

**Product Data Sheet**  
Edition 4.6.2009  
Identification no. C371  
Sika AnchorFix-2

## Sika® AnchorFix-2

High-performance, epoxy acrylate, anchoring adhesive

<b>Description</b>	Sika AnchorFix-2 is a two-component, solvent- and styrene-free, modified-acrylic, anchoring adhesive.
<b>Where to Use</b>	As a fast-curing anchoring adhesive for all grades of rebars, threaded rods, bolts and special fastening systems. Install in concrete and masonry base materials.
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Low sensitivity to mixing errors.</li> <li>■ Styrene-free, solvent-free</li> <li>■ Low waste.</li> <li>■ Can be dispensed/mixed with a standard, good quality caulking gun.</li> <li>■ Satisfies AC 58 creep criteria. Current ICC listing valid through 12/31/2007. Contact Sika's Technical Service Department for updated information at 1-800-933-7452.</li> </ul> <ul style="list-style-type: none"> <li>■ Fast-curing.</li> <li>■ Low odor.</li> <li>■ Moisture tolerant.</li> </ul>
<b>Packaging</b>	10 fl. oz. (300 ml) two-component collapsible "cartridge-in-cartridge" system. Ready-to-use with a standard, good quality caulking gun.

### Gel and Curing Times

Application Temperature	Gel Time	Cure Time
95°F (35°C)	2 minutes	25 minutes
86°F (30°C)	3 minutes	35 minutes
68°F (20°C)	5 minutes	40 minutes
50°F (10°C)	8 minutes	70 minutes
41°F (5°C)	12 minutes	90 minutes
32°F (0°C)	20 minutes	3 hours
23°F (-5°C)	50 minutes	15 hours
14°F (-10°C)	80 minutes	24 hours

### WARNING

**Component A: IRRITANT.** Contains epoxy resin, and silica quartz (sand). Eye irritant. May cause skin/respiratory irritation. Harmful if swallowed.

**Component B: IRRITANT, SENSITIZER.** Causes eye irritation. May cause skin/respiratory irritation. Prolonged and/or repeated skin contact may cause an allergic reaction/sensitization. Harmful if swallowed.

Cured material, if sanded, may result in exposure to a chemical known to the State of California to cause cancer.

### Technical Data

<b>Shelf Life</b>	Use within 12 months of manufacturing date.
<b>Storage Conditions</b>	Store in original unopened packaging in cool, well-ventilated conditions at 40°-80°F (4-7°) and out of direct sunlight.
<b>Color</b>	Component. A+B mixed: uniform gray
<b>Mixing Ratio</b>	Component A : Component B = 10:1 by volume
<b>Consistency</b>	Component. A+B mixed: non-sag, creamy paste
<b>Application Temperatures</b>	Substrate and ambient: 14°-86°F (-10°C-30°C)
<b>Density (Mixed)</b>	2.75 lb./gal (.33 kg/l)



## First Aid

**Eyes:** Flush eyes with water for at least 15 minutes **Skin:** Immediately flush skin with soap and water for at least 15 minutes. **Ingestion:** Do not induce vomiting. Contact a physician. **Inhalation:** Remove to fresh air. Contact a physician if symptoms persist. **Contact a physician immediately with all cases if symptoms persist.**

## Handling and Storage

Avoid direct contact with skin and eyes. Use chemical resistant gloves/goggles/clothing. Use with adequate general and local exhaust ventilation. In the absence of adequate ventilation, use a properly fitted NIOSH approved respirator. Wash hands thoroughly after handling product. Remove contaminated clothing and laundry before reuse. Uncured material can be removed with solvent. Strictly follow solvent manufacturer's warnings and instructions for use. Cured material can only be removed mechanically. Keep cartridge tightly closed.

## Clean Up

In case of spill, wear chemical resistant gloves/goggles/clothing. Ventilate area. In absence of adequate ventilation, use a properly fitted NIOSH respirator. Contain spill and collect with absorbent material and transfer to a sealed container. Dispose of in accordance with applicable local, state and federal regulations.

Anchor Diameter (in.)	Drill Bit Diameter (in.)	Embedment Depth (in.)	Allowable Tensile Bond Strength	Allowable Tensile Bond Strength	Allowable Shear Load
			Min. 2,000 psi (13.8 MPa) Concrete (lbs.)	Min. 4,000 psi (27.5 MPa) Concrete (lbs.)	≥ 2,000 psi (13.8 MPa) Concrete (lbs.)
3/8	7/16	2-1/4	1,155	1,680	335
		3-1/2	1,950	2,785	1,125
		4-1/2	2,310	3,360	1,125
1/2	9/16	3	1,720	2,500	600
		4-1/4	3,225	4,605	2,000
		6	3,435	5,010	2,000
5/8	3/4	3-3/4	2,855	4,160	940
		5	3,745	5,350	3,130
		7-1/2	5,715	8,320	3,130
3/4	7/8	4-1/2	4,540	6,610	1,350
		6-3/4	5,930	8,475	4,505
		9	8,050	11,520	4,505
1	1-1/8	6	6,735	7,610	2,400
		8-1/4	7,330	10,475	8,010
		12	10,635	15,225	8,010

## Load Capacities - Threaded Rod

- 1) Allowable loads are based on a minimum safety factor of 3. Higher factors of safety may be warranted depending on actual application and job site conditions. Consult a design professional prior to use.
- 2) Minimum concrete base material thickness must be 1.5 times the anchor embedment depth.
- 3) Allowable load of adhesive anchor must be the lesser of bond or steel strength.

**\*\*For information on the effects of Anchor Spacing and Edge Distance on adhesive anchor performance, please contact Sika's Technical Service Department.**

Maximum Recommended Tightening Torque on Nut/Washer for Threaded Rod

**Note:** Maximum tightening torque applied to nut and washer recommended to prevent over-stress of adhesive.

	Threaded Rod Diameter (in.)						
	3/8	1/2	5/8	3/4	7/8	1	1-1/4
<b>Max. Tightening Torque (ft-lbf)</b>	15	30	60	110	125	150	250

Rebar Size (Diameter)	Drill Bit Diameter (in.)	Embedment Depth (in.)	Allowable Tensile Bond Strength	Allowable Tensile Bond Strength	Allowable Shear Load
			Min. 2,000 psi (13.8 MPa) Concrete (lbs.)	Min. 4,000 psi (27.5 MPa) Concrete (lbs.)	≥ 2,000 psi (13.8 MPa) Concrete (lbs.)
No. 3 (3/8")	1/2	3-3/8	935	1,340	1,190
No. 4 (1/2")	5/8	4-1/2	1,685	2,410	1,970
No. 5 (5/8")	3/4	5-5/8	2,435	3,480	2,940
No. 6 (3/4")	7/8	6-3/4	3,185	4,550	4,110
No. 7 (7/8")	1	7-7/8	3,935	5,620	5,450
No. 8 (1")	1-1/8	9	4,680	6,690	7,030


## Load Capacities - Reinforcing Bar


- 1) Allowable loads are based on a minimum safety factor of 4. Higher factors of safety may be warranted depending on actual application and job site conditions. Consult a design professional prior to use.
- 2) Minimum concrete base material thickness must be 1.5 times the anchor embedment depth.
- 3) Allowable load of adhesive anchor must be the lesser of bond or steel strength.

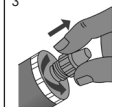
**\*\*For information on the effects of Anchor Spacing and Edge Distance on adhesive anchor performance, please contact Sika's Technical Service Department.**

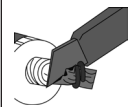
## Methods of Use

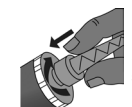
### Solid Base Material


1  Drill the hole to the correct diameter and depth using a rotary hammer drill.


2  Blow the hole clean with compressed air, brush clean with a nylon brush and blow clean again. Hole may be dry or damp but must be free from standing water.

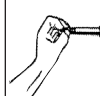
3  Unscrew and remove the cap.


4  Cut the film.


5  Screw on the static mixer

6  Place the cartridge into the applicator gun. Dispense the first part of the extruded adhesive to waste until a uniform color is achieved.

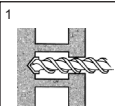
7  Insert the mixer nozzle to the far end of the hole and half fill hole (depending upon application). Withdraw nozzle as you fill the hole. For deep holes extension tubing can be used.


8  Prior to use, remove surface contaminants such as oil or grease from anchor to avoid inadequate bond. Immediately insert the anchor hardware.

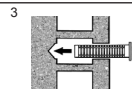
9  This should be done slowly with a slight twisting motion. Excess resin should be removed from the mouth of the hole before it sets. Use chemical resistant gloves.

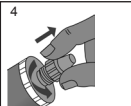
10  Leave the anchor undisturbed until curing time has elapsed, then attach the fixture and tighten the nut.

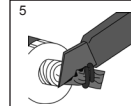
### Hollow Base Material

1  Drill the hole to the correct diameter and depth. This can be done with either a hammer drill or rotary-only machine depending upon the substrate.


2  Blow the hole clean with compressed air, brush clean with a nylon brush and blow clean again. Hole may be dry or damp but must be free from standing water.

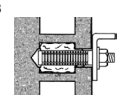
3  Insert the correct perforated screen.

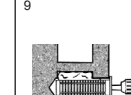
4  Unscrew and remove the cap.

5  Cut the film.

6  Attach the static mixing nozzle.

7  Place the cartridge into the applicator gun. Dispense the first part of the extruded adhesive to waste until a uniform color is achieved.

8  Insert mixer nozzle to the far end of the perforated sleeve and completely fill the sleeve with resin. Withdraw the mixer nozzle as the sleeve fills.

9  Prior to use, remove surface contaminants such as oil or grease from anchor to avoid inadequate bond. Immediately insert the anchoring hardware. This should be done slowly with a slight twisting motion. Leave the anchor undisturbed until the cure time has elapsed, then attach the fixture and tighten the nut.

**KEEP CONTAINER TIGHTLY CLOSED • KEEP OUT OF REACH OF CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY**

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