BUILDING TRUST

PRODUCT DATA SHEET

Sika® Icosit® KC 330 FK NEW

2-component polyurethane adhesive for fixing filler blocks and joining construction materials

PRODUCT DESCRIPTION

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

USES

Sika® 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, as examples, fixing machinery in industry, and for joining various construction materials, particularly metal and concrete (e. g. for fixing stainless steel cladding to the running surface of clarifiers in sewage treatment plants).

CHARACTERISTICS / ADVANTAGES

- Easy to mix and apply.
- 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	
	Parts A + B	10 kg	
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.		
Colour	Black		
Density	Part A	~1.4 kg/l	(ISO 2811-1)
	Part B	~1.2 kg/l	(ISO 2811-1)
	Parts A + B	~1.4 kg/l	(ISO 1183-1)
	The density of the mixed material (A + B) is determined by calculation.		

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/mm²	(ISO 527)
Elongation at Break	~50 %	(ISO 527)
Tear Strength	~8.5 N/mm²	(ISO 34 B)
Service Temperature	-40 °C minimum / +80 °C maximum Short term up to +150 °C	
Chemical Resistance	**Long-term resistant against:** ▪ Water ▪ Most detergents ▪ Sea water, alkaline water **Short-term resistant against:** ▪ Mineral oils, diesel fuel **Short-term or no resistance against:** ▪ Organic solvents (ester, ketone, aromates), alcohol and thinners ▪ Concentrated lyes and acids Contact Sika® Technical Services for specific information.	

APPLICATION INFORMATION

Mixing Ratio	Part A : Part B = 100 : 11 (parts by weight)
Consumption	~1.4 kg per litre of volume
Layer Thickness	minimum 3 mm / maximum 30 mm
Product Temperature	Condition product parts before application preferably at ~+15 °C to ~+25 °C.
Ambient Air Temperature	+5 °C minimum / +35 °C maximum
Relative Air Humidity	70 % maximum
Substrate Temperature	+5 °C minimum / +35 °C maximum
Substrate Moisture Content	Dry
Pot Life	~15 minutes at +20 °C After this time, the mixture becomes unusable. Higher temperatures will shorten pot life.
Curing Time	Tack-free: ~3 hours (+20 °C) Trafficable: ~24 hours (+20 °C)
Waiting Time / Overcoating	

	Minimum	Maximum
Sika® Icosit® KC 330 Primer	1 hour	3 days

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.

LIMITATIONS

Material is moisture-sensitive.

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.

Regulation (EC) No 1907/2006 (REACH) - Mandatory training
As from 24 August 2023 adequate training is required before industrial or professional use of this product. For more information and a link to the training visit www.sika.com/pu-training.

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 Sika® Icosit® KC 330 FK NEW.

SUBSTRATE PREPARATION

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

MIXING

Sika® 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 to 80 seconds.
- Ensure material is mixed from the container walls and the base by the stirrer during mixing.

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

APPLICATION METHOD / TOOLS

Apply the adhesive to the prepared substrate. If necessary spread Sika® 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 TOOLS

Mixing and application tools must be cleaned at regular intervals and immediately after use with Sika® Thinner C. 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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