

## PRODUCT DATA SHEET

# Sikadur<sup>®</sup>-330 IN

Thixotropic epoxy impregnating / laminating resin for SikaWrap<sup>®</sup> structural strengthening fabrics

### DESCRIPTION

Sikadur<sup>®</sup>-330 IN is a 2-part, thixotropic, epoxy based impregnating / laminating resin for SikaWrap<sup>®</sup> structural strengthening fabrics.

### USES

Sikadur<sup>®</sup>-330 IN may only be used by experienced professionals.

- As an impregnating / laminating resin for SikaWrap<sup>®</sup> fabric reinforcement dry application method
- As a substrate primer for the wet application method
- Structural adhesive for bonding Sika<sup>®</sup> CarboDur<sup>®</sup> NSM profiles into surface slots
- Structural adhesive for bonding SikaWrap<sup>®</sup> FX anchorage cord

### CHARACTERISTICS / ADVANTAGES

- Easy to mix
- Application by trowel and impregnation roller
- Formulated for manual saturation methods
- Good application properties for vertical and overhead surfaces
- Good adhesion to many substrates
- High mechanical properties
- No separate primer required

### PRODUCT INFORMATION

|                           |  |                  |
|---------------------------|--|------------------|
| <b>Composition</b>        | Epoxy resin  |                  |
| <b>Packaging</b>          | Part A+B pre-batched   | 3 kg             |
|                           | Part A   | 2.4 kg container |
|                           | Part B   | 0.6 kg container |
| <b>Shelf Life</b>         | 12 months from date of production  |                  |
| <b>Storage Conditions</b> | The Product must be stored properly in original unopened, sealed and undamaged packaging in dry conditions at temperatures between +5 °C and +40 °C. Protect from direct sunlight. |                  |
| <b>Colour</b>             | Part A+B mixed   | Grey paste       |
|                           | Part A   | White paste      |
|                           | Part B   | Black paste      |
| <b>Density</b>            | ~1.3 kg/L (Part A+B mixed, +30 °C)   |                  |

## SYSTEM INFORMATION

|                  |                                 |                                     |
|------------------|---------------------------------|-------------------------------------|
| System Structure | Substrate primer                | Sikadur®-330 IN                     |
|                  | Impregnating / laminating resin | Sikadur®-330 IN                     |
|                  | Structural strengthening fabric | SikaWrap® type to suit requirements |

## TECHNICAL INFORMATION

|                                  |   |                |
|----------------------------------|---|----------------|
| Modulus of Elasticity in Flexure | ~2800 N/mm <sup>2</sup> (7 days at +30 °C)                          | (ISO 178)      |
| Tensile Strength                 | ~30 N/mm <sup>2</sup> (7 days at +30 °C)                            | (EN ISO 527-2) |
| Modulus of Elasticity in Tension | ~3500 N/mm <sup>2</sup> (7 days at +30 °C)                          | (EN ISO 527-2) |
| Elongation at Break              | ~0.9 % (7 days at +30 °C)   | (EN ISO 527-2) |
| Tensile Adhesion Strength        | ~4 N/mm <sup>2</sup> (concrete failure, 7 day, +30 °C)              | (EN 1542)      |
| Service Temperature              | Maximum   | +45 °C         |
|                                  | Minimum   | 0 °C           |
| Heat Deflection Temperature      | +52 °C (7 days, +30 °C)<br>Resistant to continuous exposure +45 °C. | (ASTM D648)    |

## APPLICATION INFORMATION

|                            |   |
|----------------------------|---|
| Mixing Ratio               | Part A : Part B = 4 : 1 (by weight)   |
| Consumption                | Guide: 0.4–1.5 kg/m <sup>2</sup><br>Consumption will depend on the roughness of the substrate and the type of SikaWrap® fabric to be impregnated. See respective SikaWrap® fabric Product Data Sheet and also refer to: <ul style="list-style-type: none"><li>▪ Method Statement: SikaWrap® manual dry application - Ref 850 41 02</li><li>▪ Method Statement: SikaWrap® manual wet application - Ref 850 41 03</li></ul> |
| Ambient Air Temperature    | +10 °C min. / +40 °C max.   |
| Dew Point                  | Beware of condensation.<br>The substrate and uncured applied resin must be at least +3 °C above dew point to reduce the risk of condensation or blooming on the resin surface.  |
| Substrate Temperature      | +10 °C min. / +40 °C max.   |
| Substrate Moisture Content | ≤ 4 % parts by weight<br>The following test methods can be used: Sika®-Tramex meter, CM-measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).  |
| Pot Life                   | ~35 minutes (100 g mass at +30 °C) (FIP 5.1)<br>The pot life begins when Parts A+B are mixed. It is shorter at high temperatures and longer at low temperatures. The greater the quantity mixed, the shorter the pot life. To obtain longer workability at high temperatures, the mixed adhesive may be divided into smaller quantities. Another method is to chill Parts A+B before mixing (not below +5 °C).            |
| Open Time                  | ~60 minutes (100 g mass at +30 °C) (FIP 5.2)  |
| Waiting Time / Overcoating | 6 hours minimum at +30 °C<br>Cured resin older than 7 days has to be degreased with Sika® Colma Cleaner and gently grinded with sandpaper before coating.<br>Times are approximate and will be affected by changing ambient conditions.   |

## 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

Reference must be made to the Sika® Method Statements:

- Method Statement: SikaWrap® manual dry application - Ref 850 41 02
- Method Statement: SikaWrap® manual wet application - Ref 850 41 03

## IMPORTANT CONSIDERATIONS

- Sikadur® resins are formulated to have low creep under permanent loading. However due to the creep behaviour of all polymer materials under load, the long term structural design load must account for creep. Generally the long term structural design load must be lower than 20–25 % of the failure load. Please consult a structural engineer for load calculations for your specific application.
- Protect from rain for at least 24 hours after application.
- Ensure placement of fabric and laminating with roller takes place within open time.
- For application in cold or hot conditions, pre-condition material for 24 hours in temperature-controlled storage facilities to improve mixing, application and pot life limits.

## 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

Substrates must be structurally sound and of sufficient tensile strength to provide a minimum pull off strength of 1.0 N/mm<sup>2</sup> or as required in the design specification.

Reference must be made to the Sika® Method Statements:

- Method Statement: SikaWrap® manual dry application - Ref 850 41 02
- Method Statement: SikaWrap® manual wet application - Ref 850 41 03

### SUBSTRATE PREPARATION

Reference must be made to the Sika® Method Statements:

- Method Statement: SikaWrap® manual dry application - Ref 850 41 02
- Method Statement: SikaWrap® manual wet application - Ref 850 41 03

### MIXING

#### IMPORTANT

Mix full units only

#### IMPORTANT

Over mixing must be avoided to minimise air entrainment.

1. Add Part B (hardener) to Part A (resin).
2. Mix Parts A+B continuously for ~3 minutes until a uniformly coloured mix is achieved.
3. To ensure thorough mixing, pour materials into a clean container and mix again for approximately 1 minute.

### APPLICATION

Reference must be made to the Sika® Method Statements:

- Method Statement: SikaWrap® manual dry application - Ref 850 41 02
- Method Statement: SikaWrap® manual wet application - Ref 850 41 03

### CLEANING OF TOOLS

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

## LOCAL RESTRICTIONS

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

## 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.

### **Sika Kimia Sdn. Bhd.**

Lot 689, Nilai Industrial Estate,  
71800 Nilai, Negeri Sembilan D.K.  
Malaysia  
Phone: +606-7991762  
e-mail: [info@my.sika.com](mailto:info@my.sika.com)  
Website: [www.sika.com.my](http://www.sika.com.my)



### **Product Data Sheet**

**Sikadur®-330 IN**

November 2023, Version 02.01  
020206040010000022

Sikadur-330IN-en-MY-(11-2023)-2-1.pdf