

PRODUCT DATA SHEET

Sikadur[®]-32 Hi-Mod LPL

High-modulus, high-strength, extended pot life, epoxy bonding/grouting adhesive

PRODUCT DESCRIPTION

Sikadur[®]-32 Hi-Mod LPL is a multi-purpose, 2-component, 100% solids, moisture-tolerant, structural epoxy adhesive. Sikadur[®]-32 Hi-Mod LPL offers a long pot life and contact time even at 100 °F (38 °C). Sikadur[®]-32 Hi-Mod LPL conforms to the current ASTM C-881, Types I and II, Grade-2, Class-C and AASHTO M-235 specifications.

USES

Sikadur[®]-32 Hi-Mod LPL may only be used by experienced professionals.

- Hot weather concrete placements requiring a bonding adhesive.
- Bond fresh, plastic concrete to hardened concrete and steel.
- Grout horizontal cracks in structural concrete and wood by gravity feed.
- Machinery and baseplate grout.
- Structural adhesive for concrete, masonry, metal, wood, etc.

CHARACTERISTICS / ADVANTAGES

- Extended pot life and contact time at elevated temperatures.
- High-strength bonding/grouting adhesive.
- Tolerant of moisture before, during, and after cure.
- Excellent adhesion to most structural materials.
- Convenient easy-to-mix ratio A:B = 1:1 by volume.
- Easy-to-use for bonding/grouting applications.

PRODUCT INFORMATION

Packaging	1 (3.8 L) and 4 gal. (15.1 L) units
Color	Dark gray
Shelf Life	24 months in original, unopened containers
Storage Conditions	Store dry at 40–95 °F (4–35 °C). Condition material to 65–75 °F (18–24 °C) before using
Viscosity	Approximately 2,800 cps.

TECHNICAL INFORMATION

Compressive Strength		40 °F* (4 °C)	73 °F* (23 °C)	(ASTM D-695) 50 % R.H.
	1 day	-	-	
	3 day	-	10,700 psi (73.8 MPa)	
	7 day	2,500 psi (17.2 MPa)	11,000 psi (75.9 MPa)	
	14 day	8,300 psi (57.2 MPa)	12,000 psi (82.3 MPa)	
	28 day	10,000 psi (68.9 MPa)	13,000 psi (89.7 MPa)	
	* Material cured and tested at the temperatures indicated.			
Modulus of Elasticity in Compression	2.6 x 10 ⁵ psi (1,794 MPa) (28 days)			(ASTM D-695) 73 °F (23 °C) 50 % R.H.
Flexural Strength	9,100 psi (62.8 MPa) (14 days)			(ASTM D-790) 73 °F (23 °C) 50 % R.H.
Modulus of Elasticity in Flexure	7.3 X 10 ⁵ psi (5,037 MPa) (14 days)			(ASTM D-790) 73 °F (23 °C) 50 % R.H.
Tensile Strength	5,800 psi (40.0 MPa) (14 days)			(ASTM D-638) 73 °F (23 °C) 50 % R.H.
Elongation at Break	5 % (14 days)			(ASTM D-638) 73 °F (23 °C) 50 % R.H.
Shear Strength	6,400 psi (44.1 MPa) (14 days)			(ASTM D-732) 73 °F (23 °C) 50 % R.H.
Slant Shear Strength	Plastic concrete to hardened concrete	2,200 psi (15.2 MPa)	14 day (moist cure)	(ASTM C-882) 73 °F (23 °C) 50 % R.H.
	Plastic concrete to steel	2,200 psi (15.2 MPa)	14 day (moist cure)	
	Hardened concrete to hardened concrete	3,100 psi (21.3 MPa)	2 day (dry cure)	
	Hardened concrete to hardened concrete	2,900 psi (20 MPa)	14 day (moist cure)	
Heat Deflection Temperature	108 °F (42 °C) (14 days at (fiber stress loading = 264 psi {1.8 MPa}))			(ASTM D-648)
Water Absorption	0.15 % (7 days, 4 hours)			(ASTM D-570)

APPLICATION INFORMATION

Mixing Ratio	Component 'A' : Component 'B' = 1:1 by volume
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Pot Life

Approximately 90 minutes at 73 °F (23 °C). (8 fl. oz., 237 ml volume)
Approximately 60 minutes at 100 °F (38 °C). (8 fl. oz., 237 ml volume)

Contact Time

	Substrate Temperature 40 °F (4 °C)	Substrate Temperature 73 °F (23 °C)	Substrate Temperature 90 °F (32 °C)
Material Temperature 73 °F (23 °C)	10–14 h	6–7 h	2–2.5 h
Material Temperature 100 °F (38 °C)	6–8 h	5–6 h	1.5–2 h

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

Surface must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes and any other contaminants.

Preparation Work: Concrete - Should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means.

Steel - Should be cleaned and prepared thoroughly by blast cleaning or other equivalent mechanical means.

MIXING

Pre-mix each component. Proportion equal parts by volume of Component 'A' and Component 'B' into clean pail. Mix thoroughly for 3 minutes with Sika paddle on low-speed (400–600 rpm) drill until blend is a uniform color. Mix only that quantity that can be applied within its pot life.

APPLICATION METHOD / TOOLS

To bond fresh concrete to hardened concrete - Apply by brush, roller, broom, or spray. Place fresh concrete while Sikadur®-32 Hi-Mod LPL is still tacky. If coating becomes glossy and loses tackiness, remove any surface contaminants then recoat with additional Sikadur®-32 Hi-Mod LPL and proceed.

To grout base plates - Add 1 1/2 parts of oven-dried aggregate to 1 part of mixed Sikadur®-32 Hi-Mod LPL by volume. Place grout under baseplate. Avoid contact with the underside of the plate. A 1/4 to 3/8 in. (6–10 mm) space should remain between the top of the grout and the bottom of the plate. Maximum thickness of grout per lift is 1.5 in. (38 mm) If multiple lifts are needed, allow preceding layer to cool to touch before applying additional layer. The remaining 1/4 to 3/8 in. (6–10 mm) space should be filled with neat Sikadur®-32 Hi-Mod LPL. Pour a sufficient quantity of neat epoxy to allow the level to rise slightly higher than the underside of the

bearing plate.

To gravity feed cracks - Pour neat material into vee-notched crack. Continue placement until completely filled. Seal underside of slab prior to filling if cracks reflect through.

LIMITATIONS

- Minimum substrate and ambient temperature 40 °F (4 °C)
- For spray applications, consult Technical Service
- Use only oven-dry aggregate
- Material is a vapor barrier after cure
- For applications on exterior, on-grade substrates, consult Technical Service
- Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure

BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

OTHER RESTRICTIONS

See Legal Disclaimer.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED

- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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