BUILDING TRUST

PRODUCT DATA SHEET

# Sika AnchorFix®-2020

High performance, professional, solvent- and styrene-free, thixotropic anchoring adhesive

## PRODUCT DESCRIPTION

Sika AnchorFix®-2020 is an epoxy acrylate, resin-based, two-part, thixotropic, non-sag, fast curing, chemical adhesive for anchoring threaded rods and reinforcing bars in both cracked and un-cracked concrete. The Product is both solvent- and styrene-free, is suitable for use in normal / moderate climate conditions, can be used in dustless and diamond drilling applications, and has a service life of 100 years.

## USES

Sika AnchorFix®-2020 may only be used by experienced professionals.

Fast curing anchoring adhesive for fixing of non-expanding anchors in the following:

### Structural work

- Rebar / steel reinforcement anchoring in new and refurbishment works.
- Threaded rods.
- Bolts and special fastening / fixing systems.

### Metalwork, carpentry

- Handrails, balustrades and supports.
- Railings.
- Window and door frames.

### Substrates

- Concrete (cracked and un-cracked).
- Solid masonry.
- Wood.
- Hard natural stone.
- Solid rock.

## CHARACTERISTICS / ADVANTAGES

- Fast curing.
- Standard guns can be used for application.
- High load capacity.
- ETA to EAD 330499-01-0601 for anchoring in cracked and uncracked concrete.
- ETA to EAD 330087-01-0601 for post installed rebar connections.
- Good adhesion to substrate.
- Suitable for cracked concrete.
- Drinking Water Certified.
- Seismic tested (C1 and C2).
- Non-sag, even overhead.
- Solvent- and styrene-free.
- Low emissions and odour.
- Low wastage.
- Can be used in hammer-drilled, dustless-drilled and diamond-core-drilled bore holes.

## APPROVALS / STANDARDS

- Post-Installed Adhesive Anchors in Concrete Elements IBC/IRC, Sika AnchorFix®-2020, IAPMO UES, Evaluation report No. 601.
- CE marking and declaration of performance based on European Technical Assessment ETA 22/0892 09/01/2023. ETA issued on the basis of EAD 330087-01-0601 Post-installed rebar connections.
- CE marking and declaration of performance based on European Technical Assessment ETA-22/0893 07/01/2023. ETA issued on the basis of EAD 330499-01-0601 Bonded fasteners for use in concrete.
- European Technical Assesment ETA 22/0892 09/01/2023.
- European Technical Assesment ETA-22/0893 07/01/2023.

## PRODUCT INFORMATION

| | | |
|---|---|---|
| **Packaging** | 300 ml standard cartridge | 12 cartridges per box<br>Pallet: 75 boxes |
| | Refer to current price list for packaging variations. | |
| **Colour** | Part A | White |
| | Part B | Black |
| | A+B mixed | Grey |
| **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. Always refer to packaging. | |
| **Density** | ~1,70 kg/l (Part A)<br>~1,55 kg/l (Part B)<br>~1,69 kg/l (A+B mixed) | |

## TECHNICAL INFORMATION

| | | | |
|---|---|---|---|
| **Service Temperature** | Long term | -40 °C minimum / +50 °C maximum | (ETAG 001, Part 5) |
| | Short term (i.e. 1 to 2 hours) | +80 °C | |

## APPLICATION INFORMATION

| | |
|---|---|
| **Mixing Ratio** | Part A : Part B = 10 : 1 by volume |
| **Layer Thickness** | ~5 mm maximum |
| **Sag Flow** | Non-sag, including overhead |
| **Product Temperature** | +5 °C minimum / +30 °C maximum |
| **Ambient Air Temperature** | +5 °C minimum / +30 °C maximum |
| **Dew Point** | Beware of condensation.<br>Substrate temperature during application must be at least +3 °C above dew point. |
| **Substrate Temperature** | +5 °C minimum / +30 °C maximum |

**Curing Time**

| Temperature | Open Time - $T_{gel}$ | Curing Time - $T_{cur}$ |
|---|---|---|
| +30 °C to +35 °C | 2 minutes | 30 minutes |
| +25 °C to +30 °C | 4 minutes | 40 minutes |
| +20 °C to +25 °C | 5 minutes | 50 minutes |
| +15 °C to +20 °C | 6 minutes | 75 minutes |
| +10 °C to +15 °C | 8 minutes | 85 minutes |
| +5 °C to +10 °C* | 10 minutes | 145 minutes |

*Minimum cartridge temperature = +5 °C.

## SYSTEM INFORMATION

| | |
|---|---|
| **System Structure** | Ancillary products are available on request. Please contact Sika® Technical Services for information. |

## VALUE BASE

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 DOCUMENTS

- For specific information on design refer to: Technical Documentation Sika AnchorFix®-2020 870 43 17.

## LIMITATIONS

- Natural stone and solid rock properties vary particular with regard to strength, composition and porosity. For each application, the suitability of Sika AnchorFix®-2020 must be tested for bond strength, surface staining and discoloration by first applying the product to a sample area before full project application.

## 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.

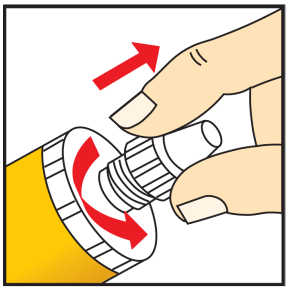
## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY

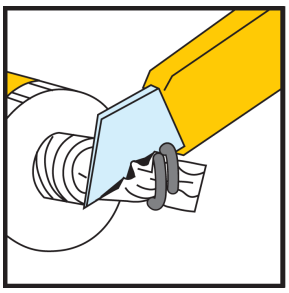
Mortar and concrete must be at the required design strength.
Substrate tensile / compressive strengths (concrete, masonry, natural stone) must be confirmed by testing.
The anchor hole must always be clean, dry, free from oil, grease, etc.
Loose particles must be removed from the holes.
Threaded rods and rebars must be cleaned thoroughly and free from dirt, oil, grease, corrosion products or any other substances and particles which could affect adhesion.

### MIXING

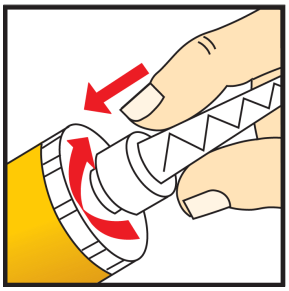
**Getting the cartridge ready:**



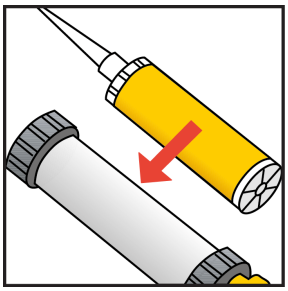
1. Unscrew the cap.



2. Cut the film.

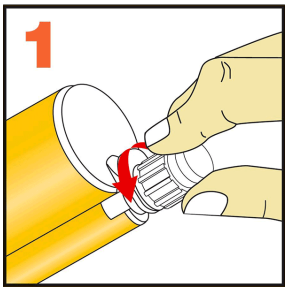


3. Screw on the static mixer.

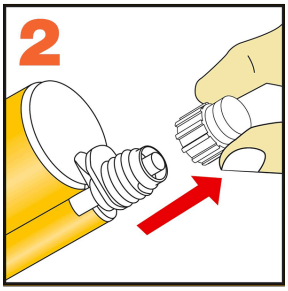


4. Place the cartridge into the gun and start application.

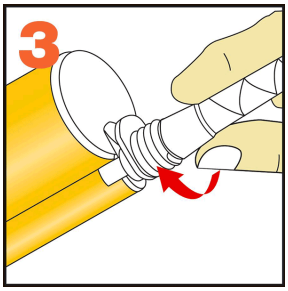
### Getting the cartridge ready:



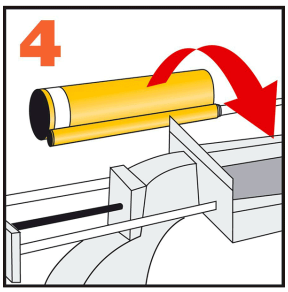

1.Unscrew the cap.




2. Remove the cap.



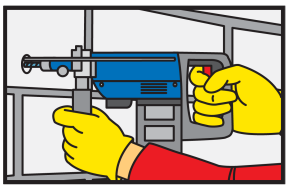

3. Screw on the static mixer.



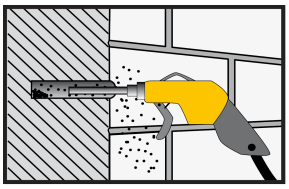

4. Place the cartridge into the gun and start application.

## APPLICATION METHOD / TOOLS

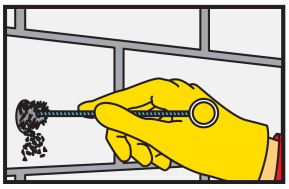
### Anchors in solid masonry / concrete



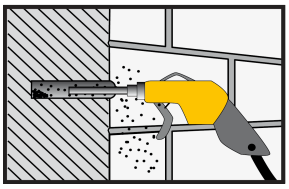
1. Drill hole with an electric drill to the diameter and depth required. Drill hole diameter must be in accordance with anchor size.



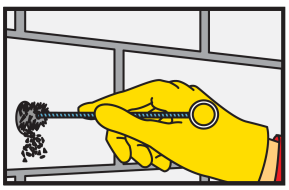
2. The drill hole must be cleaned with oil free compressed air using an air lance, pressure: 6 Bar (90 psi). Start from the bottom of the hole and clean at least twice until return air stream is free of dust.



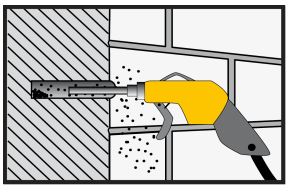
3. The drill hole must be thoroughly cleaned with the special steel brush (brush at least twice). The diameter of the brush must be larger than the diameter of the drill hole.



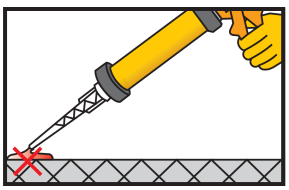
4. The drill hole must be cleaned again as per Stage 2.



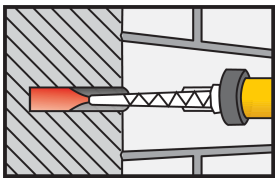
5. The drill hole must be thoroughly cleaned again as per Stage 3.



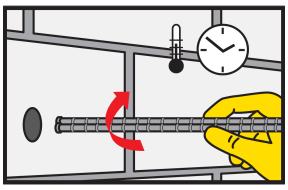
6. The drill hole must be cleaned again as per Stages 2 and 4.



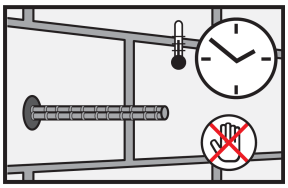
7. Pump gun at least twice until both parts are extruded as a one consistant colour. Do not use this material. Release the gun pressure and clean the static mixer opening with a cloth.



8. Inject the adhesive into the drill hole, starting from the bottom and slowly pull out the static mixer while extruding the resin into the hole. Avoid entrapping air. For deep holes use extension tubing.



9. Insert the anchor with a rotary motion into the filled drill hole within the adhesive open time. Some of the adhesive must flow out of the hole.



10. During the resin hardening time the anchor must not be moved or loaded.

**IMPORTANT NOTE:** For anchors in hollow blocks: Use Sika AnchorFix®-1.

### CLEANING OF TOOLS

Clean all tools and application equipment with Sika® Thinner C immediately after use. 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.

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