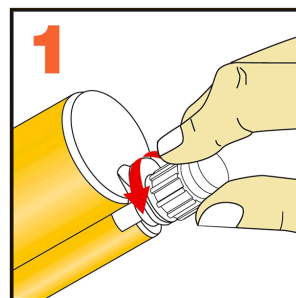
Mortar and concrete must be at the required design strength.

Substrate tensile / compressive strengths (concrete, masonry, natural stone) must be confirmed by testing. The anchor hole must always be clean, dry, free from oil and grease etc.

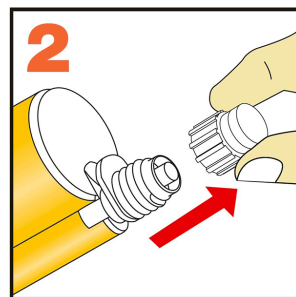
Loose particles must be removed from the holes. Threaded rods and rebar's must be cleaned thoroughly and free from dirt, oil, grease, corrosion products or any other substances and particles which could affect adhesion.

MIXING

Preparing the cartridge: 385 & 585 ml



1. Unscrew the cap



2. Remove the cap

Product Data Sheet

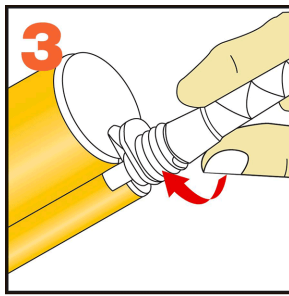
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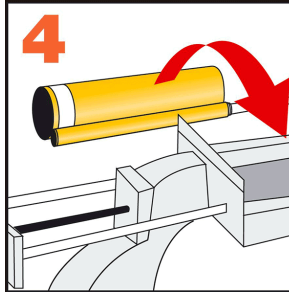
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3. Screw on the static mixer

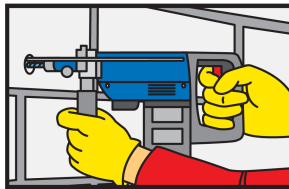


4. Place the cartridge into the application gun ready for use

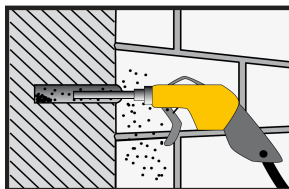
When the work is interrupted the static mixer nozzle can remain on the cartridge after the gun pressure has been released. If the resin has hardened in the nozzle when work is resumed, a new nozzle must be attached.

APPLICATION METHOD / TOOLS

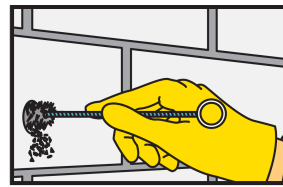
Anchors in solid masonry/concrete



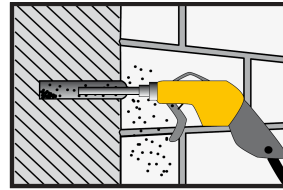
1. Drill hole with an electric drill to the diameter and depth required. Drill hole diameter must be in accordance with anchor size



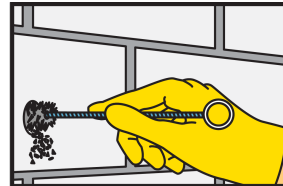
2. The drill hole must be cleaned with oil free compressed air using an air lance, pressure: 6 Bar (90 psi). Start from the bottom of the hole and clean minimum 2 x until return air stream is free of dust



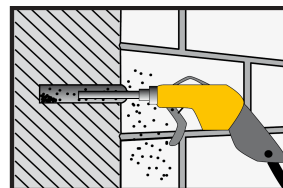
3. The drill hole must be thoroughly cleaned with the special steel brush (brush at least 2x). The diameter of the brush must be larger than the diameter of the drill hole



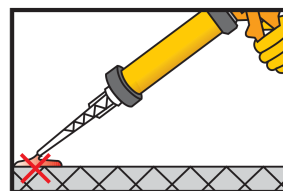
4. The drill hole must be cleaned again as stage 2



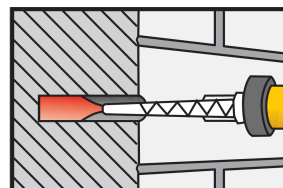
5. The drill hole must be thoroughly cleaned again as stage 3



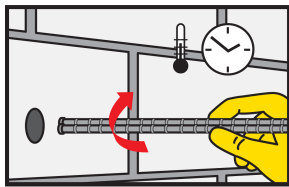
6. The drill hole must be cleaned again as stage 2 & 4



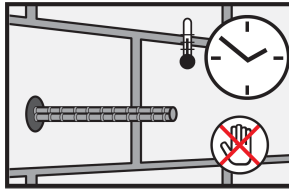
7. Pump gun at least 2 x until both parts are extruded as a one consistent colour. Do not use this material. Release the gun pressure and clean the static mixer opening with a cloth



8. Inject the adhesive into the drill hole, starting from the bottom and slowly pull out the static mixer while extruding the resin into the hole. Avoid entrapping air. For deep holes use extension tubing



9. Insert the anchor with a rotary motion into the filled drill hole within the adhesive open time. Some of the adhesive must flow out of the hole



10. During the resin hardening time the anchor must not be moved or loaded

Important Note: Anchors in hollow blocks: Use Sika AnchorFix®-1.

CLEAN UP

Remove uncured material from all tools and application equipment with Sika® Epoxy Cleaner. Cured product can only be removed mechanically.

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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

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Product Data Sheet

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