

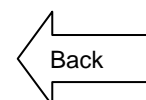
Technical Data Sheet
 Edition 1, 2009
 Identification no.
 02 04 02 06 001 0 000019
 Version no. 0010
Sika Anchorfix® -1

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Fast Curing Anchoring Adhesive

Description	Solvent- and styrene free based two-part polyester anchoring adhesive.
Uses	<p>As a fast curing anchoring adhesive for all grades of:</p> <ul style="list-style-type: none"> ■ Rebars / reinforcing steel ■ Threaded rods ■ Bolts and special fastening systems ■ Concrete ■ Hollow and solid masonry <p>Prior to any application, the suitability of the Sika AnchorFix® Adhesive for the substrate in terms of the desired bond strength, and for the prevention of surface staining or discolouration, must be confirmed by testing in a sample area. This is due to the wide variation of possible substrates, particularly in terms of strength, composition and porosity:</p> <ul style="list-style-type: none"> ■ Hard natural stone ■ Solid rock
Characteristics / Advantages	<ul style="list-style-type: none"> ■ Fast curing ■ Standard guns can be used ■ Can be used at low temperatures ■ High load capacity ■ Non-sag, even overhead ■ Styrene-free ■ Low odour ■ Low wastage ■ No transportation restrictions
Product Data	
Form	
Colours	Part A: white Part B: black Part A+B mixed: light grey
Packaging	300 ml standard cartridge, 12 per box. Pallet: 60 boxes with 12 cartridges.
Storage	
Storage Conditions / Shelf life	12 months from date of production if stored properly in original unopened, sealed and undamaged packaging in cool and dry conditions at temperatures between 0°C and +20°C. Protect from direct sunlight.

All Sika AnchorFix® -1 cartridges have the expiry date printed on the label.






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Technical data

Density 1.63 (part A+B mixed).

Curing Speed

Temperature 	Open time T _{gel} 	Curing time T _{cur} 
- 10°C	30 minutes	24 minutes
+5°C	18 minutes	145 minutes
+10°C	10 minutes	85 minutes
+20°C	6 minutes	50 minutes
+30°C	4 minutes	35 minutes

For application at -10°C store cartridges at +5°C.

Sag Flow Non-sag, even overhead.

Layer thickness 3 mm max.

Thermal Stability Glass-Transition Temperature (TG):
+60°C (According to DIN EN ISO 6721-2)

Mechanical / Physical Properties

Compressive Strength 50 N/mm² (According to ASTM D695)

Resistance

Thermal Resistance Temperature Resistance of the cured adhesive :
+50°C long term, +80°C short term (1-2 hours)

System Information

Application Details

Consumption/ Dosage Material consumption per anchor in ml

Anchor ∅ mm	Drill ∅ mm	Drill hole depth in mm																	
		80	90	110	120	130	140	160	170	180	200	210	220	240	260	280	300	350	400
8	10	3	4	4	5	5	5	6	6	7	7	7	8	8	9	9	10	11	12
10	12	4	5	5	6	6	6	7	8	8	8	8	9	10	10	11	12	14	15
13	16	8	9	11	12	12	14	16	17	18	20	21	22	24	26	28	30	35	40
16	18	9	10	11	13	14	15	17	18	19	21	22	23	26	28	30	32	36	40
	20	10	12	12	15	16	17	20	21	22	24	25	26	29	31	33	35	40	46
20	24	12	13	14	15	16	18	22	24	26	28	30	32	36	38	42	48	58	66
	25	18	19	21	23	24	26	30	31	32	36	38	40	44	46	50	54	64	72

The indicated filling quantities are calculated without wastage. Wastage 10 - 50%.

The filled quantity can be monitored during injection with the help of the scale on the cartridge label.

Substrate Quality

Mortar and concrete must be at the required strength. No need to be 28 days old. Substrate strength (concrete, masonry, natural stone) must be verified. Pull-out tests must be carried out if the substrate strength is unknown. The anchor hole must always be clean, dry, free from oil and grease etc.. The anchor hole must always be dry, free from oil and grease etc. Loose particles must be removed from the holes.

Threaded rods and rebars have to be cleaned thoroughly from any oil, grease or any other substances and particles such as dirt etc.

Application Conditions / Limitations

Substrate Temperature -10°C min. / +40°C max.
Sika AnchorFix® -1 must be at a temperature of +5°C and +40°C for a pplication.

Ambient Temperature -10°C min. / +40°C max.
Sika AnchorFix® -1 must be at a temperature of between +5°C and +40 °C for application.

**Application
Instructions**

Mixing

Part A : part B = 10 : 1 by volume

Mixing Tools

Getting the cartridge ready:



1
Unscrew
and remove
the cap



2
Cut the film



3
Screw on
the static
mixer



4
Place the cartridge into the
gun and start application

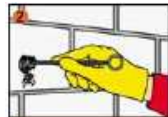
When the work is interrupted the static mixer can remain on the cartridge after the gun pressure has been relieved. If the resin has hardened in the nozzle when work is resumed, a new nozzle must be attached.

**Application Method /
Tools**

General Remarks:



1
Drilling or 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 thoroughly cleaned with a round brush (brush at least 3x). The diameter of the brush must be larger than the diameter of the drill hole.

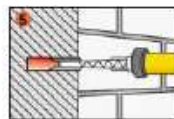


3
The drill hole must be cleaned with a blow pump or by compressed air, starting from the bottom of the hole.

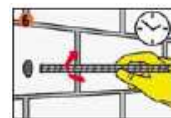
Important: use oil-free compressors!



4
Pump approx. twice until both parts come out uniformly. Do not use this material. Release the gun pressure and clean the cartridge opening with a cloth.

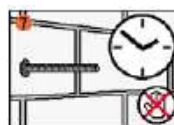


5
Inject the adhesive into the hole, starting from the bottom, while slowly drawing back the static mixer. In any case avoid entrapping air. For deep holes extension tubing can be used.



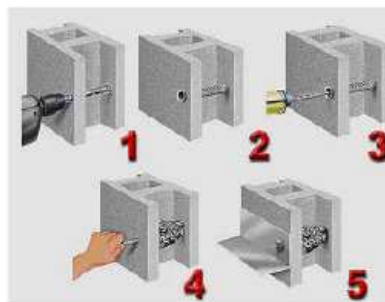
6
Insert the anchor with a rotary motion into the filled drill hole. Some adhesive must come out of the hole.

Important: the anchor must be placed within the open time.



7
During the resin hardening time the anchor must not be moved or loaded. Wash tools immediately with Sika® Colma Cleaner. Wash hands and skin thoroughly with warm soap water.

Anchors in hollow blocks:



To fix anchors into hollow materials (bricks or blocks) perforated sleeves must be used.

Note: with hollow material do not use rotary hammer drills.

Cleaning of Tools	Clean all tools and application equipment with Sika® Colma Cleaner immediately after use. Hardened / cured material can only be mechanically removed.
Value Base	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.
Health and Safety Information	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 containing physical, ecological, toxicological and other safety-related data.
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 product 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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