

Sikacrete 321 FS

Application Instructions



Sikacrete 321 FS

- ▲ One-component.
- ▲ Fast setting concrete mix.
- ▲ Portland –cement concrete containing factory blended coarse aggregate designed for quick turnaround patching and overlay needs.



Sikacrete 321 FS

▲ Where to use:

- On grade, above, and below grade on concrete.
- On horizontal, vertical and overhead surfaces when formed and pumped or poured.
- Full depth repairs.
- Filler for voids and cavities.
- As a structural repair material for:
 - Parking facilities
 - Industrial plants
 - Walkways and bridges.



Sikacrete 321 FS

▲ Packaging:

- 65 lb. multi-wall bag.

▲ Coverage:

- .50 cu. ft / unit.
- 864 cu. inches per unit.



Surface Preparation

- ▲ **Cementitious Substrates:**
 - Should be clean and sound.
 - Remove contaminants and bond inhibiting materials from repaired area.
 - Obtain exposed/fractured aggregate surface ~1.0 to 1/8 inch profile (ICRI CSP 7 & above).
 - Substrate must be saturated surface dry (SSD) with no standing water.



Surface Preparation

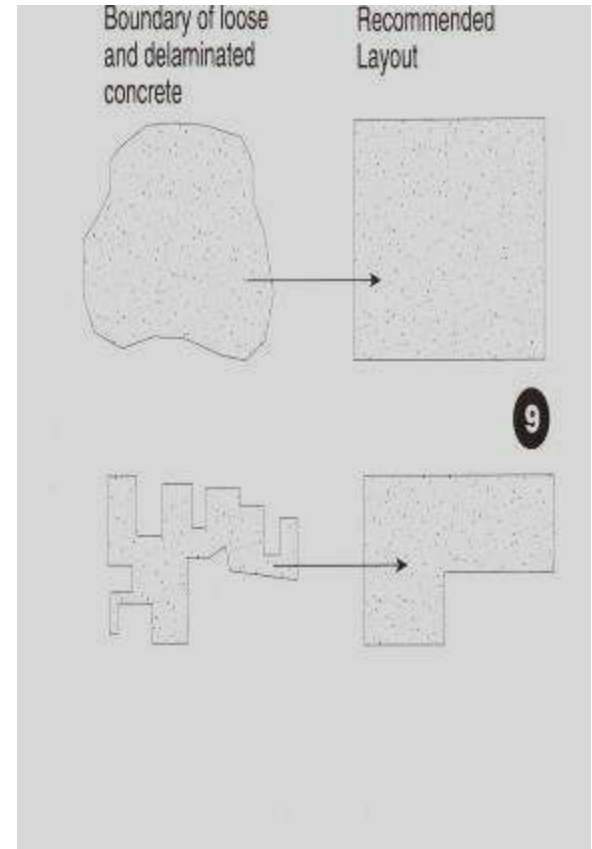
▲ Cementitious Substrates:

- Surface should be cleaned and roughened to create a profile.



Surface Preparation

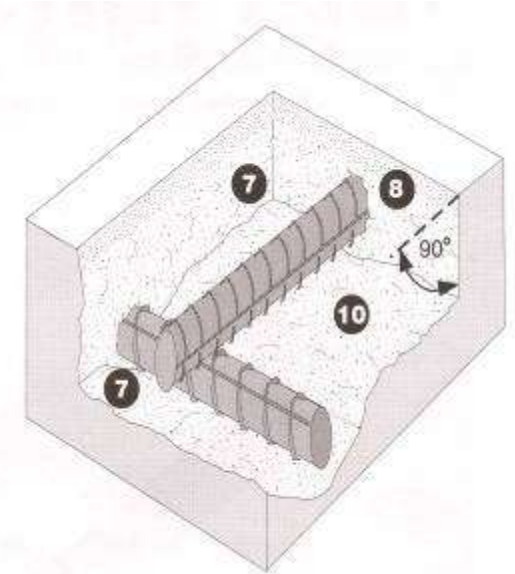
- ▲ Saw cut around perimeter of repair area to achieve a minimum 3/8" shoulder.
- ▲ Eliminates feathered edges giving a clean repair transition



Surface Preparation

▲ Steel:

- Remove all corrosion and contaminants from exposed steel.
- Surface should be cleaned thoroughly by blast cleaning or other mechanical means.
- Exposed steel should be cleaned to white steel.
- If half of the diameter is exposed, chip behind bar, 3/4" minimum.



Steel Preparation

- ▲ Steel should be cleaned to a bright metal finish.



Tools Required

- ▲ 1/2" Drill Motor
- ▲ Low speed drill
400-600 rpm
- ▲ Large mixing paddle
- ▲ Margin trowel



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Mixing

- ▲ Pour water into clean pail.
- ▲ Adjust water to achieve the required flow. Do not add more than 5 pints of water.



Mixing

- ▲ Add Sikacrete 321 FS to pail with water already inside, while mixing continuously.



Mixing

1. Slowly add powder.
2. Once all the powder is added mix for **3 minutes**.
3. Do not add any more than the recommended liquid.



Mixing

1. While mixing for 3 minutes stop at 1.5 min to scrape down the sides to insure all material is fully mixed.
2. Thorough mixing and proper proportioning is necessary.



Sikacrete 321 FS - Application

- ▲ SSD the surface and scrub coat the repair concrete into the substrate filling all pores and voids.



Sikacrete 321 FS + Application

- ▲ Apply Sikacrete 321 to the prepared area.
- ▲ Press concrete behind rebar and make sure the material is consolidated and compacted fully.



Sikacrete 321 FS + Application

- ▲ Complete filling patch area.
- ▲ Work concrete from the center of the patch to the outside.



Min / Max application thickness

▲ Thickness

- Min 1.0 inch
- Max 8.0 inch



Sikacrete 321 FS Finish

- ▲ Ensure good intimate contact with the substrate is achieved.
- ▲ Materials should be scrubbed into the substrate or other suitable means should be employed such as vibration of the materials.
- ▲ Vibrate form while pouring.
- ▲ Finished as desired.



Sikacrete 321 FS Curing

- ▲ Cure as per ACI recommendations. Curing is required.
- ▲ Moist cure with wet burlap and polyethylene, a fine mist of water or water based curing compound
- ▲ Moist curing should commence immediately after finishing.
- ▲ Protect newly applied material from direct sun light, wind, rain and frost.



Sikacrete 321 FS

Sika Product Data Sheets can be obtained via:

www.sikaconstruction.com

Refer to data sheets for specific information on each Sika product.

