

## PRODUCT DATA SHEET

# Sikadur®-330

Thixotropic epoxy impregnating resin for SikaWrap® structural fabrics

### DESCRIPTION

Sikadur®-330 is a 2-Part, thixotropic, epoxy-based impregnating / laminating resin for SikaWrap® structural strengthening fabrics.

### USES

Sikadur®-330 may only be used by experienced professionals.

Impregnating / laminating resin for:

- The SikaWrap® fabric reinforcement dry application method
  - As a substrate primer for the wet application method
- Structural adhesive for bonding:
- Sika® CarboDur® plates
  - Sika® CarboDur® NSM profiles into surface slots
  - SikaWrap FX anchorage cord

### CHARACTERISTICS / ADVANTAGES

- Easy to mix
- Application by trowel and impregnation roller
- Formulated for manual saturation methods
- Good application properties for vertical and overhead surfaces
- Good adhesion to many substrates
- High mechanical properties
- No separate primer required

### SUSTAINABILITY

- Conformity with LEED v4 MRc 2 (Option 1): Building Product Disclosure and Optimization – Environmental Product Declarations
- Conformity with LEED v4 MRc 4 (Option 2): Building Product Disclosure and Optimization - Material Ingredients

### PRODUCT INFORMATION

- Conformity with LEED v4 EQc 2: Low-Emitting Materials
- IBU Environmental Product Declaration (EPD)
- VOC emission classification GEV-Emicode EC1PLUS, license number 9546/20.10.00

### APPROVALS / CERTIFICATES

- CE Marking and Declaration of Performance to EN 1504-4 - Structural bonding
- France: Technical Approval, CSTB, Avis Technique 3.3/19-1005\_V1
- Italy: Certificate of Technical Valuation, CSLLPP, No. 209/2019
- Poland: National Technical Assessment Sika CarboDur® kit, ITB, No. ITB-KOT-2019/0415 v.1, ITB-KOT-2018/0414 v.2
- Poland: Technical Approval Sika CarboDur, Nr. IB-DiM-KOT-2019-0361 v.1
- Romania: Technical Agreement, CTPC, No. 016-011401-2019
- Serbia: Test Report, University of Belgrade, No. 368/2019
- Spain: Technical Approval, DIT, No. N604R/19
- Ukraine: Test Report, Ministry of Regional Development (Ukraine), No. 3HT-219-2167.13-001
- Slovakia: Technical Assessment, TSUS, No. SK04-ZSV-2669
- Russia: Technical Certificate SikaWrap®, No. 6078-20
- Czech Republic: Technical Approval, ITC, Nr. STO-AO 224-1012/2020

<b>Composition</b>	Epoxy resin	
<b>Packaging</b>	Part A+B	5 kg pre-batched container
	Part A (Bulk)	24 kg container
	Part B (Bulk)	6 kg container
	Refer to current price list for packaging variations	
<b>Colour</b>	Part A	white paste
	Part B	grey paste
	Parts A + B mixed	light grey paste
<b>Shelf life</b>	24 months from date of production	
<b>Storage conditions</b>	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging.	
<b>Density</b>	Mixed resin 1,30 ± 0,1 kg/l Value at +23 °C	
<b>Viscosity</b>	Shear rate: 50 / s	
	<b>Temperature</b>	<b>Viscosity</b>
	+10 °C	~10 000 mPa·s
	+23 °C	~6000 mPa·s
	+35 °C	~5000 mPa·s

## TECHNICAL INFORMATION

<b>Modulus of elasticity in flexure</b>	~3800 N/mm <sup>2</sup> (7 days at +23 °C)		(DIN EN 1465)
<b>Tensile strength</b>	~30 N/mm <sup>2</sup> (7 days at +23 °C)		(ISO 527)
<b>Modulus of elasticity in tension</b>	~4500 N/mm <sup>2</sup> (7 days at +23 °C)		(ISO 527)
<b>Tensile strain at break</b>	0,9 % (7 days at +23 °C)		(ISO 527)
<b>Tensile adhesion strength</b>	Concrete fracture (> 4 N/mm <sup>2</sup> ) on sandblasted substrate		(EN ISO 4624)
<b>Coefficient of thermal expansion</b>	4,5 × 10 <sup>-5</sup> 1/K (linear expansion between -10 °C and +40 °C)		(EN 1770)
<b>Glass transition temperature</b>	<b>Curing time</b>	<b>Curing temperature</b>	<b>TG</b>
	30 days	+30 °C	+58 °C
<b>Heat deflection temperature</b>	<b>Curing time</b>	<b>Curing temperature</b>	<b>HDT</b>
	7 days	+10 °C	+36 °C
	7 days	+23 °C	+47 °C
	7 days	+35 °C	+53 °C
	Resistant to continuous exposure +45 °C.		
<b>Service temperature</b>	-40 °C to +45 °C		

## SYSTEM INFORMATION

<b>System structure</b>	Substrate primer: Sikadur®-330 Impregnating / laminating resin: Sikadur®-330 Structural strengthening fabric - SikaWrap® type to suit requirements
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# APPLICATION INFORMATION

<b>Mixing ratio</b>	Part A : Part B = 4 : 1 by weight		
<b>Consumption</b>	Guide: ~0,7–1,5 kg/m <sup>2</sup> Also refer to: ▪ Sika Method Statement: SikaWrap® manual dry application - Ref 850 41 02.		
<b>Ambient air temperature</b>	+10 °C min. / +35 °C max.		
<b>Dew point</b>	Beware of condensation. The substrate and uncured applied resin must be at least +3 °C above dew point to reduce the risk of condensation or blooming on the resin surface.		
<b>Substrate temperature</b>	+10 °C min. / +35 °C max.		
<b>Substrate moisture content</b>	≤ 4 % parts by weight The following test methods can be used: Sika®-Tramex meter, CM-measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).		
<b>Pot Life</b>	<b>Temperature</b>	<b>Pot life</b>	<b>Open time</b> (EN ISO 9514)
	+10 °C	~90 minutes (5 kg)	~90 minutes
	+23 °C	~60 minutes (5 kg)	~60 minutes
	+35 °C	~30 minutes (5 kg)	~30 minutes
The pot life begins when the resin and hardener are mixed. It is shorter at high temperatures and longer at low temperatures. The greater the quantity mixed, the shorter the pot life. To obtain longer workability at high temperatures, the mixed adhesive may be divided into portions. Another method is to chill components A+B before mixing them (not below +5 °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.

## FURTHER INFORMATION

- Sika Method Statement: SikaWrap® manual dry application -Ref 850 41 02.

## IMPORTANT CONSIDERATIONS

- Sikadur® resins are formulated to have low creep under permanent loading. However due to the creep behaviour of all polymer materials under load, the long term structural design load must account for creep. Generally, the long-term structural design load must be lower than 20–25 % of the failure load. Please consult a structural engineer for load calculations for the specific application.
- At low temperatures and / or high relative humidity, a tacky residue (blush) may form on the surface of the cured product. If an additional layer of fabric or a coating is to be applied onto the cured product, this residue must first be removed with warm, soapy water to ensure adequate bond.
- If the surface of the cured product becomes wet or

damp, dry before application of the next layer or coating.

- Protect from rain for at least 24 hours after application.
- Ensure placement of fabric and laminating with roller takes place within open time.
- For application in cold or hot conditions, pre-condition material for 24 hours in temperature-controlled storage facilities to improve mixing, application and pot life limits.
- For further information on number of layers or creep, consult a structural engineer for calculations. Also refer to the Sika Method Statement: SikaWrap® manual dry application -Ref 850 41 02.

## 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 containing physical, ecological, toxicological and other safety-related data.

# APPLICATION INSTRUCTIONS

## SUBSTRATE QUALITY

Substrates must be structurally sound and of sufficient tensile strength to provide a minimum tensile strength of 1,0 N/mm<sup>2</sup> or as required in the design specification.

Reference must be made to the Sika® Method Statement:

- Method Statement: SikaWrap® manual dry application - Ref 850 41 02

## SUBSTRATE PREPARATION

See the "Method Statement for SikaWrap® manual dry application" Ref 850 41 02.

## MIXING

**Important:** Avoid over mixing to minimise air entrainment.

Note: Use a spiral paddle in an electric single (Pre-batched unit) or double paddle mixer (Bulk container) at a maximum speed of 300 rpm.

### Pre-batched unit

**Important:** Mix full units only

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

### Bulk container

Note: Mix only the quantity which can be used within its pot life.

Add both parts in the correct proportion into a suitable clean, dry container and mix in the same way as for the pre-batched unit.

## APPLICATION METHOD / TOOLS

Reference must be made to the Sika® Method Statement:

- Sika Method Statement: SikaWrap® manual dry application - Ref 850 41 02

## CLEANING OF EQUIPMENT

Clean all equipment immediately with Sika® Colma Cleaner. Cured 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.

**Sika (Thailand) Limited**  
700/37 Moo 5 Amata City Chonburi  
Industrial Estate, T. Klong Tamhru  
A. Muang, Chonburi 20000, Thailand  
Tel : +66 3810 9500  
E-mail : sikathai@th.sika.com  
Website: tha.sika.com



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