



Construction

Sikadur 32, Hi-Mod

Application Instructions



Sika Corporation

Sikadur 32, Hi-Mod

- ▲ Structural epoxy adhesive
- ▲ Multi-purpose
- ▲ Two-component
- ▲ 100% solids
- ▲ Moisture-tolerant



Sikadur 32, Hi-Mod

▲ Where to use:

- Bonding fresh, plastic concrete to hardened concrete and steel
- Grout horizontal cracks in structural concrete and wood by gravity feed
- Machinery and 'robotic' base-plate grout
- As a structural adhesive for:
 - Concrete
 - Masonry
 - Metal
 - Wood



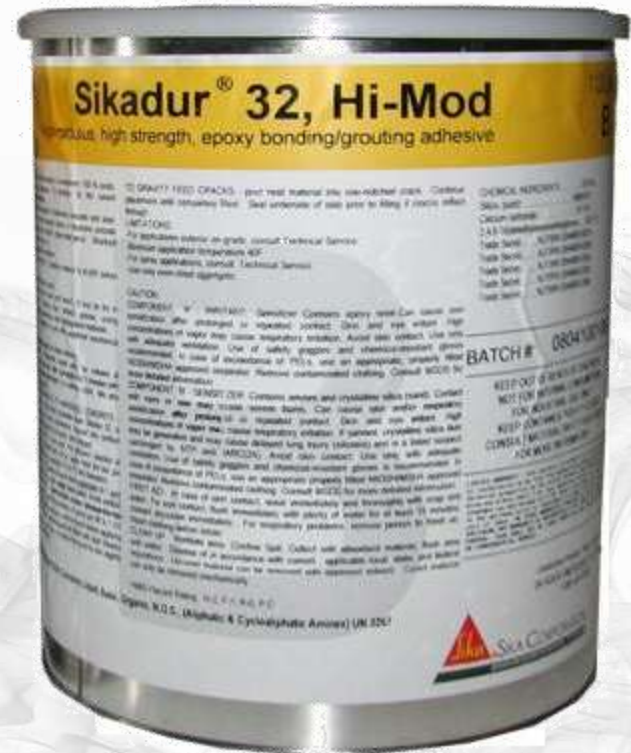
Sikadur 32, Hi-Mod

▲ Packaging:

- 1, 2 and 4 gal. units

▲ Coverage:

- **Bonding Adhesive**
 - 1 gal. covers approx 80 ft² on smooth surface.
- **Base Plate Grout**
 - 1 gal. yields approx 420 in³ of grout.
- **Anchoring Grout**
 - 1 gal. yields approx 231 in³ of grout.



Surface Preparation

- ▲ Surface must be clean and sound.
- ▲ Surface can be either dry or damp, but free of standing water.
- ▲ Remove dust, laitance, grease, curing compounds, impregnations, waxes and any other contaminants before application.



Surface Preparation

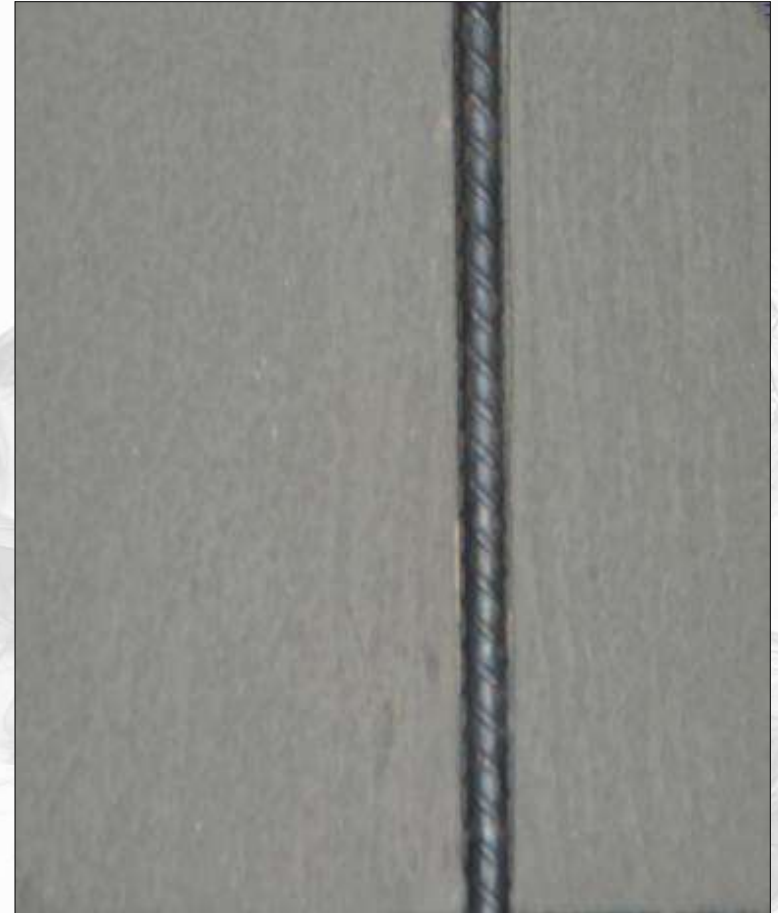
▲ Concrete:

- Surface should be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or equivalent mechanical means.



Steel Preparation

- ▲ **Steel**
 - Steel should be cleaned and prepared thoroughly by blast cleaning.



Tools Required

- ▲ 1/2" drill motor
- ▲ Low speed drill (400-600 rpm)
- ▲ Drill and paddle for mixing
- ▲ Spatula



Mixing

- ▲ Proportion equal parts by volume of Component A and B into 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 pot life



Application

- ▲ **Bond fresh concrete to hardened concrete**
 - Apply by brush, roller, broom or spray.
 - While Sikadur 32, Hi-Mod is still tacky, place fresh concrete on it.
 - Recoat with additional Sikadur 32 Hi-Mod, if the coating becomes glossy or loses tackiness.



Application

- ▲ To grout base plates
 - Add 1 ½ parts of oven-dried aggregate to 1 part of mixed Sikadur 32, Hi-Mod.
 - Place grout under base plate and avoid contact with the underside of the plate.
 - A ¼ to 3/8 in. space should remain between the top of the grout and the bottom of the plate.



Application

- ▲ **To grout base plates**
 - 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. space should be filled with neat Sikadur 32 Hi-Mod. The level should rise slightly higher than the underside of the bearing plate.



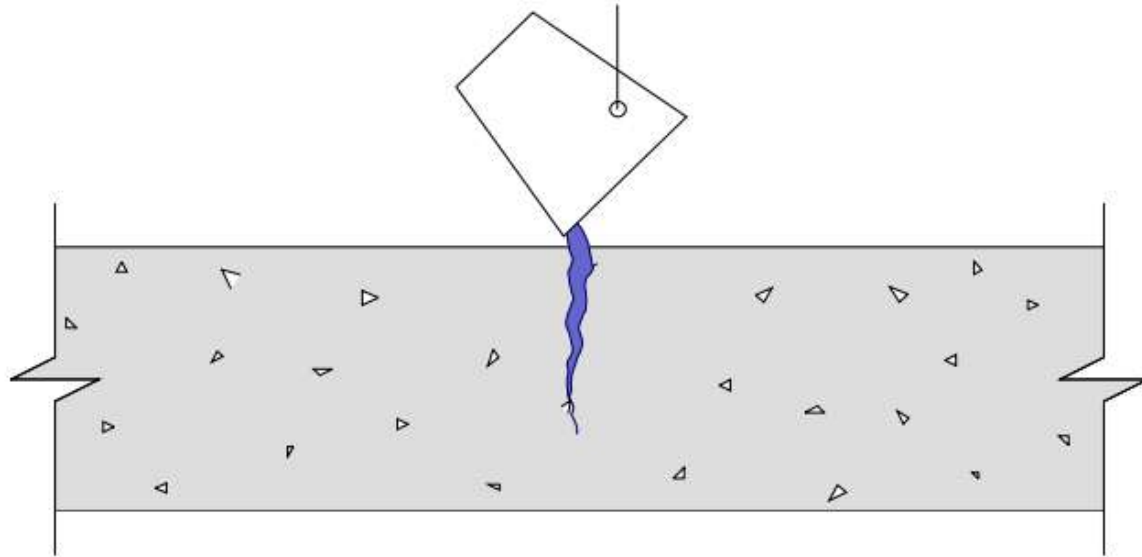
Void is filled with Sikadur 32 Hi-Mod



Application

▲ To gravity feed cracks

- Pour neat material into V-notched crack.
- Continue placement until completely filled.
- Seal underside of slab prior to filling if cracks reflects through.



Precaution

- ▲ Avoid skin and eye contact
- ▲ Wear
 - chemical resistant gloves
 - goggles
- ▲ Ventilate area
- ▲ Dispose of in accordance with local, state and federal regulations
- ▲ Uncured material can be removed with approved solvent
- ▲ Follow manufacturer's warnings and instructions for use



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Sika Product Data Sheets can be obtained via:

<http://usa.sika.com>

Refer to data sheets for specific information on each Sika product.



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