

PRODUCT DATA SHEET

Icosit[®] KC 330 FK NEW

2-component polyurethane adhesive for fixing filler blocks

DESCRIPTION

Icosit[®] KC 330 FK NEW is a 2-component, solvent-free, flexible adhesive based on polyurethane for the application in track construction.

USES

Icosit[®] KC 330 FK NEW may only be used by experienced professionals.

Particularly suited for fixing filler blocks to the web of grooved rails for in-street installation of trackwork. Flexible adhesive designed for e. g. fixing machinery in industry, for joining various construction materials, in particular metal and concrete, e. g. for fixing stainless steel cladding to the running surface of clarifiers in sewage treatment plant.

CHARACTERISTICS / ADVANTAGES

- Excellent weathering and ageing resistance
- High initial adhesion
- Levels out tolerances
- Usually no need for temporary fixation
- Vibration reducing
- Sound absorbing

PRODUCT INFORMATION

Packaging	Part A	9 kg pail
	Part B	1 kg tin
	A + B	10 kg
Colour	Black	
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 +10 °C and +25 °C. Always refer to packaging.	
Density	Part A	~1.4 kg/l (ISO 2811-1)
	Part B	~1.2 kg/l (ISO 2811-1)
	A + B	~1.4 kg/l (ISO 1183-1)

The density of the mixed material (A + B) is determined by calculation.

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TECHNICAL INFORMATION

Shore A hardness	85 ± 5 (after 28 days) Shore hardness assists with material identification and assessing the curing progress on site.	(ISO 868)
Tensile strength	~3 N/mm ²	(ISO 527)
Tensile strain at break	~50 %	(ISO 527)
Tear strength	~ 8.5 N/mm ²	(ISO 34 B)
Chemical resistance	Long-term resistant against: <ul style="list-style-type: none">▪ Water▪ Most detergents▪ Sea water, alkaline water Short-term resistant against: <ul style="list-style-type: none">▪ Mineral oils, diesel fuel Short-term or no resistance against: <ul style="list-style-type: none">▪ Organic solvents (ester, ketone, aromates), alcohol and thinners▪ Concentrated lyes and acids <p>Contact Sika Technical Services for specific information.</p>	
Service temperature	min. -40 °C / max. +80 °C short term up to +150 °C	

APPLICATION INFORMATION

Mixing ratio	Part A : Part B = 100 : 11 (parts by weight)		
Consumption	~1.4 kg per litre of volume		
Layer thickness	min. 3 mm / max. 30 mm		
Product temperature	Condition product parts before application preferably at ~+15 °C to ~+25 °C.		
Ambient air temperature	+5 °C min. / +35 °C max.		
Relative air humidity	70 % max.		
Substrate temperature	+5 °C min. / +35 °C max.		
Substrate moisture content	Dry		
Pot Life	~15 minutes at +20 °C After this time, the mixture becomes unuseable. Higher temperatures will shorten potlife.		
Curing time	Track-free: ~3 hours (+20 °C) Trafficable: ~24 hours (+20 °C)		
Waiting time to overcoating		Minimum	Maximum
	Icosit® KC 330 Primer	1 hour	3 days
	SikaCor®-299 Airless	24 hours	7 days

BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

IMPORTANT CONSIDERATIONS

Material is moisture-sensitive.

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. Further notes and information data sheets on product safety and disposal can be found on the Internet at www.sika.de.

APPLICATION INSTRUCTIONS

SUBSTRATE QUALITY

Substrate must be sound, free from oil, grease, loose and friable particles.

Slightly damp substrates are acceptable. Standing water must be removed (e.g. by vacuum extraction or oil free compressed air) before pouring Icosit® KC 330 FK NEW.

SUBSTRATE PREPARATION

To improve adhesion, apply Icosit® KC 330 Primer as a primer on absorbent substrates (concrete).

For additional corrosion protection, use SikaCor®-299 Airless and Icosit® KC 330 Primer in combination to coat the steel surfaces.

Immediately blind (broadcast) the freshly applied coated surfaces with quartz sand (0,4–0,7 mm granulometry).

MIXING

Icosit® KC 330 FK NEW is supplied in pre-weighed composite units consisting of parts A + B. Part A must be stirred thoroughly before being mixed with part B. The following mixing instructions must be carried out:

- Use an electric or pneumatic mixer with basket type stirrer (diameter 120–140 mm, speed ~600–800 rpm.)
- Mixing time ~60–80 seconds
- Ensure material is mixed from the container walls and the base by the stirrer during mixing

During mixing until approx. 3 minutes afterwards, material remains liquid (pourable) and subsequently turns into a thixotropic, sag-resistant, trowel-applicable consistency.

Sika Deutschland GmbH

Kornwestheimer Straße 103 - 107

D - 70439 Stuttgart

Telefon: 0711/8009-0

Telefax: 0711/8009-0

E-Mail: info@de.sika.com

www.sika.de



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APPLICATION METHOD / TOOLS

Apply the adhesive to the prepared substrate. If necessary spread Icosit® KC 330 FK NEW by means of a spatula.

Place the element onto the adhesive and press it firmly. Either remove any fresh adhesive immediately or smooth it down with a spatula (depending on application).

CLEANING OF EQUIPMENT

Mixing and application tools must be cleaned at regular intervals and immediately after use with Sika® Reinigungsmittel-5. Hardened material can only be removed mechanically.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

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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