

Sikadur® 33

High-modulus, high-strength, structural,
very rapid-curing epoxy, smooth-paste adhesive

Description	Sikadur 33 is a 2-component, 100% solids, moisture-tolerant, high-modulus, high-strength, structural, smooth-paste epoxy adhesive. It conforms to the current ASTM C-881, Types I and II, Grade-3, Class B/C* and AASHTO M-235 specifications. *except for gel time
Where to Use	<ul style="list-style-type: none"> Use to seal cracks and to secure injection ports in structural concrete and wood trusses prior to pressure-injection grouting.
Advantages	<ul style="list-style-type: none"> New smooth-paste consistency for vertical, horizontal and overhead crack sealing. Very rapid curing, even in thin film, for faster pressure-injection grouting. Injection may proceed as soon as 1 hour after application.

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life	2 years 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.		
Color	Concrete gray.		
Mixing Ratio	Component 'A': Component 'B' = 1:1 by volume.		
Consistency	Smooth-paste adhesive.		
Pot Life	Approximately 15 minutes. (60 gram mass)		
Tack-Free Time	40°F (4°C)*	73°F (23°C)*	90°F (32°C)*
	1.5-1.75 hr	25-30 min	20-25 min
Tensile Properties (ASTM D-638)			
1 day	Tensile Strength	3,300 psi (22.7 MPa)	
	Elongation at Break	0.2%	
	Modulus of Elasticity	8.3 X 10 ⁵ psi (5,700 MPa)	
Flexural Properties (ASTM D-790)			
1 day	Flexural Strength (Modulus of Rupture)	4,800 psi (33.1 MPa)	
	Tangent Modulus of Elasticity in Bending	1.2 X 10 ⁶ psi (8,300 MPa)	
Shear Properties (ASTM D-732) 1 day			
	Shear Strength	2,200 psi (15.2 MPa)	
Heat Deflection Temperature (ASTM D-648)			
1 day	120°F (49°C)	[fiber stress loading = 264 psi (1.8 MPa)]	
Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete			
2 day	(dry cure)	3,000 psi (20.6 MPa)	
Water Absorption (ASTM D-570) 7 day (24 hour immersion) 0.36 %			
Compressive Properties (ASTM D-695)			
Compressive Strength, psi (MPa)			
	40°F (4°C)*	73°F (23°C)*	90°F (32°C)*
1 hour	30 (0.20)	5,600 (38.6)	4,600 (31.7)
2 hour	1,800 (12.4)	6,700 (46.2)	5,600 (38.6)
4 hour	3,500 (24.1)	7,800 (53.7)	5,700 (39.3)
8 hour	6,300 (43.4)	8,200 (56.5)	6,600 (45.5)
16 hour	6,900 (47.5)	8,500 (58.6)	7,100 (48.9)
1 day	7,400 (51)	8,600 (59.3)	7,300 (50.3)
3 day	7,900 (54.4)	9,000 (62)	7,600 (52.4)
7 day	8,300 (57.2)	9,200 (63.4)	7,800 (53.7)
14 day	8,500 (58.6)	9,200 (63.4)	8,100 (55.8)
28 day	8,600 (59.3)	9,400 (64.8)	8,300 (57.2)
Compressive Modulus 28 day	9.6 X 10 ⁵ psi (6,600 MPa)		

* Material cured and tested at the temperatures indicated.



- Convenient easy mix ratio A:B = 1:1 by volume.
- Tolerant of moisture before, during and after cure.
- High-modulus, high-strength, rapid curing smooth-paste adhesive.
- Excellent adhesion to masonry, concrete, wood, steel and most structural materials.

Coverage	1 gal. yields 231 cu. in. of paste adhesive.
Packaging	2 gal. unit
How to Use	
Surface 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.
Mixing	Pre-mix each component. Proportion equal parts by volume of Component 'B' and Component 'A' into a clean pail. Mix thoroughly for 3 minutes with Sika paddle on low-speed (400-600 rpm) drill until uniform in color. Mix only that quantity that can be used within its pot life.
Application	To seal injection ports and cracks for injection grouting - Place the neat mixed material over the cracks to be pressure-injected and around each injection port. Allow sufficient time to set before pressure-injecting. Use Sikadur 35, Hi-Mod LV, or Sikadur 52 for the low-viscosity injection adhesive. Consult technical data sheets on these products for more information. For additional information on pressure-injection grouting, contact Technical Services at 800-933-7452.
Limitations	<ul style="list-style-type: none"> ■ Minimum substrate and ambient temperature 40°F (4°C). ■ Do not thin. Addition of solvents will prevent proper cure. ■ Material is a vapor barrier after cure. ■ Not for sealing cracks under hydrostatic pressure at the time of application. ■ Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.
Warning	Component 'A' - IRRITANT; SENSITIZER - Contains epoxy resin neopentyl glycol diglycidyl ether. May cause skin sensitization after prolonged or repeated contact. Eye irritant. May cause skin/respiratory irritation. Harmful if swallowed. Component 'B' - CORROSIVE; SENSITIZER - Contains amines. Contact with eyes or skin causes severe burns. May cause skin sensitization after prolonged or repeated contact. Skin/eye/respiratory irritant. Harmful if swallowed. Deliberate concentration of vapors of Component A or B for purposes of inhalation is harmful and can be fatal.
First Aid	Eyes: Hold eyelids apart and flush thoroughly with water for 15 minutes. Skin: Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. Inhalation: Remove person to fresh air. Ingestion: Do not induce vomiting. In all cases, contact a physician immediately if symptoms persist.
Clean Up	Wear chemical resistant gloves/goggles/clothing. Ventilate area. In absence of adequate general and local exhaust ventilation, use a properly filled NIOSH respirator. Confine spill. Collect with absorbent material. Dispose of in accordance with current, applicable local, state, and federal regulations. Uncured material can be removed with approved solvent. Strictly follow manufacturer's warnings and instructions for use. Cured material can only be removed mechanically.
Handling & Storage	Avoid direct contact with skin and eyes. Wear chemical resistant gloves/goggles/clothing. Use only with adequate ventilation. In absence of adequate general and local exhaust ventilation, use a properly filled NIOSH respirator. Wash thoroughly after handling product. Launder clothing before reuse. Store in a cool dry well ventilated area.

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