

PRODUCT DATA SHEET

Sikadur-Combiflex® Adhesive IN

2-part epoxy adhesive for the Sikadur-Combiflex® SG system

DESCRIPTION

Sikadur-Combiflex® Adhesive IN is a 2-part epoxy based thixotropic adhesive for bonding the Sikadur-Combiflex® SG modified flexible Polyolefin (FPO) waterproofing tapes to different substrates. Internal and external use. Application temperature range +10 °C to +40 °C. It is part of the Sikadur-Combiflex® SG System.

USES

Sikadur-Combiflex® Adhesive IN may only be used by experienced professionals.

- Adhesive for the Sikadur-Combiflex® SG System
- Adhesive for the other Sika® Joint Sealing Systems

These systems are used for various applications such as:

- Expansion Joint treatment
- Construction Joint treatment
- Crack treatment
- Precast panels joint treatment

FEATURES

- Easy to mix and apply
- Suitable for both dry and damp concrete surfaces
- Excellent adhesion to many materials
- Solvent free
- Performs well within a wide temperature range
- Completely weather and water resistant
- Fast curing
- Root resistant
- Good resistance to many chemicals
- Thixotropic - suitable for overhead and vertical application
- No primer needed
- High mechanical resistance
- Good abrasion resistance

PRODUCT INFORMATION

Composition	Epoxy resin and selected fillers	
Packaging	Part A+B pre-batched	6 kg set
	Part A	4 kg container
	Part B	2 kg container
Shelf life	12 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 +5 °C and +40 °C.	
Colour	Part A+B mixed	Concrete grey
	Part A	White
	Part B	Black
Density	~1.6 kg/L (Part A+B mixed, +30 °C)	(EN ISO 2811-1)

SYSTEM INFORMATION

System structure Refer to Sikadur-Combiflex® SG System data sheet or contact Sika Technical Services for specific information.

TECHNICAL INFORMATION

Compressive strength	Curing time (+30 °C)	Compressive strength	(ASTM D695)
	3 day	50 N/mm ²	
	7 days	55 N/mm ²	

Tensile adhesion strength	Substrate	Adhesion strength	(EN 1542)
	Concrete (dry)	> 2 N/mm ² *	
	Concrete (mat damp)	> 2 N/mm ² *	
	Steel (blast cleaned)	> 2 N/mm ²	
* failure in concrete			

Chemical resistance Refer to Sikadur-Combiflex® SG System system data sheet or contact Sika Technical Services for specific information.

APPLICATION INFORMATION

Mixing ratio Part A : Part B = 2 : 1 (by weight)

Consumption	Tape width	Tape thickness	Consumption *
	150 mm	1 mm	1.0 kg/m
	200 mm	1 mm	1.2 kg/m
	250 mm	1 mm	1.4 kg/m
	150 mm	2 mm	1.1 kg/m
	200 mm	2 mm	1.4 kg/m
	250 mm	2 mm	1.7 kg/m

* The effective consumption can vary depending on site conditions (surface roughness, size of aggregate etc.).

Ambient air temperature +10 °C min. / +40 °C max.

Dew point Beware of condensation.
Steel substrate temperature during application must be at least +3 °C above dew point.

Substrate temperature +10 °C min. / +40 °C max.

Substrate moisture content Cementitious substrates:
Substrate must be dry or matt damp (no standing water).
Brush the adhesive well into the substrate if matt damp.

Pot Life ~30 minutes (100 g mass, +30 °C)
If larger quantities are being mixed the temperature of Sikadur-Combiflex® Adhesive IN will increase due to the chemical reaction, resulting in a reduced pot life.

Waiting time to overcoating Sikadur-Combiflex® Adhesive IN may be overcoated with an epoxy coating. If this is required, do not smooth the adhesive with detergent. If waiting time between application of adhesive and overcoating is to be longer than 2 days, the adhesive must be blinded to excess with quartz sand immediately after application.

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.

FURTHER INFORMATION

Please refer to Sikadur-Combiflex® SG System and Sika® Dilatec® System data sheet.

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

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

Concrete/masonry/mortar/stone

Concrete and mortar must be at least 3–6 weeks old. Substrate surfaces must be sound, clean, dry or matt damp, free from standing water, ice, dirt, oil, grease, coatings, laitance, efflorescence, old surface treatments, all loose particles and any other surface contaminants that could affect adhesion of the adhesive.

Steel

Surfaces must be clean, dry, free from oil, grease, coatings, rust, scale, all loose particles and any other surface contaminants that could affect adhesion of the adhesive.

SUBSTRATE PREPARATION

Concrete/masonry/mortar/stone

Substrates must be prepared mechanically using suitable abrasive blast cleaning, needle gunning, light scabbling, bush hammering, grinding or other suitable equipment to achieve an open textured gripping surface profile.

Steel

Surfaces must be prepared mechanically using suitable abrasive blast cleaning, grinding, rotating wire brush or other suitable equipment to achieve a bright metal finish with a surface profile similar to aluminium oxide paper medium grade. Avoid dew point conditions before and during application.

All substrates

All dust and loose material must be completely removed from all substrate surfaces before application of the product by vacuum / dust removal equipment.

MIXING

IMPORTANT

Avoid over mixing to minimise air entrainment.

IMPORTANT

Mix full units only.

Note: Use a spiral paddle in an electric single paddle mixer at a maximum speed of 500 rpm.

1. Mix Part A (resin) for ~60 seconds.
2. Add Part B (hardener) to Part A (resin).
3. Mix Parts A+B continuously for ~2 minutes until a uniformly smooth, coloured mix is achieved.
4. To ensure thorough mixing, pour materials into another clean container and mix again for 1 minute to achieve a smooth and uniform mix.

APPLICATION

1. Apply the mixed product by hard brush or trowel. For detailed application method, please refer Sikadur-Combiflex® SG System data sheet and Sika Method Statement.

CLEANING OF EQUIPMENT

Clean all tools and application equipment with suitable solvent immediately after use. Hardened or cured material can only be removed mechanically.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product 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 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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