



**PRODUCT DATA SHEET**

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COMPOSITE STRENGTHENING

# Sikadur® Hex-300

## HIGH-MODULUS, HIGH-STRENGTH, IMPREGNATING RESIN

<b>Description</b>	Sikadur® Hex-300 is a two-component 100 % solids, moisture-tolerant, high strength, high modulus epoxies.		
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>For use as an impregnating resin with the SikaWrap® Structural Strengthening System.</li> <li>Sikadur® Hex-300 is used as a seal coat and impregnating resin for horizontal and vertical applications.</li> </ul>		
<b>Advantages</b>	<ul style="list-style-type: none"> <li>Long pot life</li> <li>Long open time</li> <li>Easy to mix</li> <li>Tolerant of moisture before, during and after cure</li> <li>High strength, high modulus adhesive</li> <li>Excellent adhesion to concrete, masonry metals, wood and most structural materials</li> <li>Fully compatible and developed specifically for the SikaWrap® System</li> <li>High temperature resistance</li> <li>High abrasion and shock resistance</li> <li>Solvent-free, VOC compliant</li> <li>Approval ANSI/NSF 61 approved for contact with potable water (special order only).</li> <li>2009 &amp; 2012 International Building Codes (IBC)</li> <li>1997 Uniform Building Code (UBC) per ICC-ES Evaluation Report ESR-3288.</li> </ul>		
<b>Technical Data</b>			
<b>Packaging</b>	15.14 L unit (4 US gal)		
<b>Colour</b>	Clear, slightly amber		
<b>Yield</b>	<b>As a sealer:</b> ~ 100 ft <sup>2</sup> / US gal <b>As an impregnating resin:</b> ~ 120 ft <sup>2</sup> / US gal - 9 oz per sq. yd. fabrics ~ 60 ft <sup>2</sup> / US gal - 18 oz per sq. yd. fabrics ~ 30 ft <sup>2</sup> / US gal - 37 oz per sq. yd. fabrics		
<b>Shelf Life</b>	Two (2) years from date of production if stored properly in original, unopened and undamaged sealed packaging		
<b>Mix Ratio</b>	Mix entire unit, do not batch down		
<b>Properties at 23 °C (73 °F) and 50 % R.H.</b>			
<b>Viscosity</b>	~ 500 - 750 cps		
<b>Pot Life</b>	~ 3 - 4 hours (1 quart volume mixed)		
<b>Open Time</b>	~ 6 - 7 hours (Time to reach ~10,000 cps)		
<b>Cure Time</b>	~ 12 - 14 hours (Tack Free)		
<b>Service Temperature</b>	-40 to 60 °C (-40 to 140 °F)		
<b>Compressive Strength ASTM D695</b>	<b>4 °C (40 °F)</b>	<b>23 °C (73 °F)</b>	<b>32 °C (90 °F)</b>
	3 days	-	57.2 MPa (8 300 psi)
	7 days	7.1 MPa (1000 lb/po <sup>2</sup> )	82.7 MPa (12 000 psi)
	28 days	-	77.9 MPa (11 300 psi)
<i>Material cured and tested at the temperatures indicated and 50 % R.H.</i>			
<b>Modulus of Elasticity in Compression</b>	3.8 x 10 <sup>5</sup> psi (2 621 MPa) (7 days)		
<b>Flexural Strength ASTM D790</b>	79.3 MPa (11 500 psi) at 23 °C (73 °F) and 50 % R.H.		
	123 MPa (17 800 psi) at 60 °C (140 °F) and 50 % R.H. ; Post cured min. 48 hrs		
<b>Modulus of Elasticity in Flexure ASTM D790</b>	3517 MPa (5.1 x 10 <sup>5</sup> psi) at 23 °C (73 °F) and 50 % R.H.		
	4138 MPa (6 x 10 <sup>5</sup> psi) at 60 °C (140 °F) and 50 % R.H. ; Post cured min. 48 hrs		
<b>Tensile Strength ASTM D638</b>	41.1 MPa (7 500 psi) at 23 °C (73 °F) and 50 % R.H.		
	70.3 MPa (10 200 psi) at 60 °C (140 °F) and 50 % R.H. ; Post cured min. 48 hrs		
<b>Tensile Modulus of Elasticity</b>	2.8 x 10 <sup>5</sup> psi at 23 °C (73 °F) and 50 % R.H.		
	3.4 x 10 <sup>5</sup> psi at 60 °C (140 °F) and 50 % R.H. ; Post cured min. 48 hrs		
<b>Elongation at Break</b>	3.2 % at 23 °C (73 °F) and 50 % R.H.		
	4.8 % at 60 °C (140 °F) and 50 % R.H. ; Post cured min. 48 hrs		
<b>Heat Deflection Temperature</b>	44.5 °C (112 °F) [7 days, fiber stress loading: 1.8 MPa (264 psi)]		
<b>Water Absorption</b>	0.32 % (7 days, 24 hour immersion)		
<i>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.</i>			

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**HOW TO USE**

**Surface Preparation** The concrete surface should be prepared to a minimum concrete surface profile (CSP) 3 as defined by the ICRI surface-profile chips. Localized out-of-plane variations, including form lines, should not exceed 1/32 in. (1 mm). Substrate must be clean, sound, and free of surface moisture. Remove dust, laitance, grease, oils, curing compounds, waxes, impregnations, foreign particles, coatings and disintegrated materials by mechanical means ( i.e. sandblasting). For best results, substrate should be dry. However, a saturated surface dry condition is acceptable.

**Mixing** Pre-mix each component. Mix entire unit, do not batch. Pour contents of part 'B' to part 'A'. Mix thoroughly for five (5) minutes using a paddle style mixer on low speed (400–600 rpm) drill until uniformly blended.

**Application** **As a sealer:** Apply mixed Sikadur® Hex-300 epoxy to a properly prepared substrate using a brush, roller or airless sprayer. Sikadur® Hex-300 should be applied at a sufficient rate to fully saturate the substrate without producing a surface film. Coverage rates are based on a substrate with normal porosity.  
**As an impregnating resin:** For vertical and horizontal applications, use Sikadur® Hex-300. For vertical and overhead applications use Sikadur® 330 US as tack coat/primer for the saturated fabric to prevent it from sliding off. Resins may be applied to fabric by either manual or mechanical means. For further information, consult installation guidelines.

**Clean Up** Uncured product can be removed with Sika® Epoxy Cleaner. The cured product can only be removed mechanically.

- Limitations**
- Sikadur® Hex-300 may only be used by experienced professionals. Contact Sika Canada for advice and/or suggestions.
  - Minimum substrate and ambient temperature: 4 °C (40 °F).
  - Do not thin with solvents.
  - Material is a vapor barrier after cure.
  - Minimum age of concrete must be 21–28 days depending on curing and drying conditions.
  - Sikadur® Hex-300 is not an aesthetic product. Color may alter due to variations in lighting and/or UV exposure.
  - Mechanically prepared, top side, horizontal concrete surfaces can be primed with Sikadur® Hex-300. Vertical or overhead surfaces however, must be primed with Sikadur®-330.

**Health and Safety Information** For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.

KEEP OUT OF REACH OF CHILDREN  
FOR INDUSTRIAL USE ONLY

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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, within their shelflife. 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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