

## PRODUCT DATA SHEET

# Sika AnchorFix<sup>®</sup>-3030

Epoxy high performance chemical anchoring adhesive

### DESCRIPTION

Sika AnchorFix<sup>®</sup>-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.

### USES

Sika AnchorFix<sup>®</sup>-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

### CHARACTERISTICS / ADVANTAGES

- Long open Time
- Can be used in damp concrete
- High load capacity
- ETA for anchoring in cracked concrete
- ETA for post installed rebar connections
- Seismic tested (C1 & C2)
- Suitable for contact with drinking water
- Fire resistant
- Styrene-free
- Good adhesion to substrate
- Shrinkage-free hardening
- Standard sealant guns can be used (300ml cartridge)
- Low emissions
- Low wastage

### ENVIRONMENTAL INFORMATION

- Conformity with LEED v2009 IEQc 4.1: Low-Emitting Materials - Adhesives and Sealants, Report No. G23807C\_04

### APPROVALS / STANDARDS

- CE Marking and Declaration of Performance to ETAG 001 Part 1 - Anchors in general and Part 5 - Bonded anchors, used as European Assessment Document (EAD)
- CE Marking and Declaration of Performance to ETA 17/0694 - Bonded injection type anchor for use in cracked and uncracked concrete
- Fire Evaluation of Post Installed Rebar Connections CEN EN 1991-1-2, Sika AnchorFix<sup>®</sup>-3030, CSTB, Test report MRF 26072904/C

## PRODUCT INFORMATION

Chemical Base	Epoxy resin	
Packaging	585 ml dual cartridge	12 cartridges per box Pallet: 56 boxes with 672 cartridges
	Refer to current price list for packaging variations.	
Colour	Part A	Off white
	Part B	Grey
	A+B mixed	Light grey
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. Always refer to packaging.	
Density	A+B mixed	~1,5 kg/l

## TECHNICAL INFORMATION

Compressive Strength	~95 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 695)
Tensile Strength in Flexure	~45 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 790)
Tensile Strength	~23 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
Modulus of Elasticity in Tension	~5500 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
Service Temperature	Long term	-40 °C min. / +50 °C max. (ETAG 001, Part 5)
	Short term (1–2 hours)	+70 °C

## 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. / +40 °C max.		
Ambient Air Temperature	+5 °C min. / +40 °C max.		
Dew Point	Beware of condensation. Substrate temperature during application must be at least +3 °C above dew point.		
Substrate Temperature	+5 °C min. / +40 °C max.		
Curing Time	<b>Temperature</b>	<b>Open time - T<sub>gel</sub></b>	<b>Curing time - T<sub>cur</sub></b>
	+35 °C – +40 °C	6 minutes	2 hours
	+30 °C – +35 °C	8 minutes	4 hours
	+25 °C – +30 °C	12 minutes	6 hours
	+20 °C – +25 °C	18 minutes	8 hours
	+15 °C – +20 °C	25 minutes	12 hours
	+10 °C – +15 °C	40 minutes	18 hours
	+5 °C – +10 °C*	150 minutes	24 hours
	+5 °C*	300 minutes	24 hours

\* Minimum cartridge temperature: +10 °C

## 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.

## 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.

## 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 Material Safety Data Sheet (MSDS) containing physical, ecological, toxicological and other safety-related data.

### VOC DATA

The maximum content of Sika AnchorFix®-3030 is 70 g/L VOC for the ready to use product.

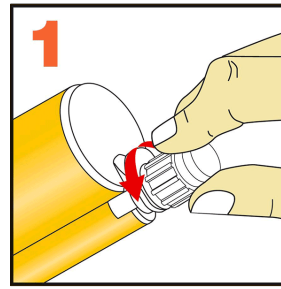
## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY

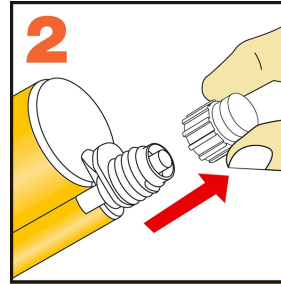
Mortar and concrete must be at the required design strength.  
Substrate tensile / compressive strengths (concrete, masonry, natural stone) must be confirmed by testing. The anchor hole must always be clean, dry, free from oil and grease etc.  
Loose particles must be removed from the holes. Threaded 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

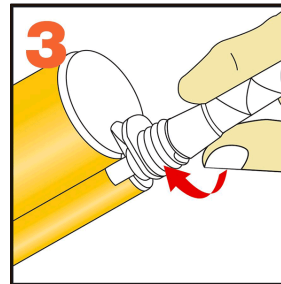
### Preparing the cartridge: 585 ml



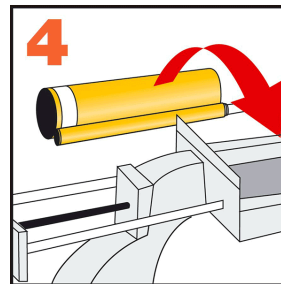
1. Unscrew the cap



2. Remove the cap



3. Screw on the static mixer

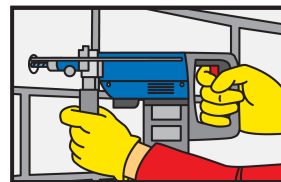


4. Place the cartridge into the application gun ready for use

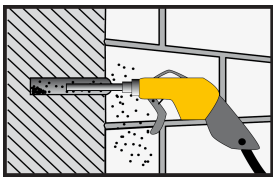
When the work is interrupted the static mixer nozzle can remain on the cartridge after the gun pressure has been released. If the resin has hardened in the nozzle when work is resumed, a new nozzle must be attached.

### APPLICATION METHOD / TOOLS

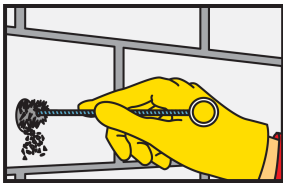
#### Anchors in solid masonry/concrete



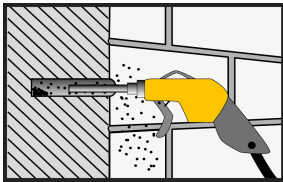
1. Drill hole with an electric drill to the diameter and depth required. Drill hole diameter must be in accordance with anchor size



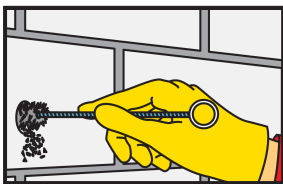
2. The drill hole must be cleaned with oil free compressed air using an air lance, pressure: 6 Bar (90 psi). Start from the bottom of the hole and clean minimum 2 x until return air stream is free of dust



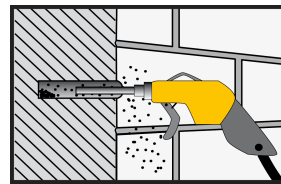
3. The drill hole must be thoroughly cleaned with the special steel brush (brush at least 2x). The diameter of the brush must be larger than the diameter of the drill hole



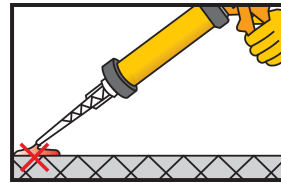
4. The drill hole must be cleaned again as stage 2



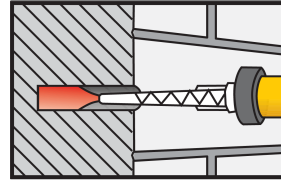
5. The drill hole must be thoroughly cleaned again as stage 3



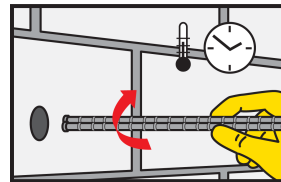
6. The drill hole must be cleaned again as stage 2 & 4



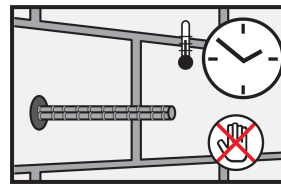
7. Pump gun at least 2 x until both parts are extruded as a one consistent colour. Do not use this material. Release the gun pressure and clean the static mixer opening with a cloth



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.

## CLEANING OF TOOLS

Clean all tools and application equipment with Sika® Colma Cleaner/ Sika® Remover-208 immediately after use. Hardened material can only be removed mechanically.

## 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.

## 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. It may be necessary to adapt the above disclaimer to specific local laws and regulations. Any changes to this disclaimer may only be implemented with permission of Sika® Corporate Legal in Baar.

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### Product Data Sheet

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