

## PRODUCT DATA SHEET

# Sika AnchorFix®-1

Fast-curing polyester anchoring adhesive

### DESCRIPTION

Sika AnchorFix®-1 is a solvent-free, styrene-free, two-part polyester anchoring adhesive. It is used for anchoring threaded rods in uncracked, dry or damp concrete, and hollow or solid masonry.

### USES

Sika AnchorFix®-1 is used as a fast-curing anchoring adhesive for the following substrates:

- Concrete
- Hollow and solid masonry
- Hard natural stone
- Solid rock

Sika AnchorFix®-1 is used as a fast-curing anchoring adhesive for the following objects:

- Threaded rods
- Reinforcing steel
- Bolts and special fastening systems

Please note:

- The Product may only be used by experienced professionals.

### CHARACTERISTICS / ADVANTAGES

- Fast curing
- Standard sealant dispensers can be used
- Can be applied at low temperatures
- Suitable for use in dry, wet, and water-filled holes
- Very good load capacity
- ETA to EAD 330499-01-0601 for anchoring in uncracked concrete
- ETA to ETAG 029 for anchoring in solid and hollow masonry
- ETA based on working life of 50 years or 100 years
- Thixotropic: non-sag in vertical and overhead applications
- Styrene-free
- Low wastage
- Low odour

### SUSTAINABILITY

- LEED v2009 IEQc 4.1 Sika AnchorFix®-1

### APPROVALS / CERTIFICATES

- CE marking and declaration of performance based on European Technical Assessment ETA-13/0720. ETA issued on the basis of EAD 330499-01-0601 Bonded fasteners for use in concrete.
- CE marking and declaration of performance based on European Technical Assessment ETA 17/0179 Injection anchors for use in masonry. ETA issued on the basis of ETAG 029 Metal injection anchors for use in Masonry.

## PRODUCT INFORMATION

Packaging	150 ml standard cartridge	20 cartridges per box 75 boxes per pallet	
	300 ml standard cartridge	12 cartridges per box 75 boxes per pallet	
	550 ml standard cartridge	12 cartridges per box 50 boxes per pallet	
	Refer to the current price list for available packaging variations.		
Colour		Colour of the cured Product: concrete	Colour of the cured Product: stone
	Part A	white	white
	Part B	black	salmon
	Part A+B	light grey	beige
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 +5 °C and +25 °C. Protect the Product from direct sunlight. Refer to the current Safety Data Sheet for information on safe handling and storage.		
Density	~1.63 kg/L (component A+B mixed)		(ISO 1183-1)

## TECHNICAL INFORMATION

Compressive strength	Cured 7 days at +20 °C	60 N/mm <sup>2</sup>	(ASTM D695)
Modulus of elasticity in compression	Cured 7 days at +20 °C	3500 N/mm <sup>2</sup>	(ASTM D695)
Tensile strength in flexure	Cured 7 days at +20 °C	28 N/mm <sup>2</sup>	(ASTM D790)
Tensile strength	Cured 7 days at +20 °C	12 N/mm <sup>2</sup>	(ASTM D638)
Modulus of elasticity in tension	Cured 7 days at +20 °C	4500 N/mm <sup>2</sup>	(ASTM D638)
Service temperature	<b>Time</b>	<b>Minimum</b>	<b>Maximum</b>
	Long term	-40 °C	+50 °C
	Short term (up to 2 hours)	-	+80 °C
			(EAD 330499-01-0601)

## APPLICATION INFORMATION

Mixing ratio	Part A : Part B	10 : 1 by volume
Layer thickness	Maximum	3 mm
Sag flow	Non-sag, even overhead	
Product temperature	Maximum	+40 °C
	Minimum	+5 °C
Ambient air temperature	Maximum	+40 °C
	Minimum	-10 °C
Dew point	The substrate temperature must be at least +3 °C above dew point to reduce the risk of condensation decreasing adhesion.	

<b>Substrate temperature</b>	Maximum	+40 °C	
	Minimum	-10 °C	

<b>Curing time</b>	<b>Temperature</b>	<b>Open time - T<sub>gel</sub></b>	<b>Curing time - T<sub>cur</sub></b>
	+30 °C	4 minutes	35 minutes
	+25 °C to +30 °C	4 minutes	40 minutes
	+20 °C to +25 °C	5 minutes	50 minutes
	+10 °C to +20 °C	6 minutes	85 minutes
	+5 °C to +10 °C	10 minutes	145 minutes
	+5 °C	18 minutes	145 minutes
	Minimum cartridge temperature: +5 °C		
	-10 °C	30 minutes	24 hours
	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 Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## FURTHER INFORMATION

For design details, refer to the following technical documentation: 870 43 01 Technical Documentation Sika AnchorFix®-1 (02 / 2024) 3

## 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.

## APPLICATION INSTRUCTIONS

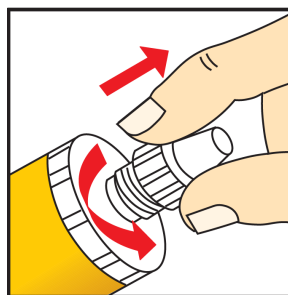
### SUBSTRATE PREPARATION

Mortar and concrete must be older than 28 days. Verify the substrate strength (concrete, masonry, natural stone). Perform pull-out tests if the substrate strength is unknown.  
Make sure that the anchor hole is clean, dry, free from oil and grease. Remove loose particles from the anchor hole.  
Clean threaded rods and reinforcement bars thoroughly. Remove oil, grease or any other substances and particles such as dirt.

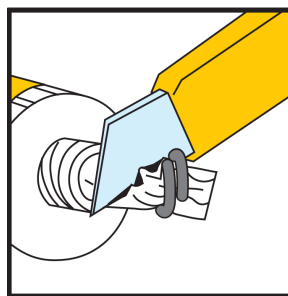
### MIXING

#### GETTING THE CARTRIDGE READY

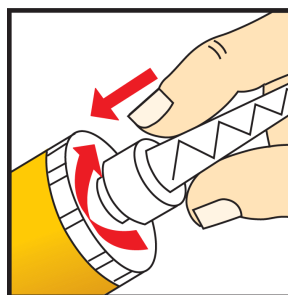
1. Unscrew the cap.



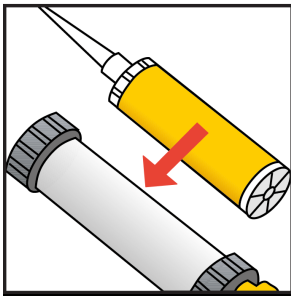
2. Cut the film if needed.



3. Screw on the static mixer.



4. Place the cartridge into the dispenser 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.

## APPLICATION

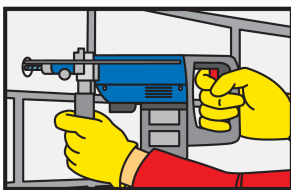
### Test if the Product is suitable for the substrate

Note: Due to the variety of possible substrates, the Product's suitability for the substrate must be confirmed before application, particularly in terms of desired bond strength, composition, porosity, potential surface staining or discolouration.

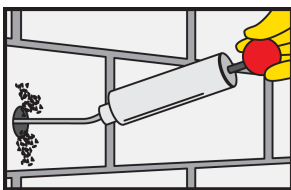
1. Test the Product's suitability in a sample area.

#### ANCHORS IN SOLID MASONRY OR CONCRETE

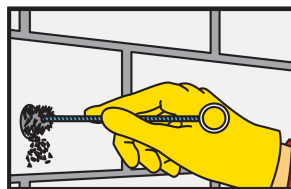
1. **IMPORTANT** Make sure that the drill hole diameter is in accordance with the anchor size. Drill a hole with an electric drill to the diameter and depth specified in the Technical Documentation listed in the section Further Information.



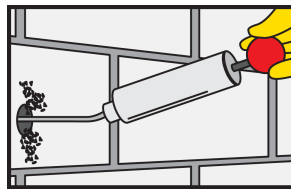
2. **IMPORTANT** Use oil-free compressors. Clean the drill hole with a blow pump or by compressed air, starting from the bottom of the hole. Note The hole must be cleaned a minimum of two times.



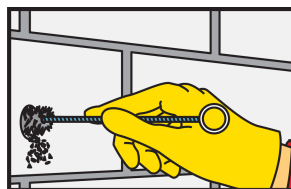
3. Thoroughly clean the drill hole with the hybrid brush. Note The diameter of the brush must be larger than the diameter of the drill hole and the hole must be cleaned a minimum of two times.



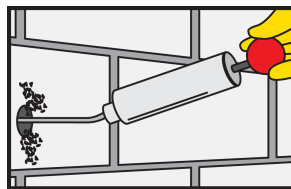
4. **IMPORTANT** Use oil-free compressors. Clean the drill hole with a blow pump or by compressed air, starting from the bottom of the hole. Note The hole must be cleaned a minimum of two times.



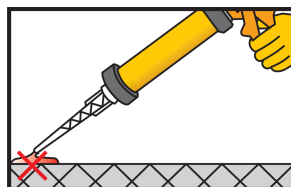
5. Thoroughly clean the drill hole with the hybrid brush. Note The diameter of the brush must be larger than the diameter of the drill hole and the hole must be cleaned a minimum of two times.



6. **IMPORTANT** Use oil-free compressors. Clean the drill hole with a blow pump or by compressed air, starting from the bottom of the hole. Note The hole must be cleaned a minimum of two times.



7. Pump the Product until both parts come out uniformly. Release the gun pressure and clean the cartridge nozzle with a cloth.



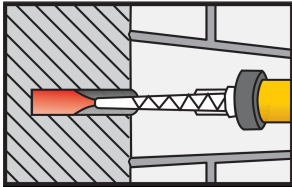
#### Product Data Sheet

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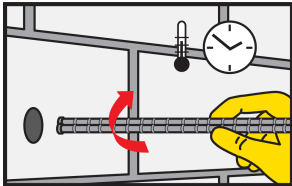
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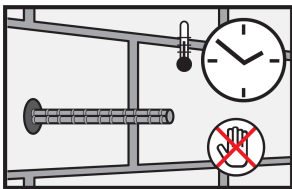
8. **IMPORTANT** Do not entrap air into the hole. Inject the Product into the hole starting from the bottom while slowly drawing back the static mixer. Note For deep holes extension tubing can be used.



9. **IMPORTANT** The anchor must be placed within the open time. Insert the anchor with a rotary motion into the filled drill hole. Note Some adhesive must come out of the hole.

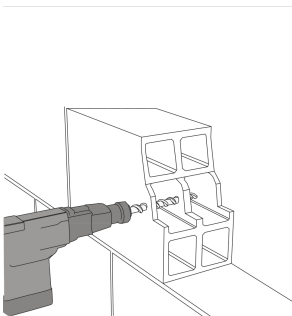


10. Do not load or move the anchor during the hardening time.

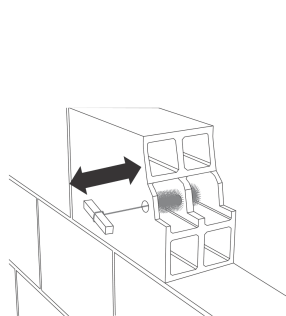


#### ANCHORS IN HOLLOW BLOCKS

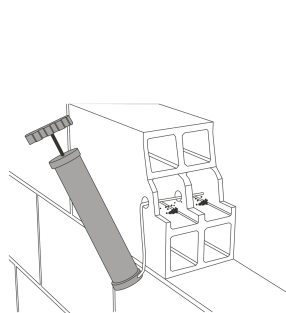
1. **IMPORTANT** Do not use rotary hammer drills. Drill a hole with an electric drill to the diameter and depth specified in the Technical Documentation listed in the section Further Information. The drill hole diameter must be in accordance with the anchor and the perforated sleeve size.



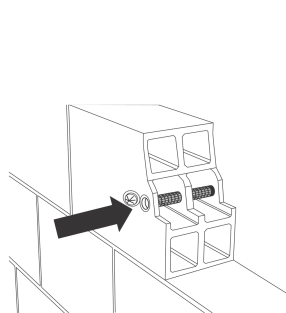
2. Clean, at least once, the drill hole with a hybrid brush. Note The diameter of the brush must be larger than the diameter of the drill hole.



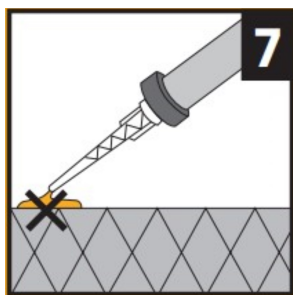
3. **IMPORTANT** Use oil free compressors. After cleaning the drill hole with the brush, clean the drill hole each time with a blow pump.



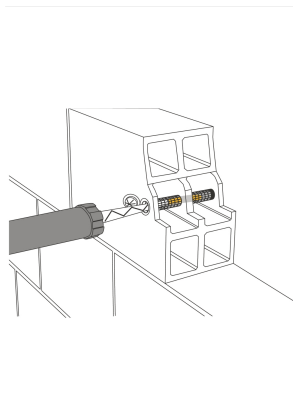
4. Insert the perforated sleeve completely into the drill hole.



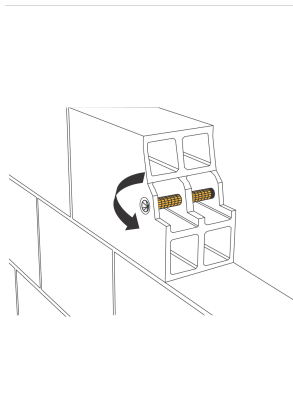
5. Pump the Product until both parts come out uniformly. Discard this material. Release the gun pressure and clean the cartridge nozzle with a cloth.



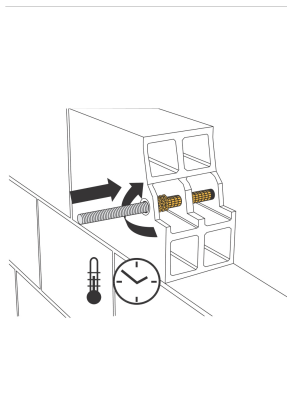
6. **IMPORTANT** Do not entrap air into the hole. Inject the Product into the perforated sleeve starting from the bottom, while slowly drawing back the static mixer.



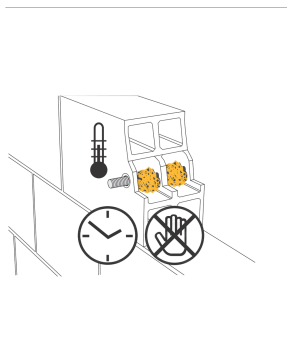
7. Close the cap of the perforated sleeve to prevent adhesive from escaping when inserting the steel rod.



8. **IMPORTANT** The anchor must be placed within the open time. Insert the anchor with a rotary motion into the filled perforated sleeve. Use the appropriate steel rod size. Note Some adhesive must come out of the hole.



9. Do not load or move the anchor during the hardening time.



## CLEANING OF EQUIPMENT

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

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

## 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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### **Product Data Sheet**

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