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Sikadur® 31, SBA, Normal Set (55°-95°F)
Segmental Bridge Adhesive, Normal Set High-modulus, high-strength, moisture tolerant, epoxy paste adhesive

Description
Sikadur® 31, SBA is a unique high-modulus 2-component, moisture-tolerant, solvent-free, epoxy resin system available in three application temperature ranges. A unique high-modulus, structural adhesive for bonding hardened concrete to hardened concrete for segmental bridge construction. The mixed material has the consistency of paste and is a concrete gray color. It conforms to the current ASTM C-881, Type VI requirements, and ASBI guidelines.

Where to Use
- Structural bonding of post-tensioned precast concrete bridge segments.
- Sealing joints between concrete segments.
- For use in segment-by-segment erection.
- Supplied in three temperature grades to meet project requirements. (For cold weather conditions, refer to separate technical data sheet on Sikadur 31, SBA [20°-45° F].)

Advantages
- Moisture tolerant before, during and after cure.
- High-modulus, high-strength, structural paste adhesive.
- Range of curing times to meet assembly and strength gain requirements.
- Easy to apply, non-sag paste for vertical applications.
- Excellent adhesion to concrete, steel and most construction materials.
- Color-coded components to ensure proper mixing control.

Coverage
Approximately 12 ft²/gal. or 36 ft²/3 gal. unit.

Packaging
3 gal. units.

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

<table>
<thead>
<tr>
<th>Product name</th>
<th>Temp. Range</th>
<th>Mix Ratio, A:B by volume</th>
</tr>
</thead>
<tbody>
<tr>
<td>Normal Set (40°-60°F)</td>
<td>40°-60°F (4°-15°C)</td>
<td>2:1</td>
</tr>
<tr>
<td>Normal Set (55°-95°F)</td>
<td>55°-95°F (13°-35°C)</td>
<td>2:1</td>
</tr>
<tr>
<td>Normal Set (80°-115°F)</td>
<td>80°-115°F (27°-46°C)</td>
<td>2:1</td>
</tr>
</tbody>
</table>

Pot Life (1 gallon volume)
Approximately 30 minutes at 73°F (23°C)

Open Time (60°F, 95°F, 115°F)
60 minutes

Compressive Strength (ASTM D-695)
- 24 hours 2,000 psi, minimum (13.8 MPa)
- 48 hours 6,000 psi, minimum (41.3 MPa)

Contact Strength (ASTM C-882)
- 48 hours 1,000 psi, minimum (6.9 MPa)

Bond Strength (ASTM C-882): Hardened Concrete to Hardened Concrete
- 2 day (moist cure) 1,000 psi, minimum (6.9 MPa)

Heat Deflection Temperature (ASTM D-648)
14 day (fiber stress loading = 264 psi [1.8 MPa]) 120°F (49°C), minimum
### How to Use

#### Surface Preparation
Surface must be clean and sound. It may be dry or damp, but free of standing water and frost. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles, disintegrated materials and any other contaminants.

#### Mixing
Pre-mix each component. Wear chemical resistant gloves and safety goggles. Mix all of Part ‘A’ with all of Part ‘B’. Mix thoroughly for a minimum of 3 minutes with a low-speed (400-600 rpm) drill fitted with a mixing Sika paddle until a uniform gray color is achieved. Scrape down the sides of the mixing pail and ensure there are no streaks of unmixed epoxy before applying. Mix only that quantity which can be used within its pot life.

#### Application
Apply the neat mixed Sikadur® 31, SBA to the concrete surface using a trowel, spatula or glove protected hand; work into surface, especially if it is damp. Spread to a thickness of 1/8” (3 mm) to one face or 1/16” (1.5 mm) on both faces, depending upon project requirements. Segments must be post-tensioned within the open time of the epoxy.

#### Limitations
- Do not thin Sikadur® 31, SBA. Solvents will prevent proper cure.
- Use correct temperature range material for prevailing conditions.
- Use correct setting material (normal or slow) depending on method of erection.
- Not for use as an adhesive for fresh, plastic portland cement concrete or mortar.
- Lower temperatures will prolong cure time. Higher temperatures will rapidly accelerate cure time.
- Use of product outside of designated temperature range is not recommended.
- Not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.

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