

# PRODUCT DATA SHEET

## Sika AnchorFix<sup>®</sup>-2+

Styrene-free anchoring adhesive for medium to high loads

### PRODUCT DESCRIPTION

Solvent and styrene-free, epoxy acrylate based, 2-component anchoring adhesive for normal / moderate climate conditions.

### USES

Sika AnchorFix<sup>®</sup>-2+ may only be used by experienced professionals.

As a fast curing anchoring adhesive for all grades of:

- Rebars / reinforcing steel
- Threaded rods
- Bolts and special fastening systems
- Concrete (cracked and non-cracked)
- Solid masonry
- Steel
- Hard natural stone\*
- Solid rock\*

\* These substrates may vary greatly, in particular with regard to strength, composition and porosity. Therefore, for each application the suitability of Sika AnchorFix<sup>®</sup>-2+ Adhesive must be tested by first applying the product to a sample area. In particular, check bond strength, surface staining and discoloration.

### CHARACTERISTICS / ADVANTAGES

- Fast curing.
- Standard guns can be used for application.
- High load capacity.
- ETA to ETAG 001 for anchoring in concrete.
- ETA to ETAG 001 for rebar connections.
- Suitable for cracked concrete.
- Drinking Water certified.
- LEED Attestation available.
- Non-sag, even overhead.
- Styrene-free.
- Low odour.
- Low wastage.
- Suitable in wet / damp (but clean) holes.
- Appropriate for marine environments.

### APPROVALS / STANDARDS

- Bonded injection type anchor according to ETAG 001 Part 1 and 5 Option 1, ETA-14/0346, Declaration of Performance 020205010020000011 5034408 (1138), certified by notified product certification body 1020, certificate of constancy of performance 1020-CPR-090-032534, and provided with the CE marking.
- Post installed rebar connection according to ETAG 001 Part 1 and 5 TR 023, ETA-13/0779, Declaration of Performance 020205010020000011 5034408 (1138), certified by notified product certification body 1020, certificate of constancy of performance 1020-CPD-090-036698, and provided with the CE marking.
- Drinking Water Certificate: Water Regulations Advisory Scheme Ltd. (WRAS) Approval Number: 1604543.

## PRODUCT INFORMATION

<b>Packaging</b>	<u>300 ml standard cartridge</u>	<u>12 cartridges per box</u> <u>1 pallet: 75 boxes</u>
<b>Shelf Life</b>	15 months from date of production All Sika AnchorFix®-2+ cartridges have the expiry date printed on the label.	
<b>Storage Conditions</b>	Stored properly in original, unopened, sealed and undamaged packaging in dry conditions at temperatures between +5 °C and +25 °C. Protect from direct sunlight.	
<b>Colour</b>	Component A: white Component B: black Component A+B mixed: grey	
<b>Density</b>	~1.62–1.70 kg/l (component A) ~1.44–1.50 kg/l (component B) ~1.60–1.68 kg/l (component A+B mixed)	

## TECHNICAL INFORMATION

<b>Compressive Strength</b>	~70 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 695)
<b>Modulus of Elasticity in Compression</b>	~7 000 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 695)
<b>Flexural Strength</b>	~29 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 790)
<b>Tensile Strength</b>	~15 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
<b>Tensile Modulus of Elasticity</b>	~3 800 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
<b>Service Temperature</b>	<u>Long term</u>	<u>-40 °C min. / +50 °C max</u> (ETAG 001, part 5)
	<u>Short term (1–2 hours)</u>	<u>+80 °C</u>

## SYSTEM INFORMATION

<b>System Structure</b>	For design details, please refer to the separate documentation provided: Technical Documentation Sika AnchorFix®-2+ 870 43 06.
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## APPLICATION INFORMATION

<b>Mixing Ratio</b>	Component A : Component B = 10 : 1 by volume
<b>Layer Thickness</b>	~5 mm max.
<b>Sag Flow</b>	Non-sag, even overhead
<b>Product Temperature</b>	Sika AnchorFix®-2+ must be at a temperature of between +5 °C and +30 °C for application.
<b>Ambient Air Temperature</b>	+5 °C min. / +30 °C max.
<b>Dew Point</b>	Beware of condensation. Substrate temperature during application must be at least 3 °C above dew point.
<b>Substrate Temperature</b>	+5 °C min. / +30 °C max.

## Curing Time

Temperature	Open time - T <sub>gel</sub>	Curing time - T <sub>cur</sub>
+25 °C to +30 °C	4 minutes	40 minutes
+20 °C to +25 °C	5 minutes	50 minutes
+15 °C to +20 °C	6 minutes	75 minutes
+10 °C to +15 °C	8 minutes	85 minutes
+5 °C to +10 °C*	10 minutes	145 minutes

\*Minimum cartridge temperature = +5 °C

## 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.

## FURTHER DOCUMENTS

For design details, please refer to the separate documentation provided: Technical Documentation Sika AnchorFix®-2+ 870 43 06.

## ECOLOGY, HEALTH AND 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.

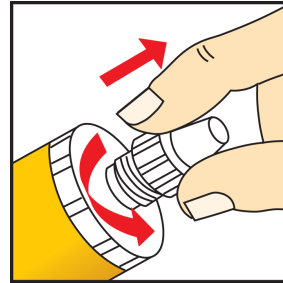
## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY

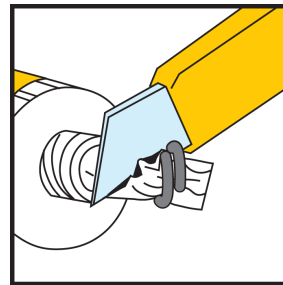
Mortar and concrete must be older than 28 days. Substrate strength (for concrete, masonry, natural stone) must be verified. Pull-off tests must be carried out if the substrate strength is unknown. The anchor hole must always be clean and free from oil and grease, etc. Loose particles must be removed from the holes. If applying within flooded holes, the holes must be clean and contain uncontaminated water. Threaded rods and rebars have to be cleaned thoroughly from any oil, grease or any other substances and particles such as dirt, etc.

## MIXING

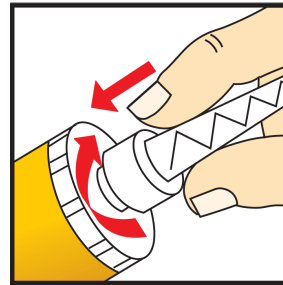
Getting the 300 ml cartridge ready:



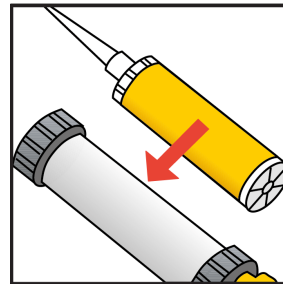
1. Unscrew the cap.



2. Cut the film.



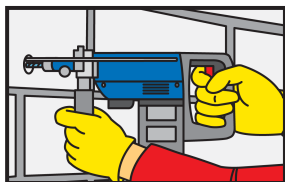
3. Screw on the static mixing nozzle.



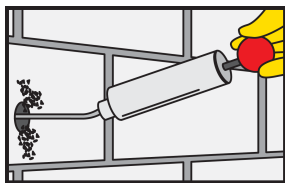
4. Place the cartridge into the gun and start application.

## 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.

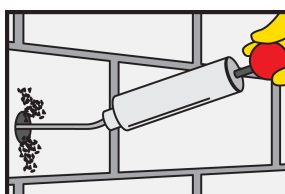


2. The drill hole must be cleaned with a blow pump, or by compressed air (rebar application), starting from the bottom of the hole. Complete at least twice.

**Important: use oil-free compressors.**



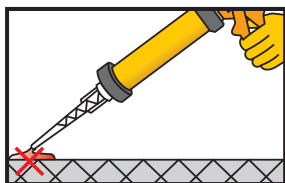
3. The drill hole must be thoroughly cleaned with a special steel brush. Brush at least twice. To be effective, the diameter of the brush must be larger than the diameter of the drill hole.



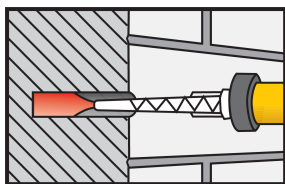
4. Repeat cleaning with a blow pump, or by compressed air (rebar application), starting from the bottom of the hole. Complete again at least twice.

**Important: use oil-free compressors.**

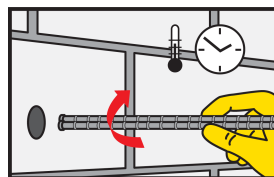
\*The above process of cleaning should be completed at least twice to ensure all contaminants are removed



5. Pump at least twice until the product appears uniform. Do not use this material and discard. Release the gun pressure and clean the cartridge opening with a cloth.

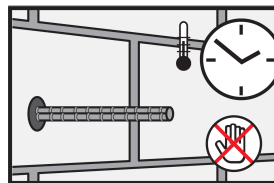


6. Inject the adhesive into the hole, starting from the bottom, while slowly drawing back the static mixing nozzle. Avoid entrapping air. For deep holes, extension tubing can be used.



7. 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.**



8. During the resin hardening time, the anchor must not be moved or loaded. Wash tools immediately with Sika® Thinner C.

Wash hands and skin thoroughly with warm soap water.

## 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.

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### Product Data Sheet

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