

# PRODUCT DATA SHEET

## Sika AnchorFix®-1

Fast curing anchoring adhesive

### DESCRIPTION

Sika AnchorFix®-1 is a solvent and styrene free based, two-component polyester anchoring adhesive.

### USES

As a fast curing anchoring adhesive for all grades of:

- Rebars / reinforcing steel
- Threaded rods / bolts
- Concrete
- Hollow and solid masonry

### CHARACTERISTICS / ADVANTAGES

- Fast curing
- Standard guns can be used
- Can be used at low temperatures
- High load capacity
- Non-sag, even overhead
- Styrene-free
- Low odour
- Low wastage

### APPROVALS / CERTIFICATES

- Injection system for use in masonry according to ETAG 029, ETA-12/0227, Declaration of Performance 020403010010000001 5034408, certified by notified product certification body 0679, certificate of constancy of performance 0679-DPD-0777, and provided with the CE marking
- Bonded injection type anchor for non cracked concrete according to ETAG 001 annex 1 and 5, ETA-13/0720, Declaration of Performance 020403010010000001 5034408, certified by notified product certification body 1020, certificate of constancy of performance 1020-CPD-090-029816, and provided with the CE marking.

### PRODUCT INFORMATION

<b>Packaging</b>	300 ml standard cartridge: 12 cartridges per box / pallet: 75 boxes	
<b>Shelf life</b>	12 months from date of production All Sika AnchorFix®-1 cartridges have the expiry date printed on the label.	
<b>Storage conditions</b>	Stored properly in original, unopened, sealed and undamaged packaging in dry conditions at temperatures between +5 °C and +25 °C. Protect from direct sunlight.	
<b>Colour</b>	Component A:	white
	Component B:	black
	Component A+B mixed:	light grey
<b>Density</b>	~1.63 kg/l (component A+B mixed)	

### TECHNICAL INFORMATION

<b>Compressive strength</b>	~60 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 695)
<b>Modulus of elasticity in compression</b>	~3,500 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 695)
<b>Tensile strength in flexure</b>	~28 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 790)
<b>Tensile strength</b>	~12 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
<b>Modulus of elasticity in tension</b>	~4,500 N/mm <sup>2</sup> (7 days, +20 °C)	(ASTM D 638)
<b>Temperature resistance</b>	Long term	40 °C min. / +50 °C max.
	Short term (1–2 hours)	+80 °C

## APPLICATION INFORMATION

**Mixing ratio** Component A : component B = 10 : 1 by volume

**Consumption** Material consumption per drill hole:

Anker ø mm	Bohrer ø mm	Bohrlochtiefe in mm																	
		80	90	110	120	130	140	160	170	180	200	210	220	240	260	280	300	350	400
M8	10	3,4	3,8	4,6	5,0	5,4	5,9	6,7	7,1	7,5	8,4	8,8	9,2	10,1	10,9	11,7	12,6	14,7	16,8
M10	12	4,4	5,0	6,1	6,6	7,2	7,7	8,8	9,4	9,9	11,0	11,6	12,1	13,2	14,3	15,4	16,5	19,3	22,0
M12	14	5,6	6,3	7,7	8,4	9,1	9,8	11,2	11,8	12,5	13,9	14,6	15,3	16,7	18,1	19,5	20,9	24,4	27,9
M14	16	6,9	7,7	9,5	10,3	11,2	12,0	13,8	14,6	15,5	17,2	18,1	18,9	20,6	22,4	24,1	25,8	30,1	34,4
M14	18	11,2	12,6	15,4	16,8	18,2	19,6	22,4	23,8	25,2	28,0	29,4	30,8	33,6	36,4	39,2	42,0	49,0	56,0
M16	18	7,8	8,8	10,8	11,8	12,7	13,7	15,7	16,7	17,6	19,6	20,6	21,6	23,5	25,5	27,4	29,4	34,3	39,2
M16	20	12,6	14,1	17,3	18,8	20,4	22,0	25,1	26,7	28,3	31,4	33,0	34,5	37,7	40,8	44,0	47,1	55,0	62,8
M20	22	10,8	12,2	14,9	16,2	17,6	18,9	21,6	23,0	24,3	27,0	28,4	29,7	32,4	35,1	37,8	40,5	47,3	54,0
M20	24	16,6	18,6	22,8	24,8	26,9	29,0	33,1	35,2	37,3	41,4	43,5	45,5	49,7	53,8	58,0	62,1	72,5	82,8
M20	25	19,7	22,1	27,1	29,5	32,0	34,4	39,4	41,8	44,3	49,2	51,7	54,1	59,0	64,0	68,9	73,8	86,1	98,4
M24	26	14,2	16,0	19,6	21,4	23,1	24,9	28,5	30,3	32,0	35,6	37,4	39,2	42,7	46,3	49,8	53,4	62,3	71,2
M27	30	19,4	21,9	26,7	29,2	31,6	34,0	38,9	41,3	43,7	48,6	51,0	53,5	58,3	63,2	68,0	72,9	85,1	97,2

Anker: Anchor

Bohrer: Drill

Bohrlochtiefe in mm: Drill hole depth in mm

The above filling volumes were calculated without waste. Consumption waste is approx. 10-50 %.

The filling quantity can be checked with the help of the scale on the cartridge.

**Layer thickness** 3 mm max.

**Sag flow** Non-sag, even overhead

**Material temperature** Sika AnchorFix®-1 must be at a temperature of between +5 °C and +40 °C for application.

**Ambient air temperature** -10 °C min. / +40 °C max.

**Dew point** Beware of condensation.  
Substrate temperature during application must be at least 3 °C above dew point.

**Substrate temperature** -10 °C min. / +40 °C max.

## Curing time

Temperature	Open time - T <sub>gel</sub>	Curing time - T <sub>cur</sub>
+30 °C	4 minutes	35 minutes
+25 °C – +30 °C	4 minutes	40 minutes
+20 °C – +25 °C	5 minutes	50 minutes
+10 °C – +20 °C	6 minutes	85 minutes
+5 °C – +10 °C	10 minutes	145 minutes
+5 °C	18 minutes	145 minutes
-10 °C <sup>1 2</sup>	30 minutes	24 hours

1 Minimum cartridge temperature: +5 °C

2 This application is not covered by the scope of the product ETA or any other approval.

## 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.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

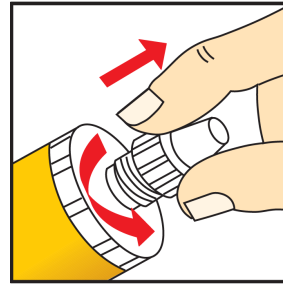
## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY

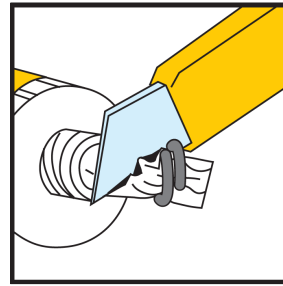
- Mortar and concrete must be at the required strength. No need to be 28 days old.
- Substrate strength (concrete, masonry, natural stone) must be verified.
- Pull-out tests must be carried out if the substrate strength is unknown.
- The anchor hole must always be clean, dry, free from oil and grease etc.
- Loose particles must be removed from the holes.
- Threaded rods and rebars have to be cleaned thoroughly from any oil, grease or any other substances and particles such as dirt etc.

## MIXING

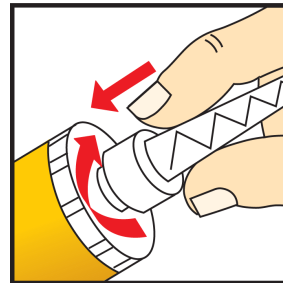
### Getting the cartridge ready: 300 ml / 550 ml



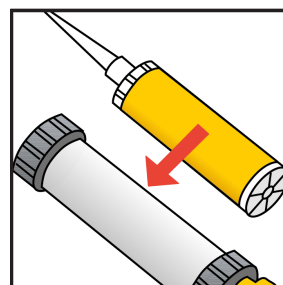
1. Unscrew the cap



2. Cut the film



3. Screw on the static mixer



4. Place the cartridge into the gun and start application

When the work is interrupted the static mixer can remain on the cartridge after the gun pressure has been relieved. If the resin has hardened in the nozzle when work is resumed, a new nozzle must be attached.

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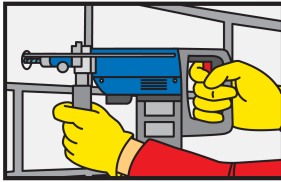
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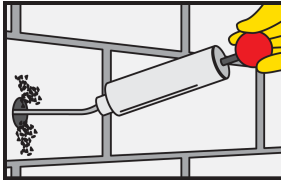
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## APPLICATION METHOD / TOOLS

### Anchors in solid masonry / concrete



Drilling of hole with an electric drill to the diameter and depth required. Drill hole diameter must be in accordance with anchor size.

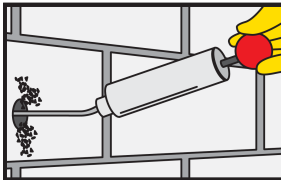


The drill hole must be cleaned with a blow pump or by compressed air, starting from the bottom of the hole (at least 2x).

Important: use oil-free compressors.



The drill hole must be thoroughly cleaned with the special steel brush (brush at least 2x). The diameter of the brush must be larger than the diameter of the drill hole.

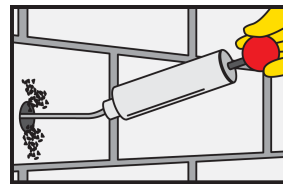


The drill hole must be cleaned with a blow pump or by compressed air, starting from the bottom of the hole (at least 2x).

Important: use oil-free compressors.

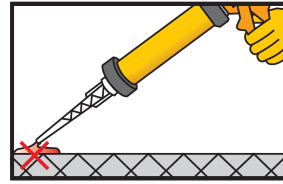


The drill hole must be thoroughly cleaned with the special steel brush (brush at least 2x). The diameter of the brush must be larger than the diameter of the drill hole.

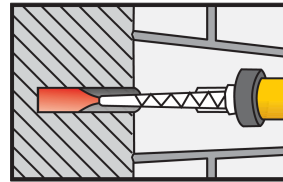


The drill hole must be cleaned with a blow pump or by compressed air, starting from the bottom of the hole. (at least 2x)

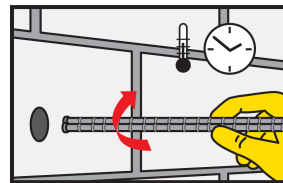
Important: use oil-free compressors.



Pump approx. twice until both parts come out uniformly. Do not use this material. Release the gun pressure and clean the cartridge opening with a cloth.

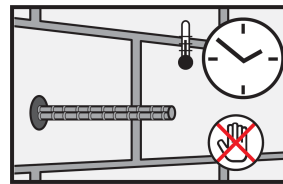


Inject the adhesive into the hole, starting from the bottom, while slowly drawing back the static mixer. In any case avoid entrapping air. For deep holes extension tubing can be used.



Insert the anchor with a rotary motion into the filled drill hole. Some adhesive must come out of the hole.

Important: the anchor must be placed within the open time.



During the resin hardening time the anchor must not be moved or loaded. Wash tools immediately with Sika® Colma Cleaner. Wash hands and skin thoroughly with warm soap water.

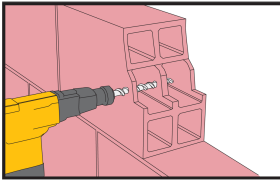
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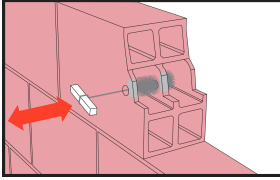
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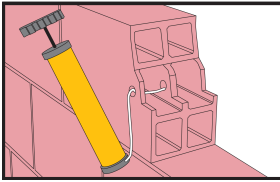
## Anchors in hollow blocks



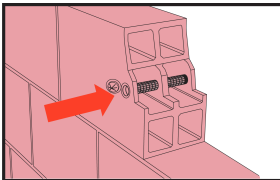
Drilling of hole with an electric drill to the diameter and depth required. Drill hole diameter must be in accordance with anchor and perforated sleeve size. Note: with hollow material do not use rotary hammer drills.



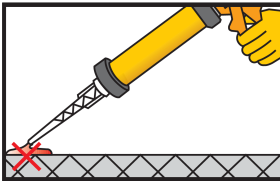
The drill hole must be thoroughly cleaned with a round brush (brush at least 1x). The diameter of the brush must be larger than the diameter of the drill hole.



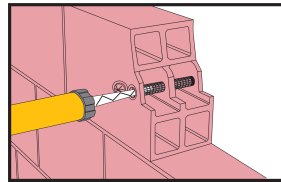
The drill hole must be cleaned after each cleaning step with a blow pump or by compressed air, starting from the bottom of the hole (pump at least 1x). Important: use oil-free compressors.



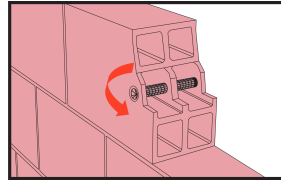
Insert perforated sleeve completely into the drill hole.



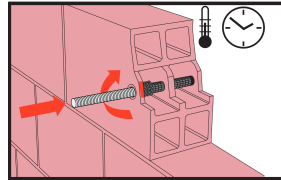
Pump approx. twice until both parts come out uniformly. Do not use this material. Release the gun pressure and clean the cartridge opening with a cloth.



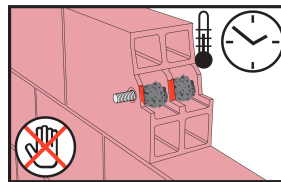
Inject the adhesive into the perforated sleeve, starting from the bottom, while slowly drawing back the static mixer. In any case avoid entrapping air.



Close the cap from the perforated sleeve to avoid some escape of the resin during entering the steel rod.



Insert the anchor with a rotary motion into the filled perforated sleeve. Use the adequate steel rod size. Important: the anchor must be placed within the open time.



During the resin hardening time the anchor must not be moved or loaded. Wash tools immediately with Sika® Colma Cleaner. Wash hands and skin thoroughly with warm soap water.

## CLEANING OF EQUIPMENT

Clean tools and application equipment with Sika® Colma Cleaner immediately after use. Hardened / cured material can only be mechanically removed.

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## 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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