

# PRODUCT DATA SHEET

## Sikadur®-32 Hi-Mod

High-modulus, high-strength, epoxy-based protective coating and bonding adhesive



### PRODUCT DESCRIPTION

Sikadur®-32 Hi-Mod is a multi-purpose, two-component, solvent-free, moisture-insensitive, structural epoxy adhesive and protective coating.

### WHERE TO USE

Sikadur®-32 Hi-Mod may only be used by experienced professionals.

- Protective coating for reinforcing steel.
- Bond fresh, plastic concrete to hardened concrete and steel.
- Grout bolts, dowels, pins etc.
- Grout horizontal cracks in structural concrete and wood by gravity feed.
- Structural adhesive for concrete, masonry, metal, wood, etc.

### CHARACTERISTICS / ADVANTAGES

- High-build, chemically resistant and protective coating.
- Super-strength bonding/grouting adhesive.
- Insensitive to moisture before, during and after cure.
- Excellent adhesion to most structural materials.
- Easy to mix: 1:1 ratio.
- Easy to use for bonding/grouting applications.

### APPROVALS / CERTIFICATES

- Meets ASTM C881, Type I, II and V, Grade 2, Class B and C, epoxy resin adhesive.
- USDA-approved for use in food plants.
- Ministère des Transports et de la Mobilité durable du Québec acceptance.
- Product recognized by the British Columbia Ministry of Transportation (BC MoT).

### PRODUCT INFORMATION

Packaging	10 L (2.64 US gal) unit
Colour	Concrete grey
Shelf Life	2 years in original, unopened containers
Storage Conditions	Store dry at 5 °C to 32 °C (41 °F to 89 °F).
Viscosity	2800 cps

### TECHNICAL INFORMATION

**Compressive Strength**

	<b>4 °C*</b> <b>(39 °F)</b>	<b>23 °C*</b> <b>(73 °F)</b>	<b>32 °C*</b> <b>(89 °F)</b>	(ASTM D695) 23 °C (73 °F)
8 hour	-	-	7 MPa (1015 psi)	
16 hour	-	17 MPa (2466 psi)	31 MPa (4498 psi)	
1 day	-	32 MPa (4643 psi)	44 MPa (6384 psi)	
3 days	5 MPa (725 psi)	56 MPa (8125 psi)	57 MPa (8270 psi)	
7 days	50 MPa (7255 psi)	66 MPa (9576 psi)	57 MPa (8270 psi)	
14 day	56 MPa (8125 psi)	66 MPa (9576 psi)	57 MPa (8270 psi)	
28 days	60 MPa (8706 psi)	66 MPa (9576 psi)	57 MPa (8270 psi)	

\*Product cured and tested at the temperatures indicated.

<b>Modulus of Elasticity in Compression</b>	3.03 GPa (4.4 x 10 <sup>5</sup> psi)	(ASTM D695) 23 °C (73 °F) 28 days
<b>Tensile Strength in Flexure</b>	51 MPa (7400 psi)	(ASTM D790) 23 °C (73 °F) 14 days
<b>Modulus of Elasticity in Flexure</b>	3.24 GPa (4.7 x 10 <sup>5</sup> psi)	(ASTM D790) 23 °C (73 °F) 14 days
<b>Tensile Strength</b>	33 MPa (4788 psi)	(ASTM D638) 23 °C (73 °F) 14 days
<b>Modulus of Elasticity in Tension</b>	2.2 GPa (3.2 x 10 <sup>5</sup> psi)	(ASTM D638) 23 °C (73 °F) 14 days
<b>Elongation at Break</b>	1.9 %	(ASTM D638) 23 °C (73 °F) 14 days
<b>Shear Strength</b>	41 MPa (5949 psi)	(ASTM D732) 23 °C (73 °F) 14 days
<b>Pull-Off Strength</b>	Plastic concrete to hardened concrete Plastic concrete to steel	13 MPa (1886 psi) 13 MPa (1886 psi) (ASTM C882) 23 °C (73 °F) 14 days
<b>Heat Deflection Temperature</b>	Fibre stress loading = 1.8 MPa (261 psi)	(ASTM D648) 14 days 49 °C (120 °F)

**APPLICATION INFORMATION**

<b>Mixing Ratio</b>	A : B = 1 : 1 by volume
<b>Consumption</b>	1 L = approx. 2 m <sup>2</sup> (1 US gal. = approx. 80 ft <sup>2</sup> )

<b>Product Temperature</b>	Condition material to 18 °C to 30 °C (65 °F to 86 °F) before using
<b>Ambient Air Temperature</b>	Minimum ambient temperature 4 °C (39 °F).
<b>Substrate Temperature</b>	Minimum substrate temperature 4 °C (39 °F).
<b>Pot Life</b>	30 - 38 min (318 g (11.2 oz))
<b>Contact Time</b>	<b>4 °C (39 °F)*:</b> 14–16 h <b>23 °C (73 °F)*:</b> 3.5–4 h <b>32 °C (59 °F)*:</b> 1.5–2 h * Product cured and tested at the temperatures indicated.

## BASIS OF PRODUCT DATA

Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.

## FURTHER INFORMATION

Water Absorption (ASTM D570)  
0.7% (2 h boil) 7 days

## LIMITATIONS

- Do not use as a bonding agent with set accelerated mortars or concrete, e.g. SikaSet®-45, SikaQuick®-1000, SikaQuick®-2500, SikaTop®-123 Plus Winter Grade, SikaEmaco®-1060, SikaEmaco®-1061, RS-S6/RS-S10 and Self-Consolidating concrete. Contact Sika Canada for more information.
- Product is a vapour barrier after cure.
- Do not thin with solvents.

## ENVIRONMENT, HEALTH & 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

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

### SUBSTRATE PREPARATION

Substrate must be clean and sound. It may be dry or damp, but free of standing water. Remove dust, laitance, grease, curing compounds, impregnations, waxes, foreign particles and disintegrated materials.  
**Concrete:** Sandblast or use other approved mechanical

methods.

**Steel:** Sandblast to white-metal finish (SP-10).

### MIXING

Pre-stir each component then proportion equal parts by volume of component A and component B into a clean pail. Mix thoroughly for three (3) minutes with paddle on low-speed drill (300 - 450 rpm) until blend is a uniform colour. Mix only that quantity that can be applied within its pot life.

### APPLICATION METHOD / TOOLS

**To protect steel reinforcing:** Apply two (2) coats of Sikadur®-32 Hi-Mod by brush or spray. Allow first coat to become tack-free. Apply second coat prior to application of repair mortar/concrete.

**To bond fresh concrete to hardened concrete:** Apply by brush, roller, broom or spray. Place fresh concrete while Sikadur®-32 Hi-Mod is still tacky. If coating becomes glossy and loses tackiness, remove any surface contaminates then recoat with additional Sikadur®-32 Hi-Mod and proceed.

**To anchor bolts, dowels and pins:** Use neat. For efficient transfer of stress, the holes should be not greater than 6 mm (1/4 in) in diameter than the bar, pin or rod to be embedded. Depth of embedment is typically 10 to 15 times the bar diameter.

**To gravity feed cracks:** Pour neat material into "V"-notched crack. Continue placement until completely filled. Seal underside of slab prior to filling if cracks reflect through.

### CLEAN UP

Collect with absorbent material. Dispose of in accordance with local disposal regulations. Uncured material can be removed with Sika® Epoxy Cleaner. Cured product can only be removed mechanically.

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

## 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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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### **Other locations**

Boisbriand (Quebec)  
Brantford; Cambridge;  
Sudbury; Toronto (Ontario)  
Edmonton (Alberta)  
Surrey (British Columbia)

### **Product Data Sheet**

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