



**PRODUCT DATA SHEET**

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EPOXY INJECTION GROUTING

# SikaFix® HH+

## HYDROPHOBIC, LOW VISCOSITY, EXPANDING POLYURETHANE INJECTION GROUT

<b>Description</b>	SikaFix® HH+ is a one-component, low viscosity, high solids, hydrophobic (water-reacted) polyurethane injection grout. It will stop flowing water and displace it from cracks and voids, replacing the water with a flexible and closed cell foam. SikaFix® HH+ is used with SikaFix® HH Accelerator to halt the passage of water through joints or defects in concrete and masonry and provide an effective seal.
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>▪ Filling joints or cracks in concrete structures that exhibit some movement.</li> <li>▪ In applications with high pressure water flow.</li> <li>▪ Curtain wall grouting of below- grade structures.</li> <li>▪ Filling voids such as rock fissures, crushed fault or gravel layers.</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>▪ Easy to use, one component with simple dosage accelerator.</li> <li>▪ Hydrophobic; only a small amount of water is needed for reaction.</li> <li>▪ Expands up to 30 times the liquid volume.</li> <li>▪ Use of accelerator permits work against flow of water and at lower temperatures.</li> <li>▪ Contains no volatile solvents.</li> </ul>

**Technical Data**

<b>Packaging</b>	SikaFix® HH+: 18.9 L (5 US gal.) pail SikaFix® HH Accelerator: 473 mL (1 US pint) can
<b>Colour</b>	SikaFix® HH+: Amber SikaFix® HH Accelerator: Transparent
<b>Yield</b>	SikaFix® HH+ 1 L (33.8 US fl. oz) grout = approx. 30 L (7.9 US gal.) foam (typical free expansion) Dependent upon quantity of Accelerator used and variation in crack/void configuration, injection conditions and end use will influence the yield
<b>Dosage</b>	SikaFix® HH Accelerator Up to 2.5 % Accelerator 473 mL (1 US pint) can per 18.9 L (5 US gal.) of grout (typical)
<b>Shelf Life</b>	1 year in original, resealable packaging. Store in dry, heated area at between 4 - 32 °C (40 - 90 °F). Do not allow product to freeze. Once opened and depending on humidity level, shelf life may be reduced. Precondition material for at least 24 hours at 16 - 32 °C (60 - 90 °F) before use
<b>Application Temperature</b>	Ambient: 4 - 32 °C (40 - 90 °F) Product: 16 - 32 °C (60 - 90 °F)
<b>Cure Mechanism (with 2.5 % SikaFix® HH Accelerator)</b>	
	<b>Reaction/Gel Time</b>
at 10 °C (50 °F)	3 min 15 s
at 20 °C (68 °F)	2 min 10 s
at 25 °C (77 °F)	1 min 20 s
at 30 °C (86 °F)	1 min 10 s
2.5 % of SikaFix® Accelerator = 473 mL (1 US pint) per 18.9 L (5 US gal.) of SikaFix® HH+	
<b>Service Temperature</b>	82 °C (180 °F) maximum
<b>Properties at 23 °C (73 °F) and 50 % R.H.</b>	
<b>Uncured Solids</b>	Uncured SikaFix® HH+
<b>Viscosity</b>	100 % 700 cps
<b>Specific Gravity</b>	1.13 g/L
<b>Flashpoint ASTM D93</b>	> 93 °C (> 200 °F)
<b>Corrosiveness</b>	Non-corrosive
<b>Viscosity</b>	SikaFix® HH Accelerator 25 cps
<b>Specific Gravity</b>	0.95 kg/L
<b>Flashpoint OC ASTM D3278-96</b>	102 °C (216 °F)
	<b>Cured SikaFix® HH+ (+SikaFix® Accelerator)</b>
<b>Density ASTM D1622</b>	64 kg/m³ (4 lb/ft³)
<b>Tensile Strength ASTM D638</b>	0.19 MPa (29 psi)
<b>Elongation D638</b>	44 %
<b>Shrinkage</b>	< 1 %
<b>Absorption D2842</b>	< 1 %
<b>Shear ASTM C273</b>	0.1 MPa (17 psi)

*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.*

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## HOW TO USE

### Surface Preparation

Drill 15 mm (5/8 in) diameter holes along the side of the crack at a 45° angle to intersect the crack midway through the substrate. These holes should be drilled alternately on opposite sides of the crack at approximately 150 - 900 mm (6 - 36 in) centres depending upon the crack width. This spacing can be adjusted to suit specific applications where necessary. Install injection packers into the drilled holes and tighten or position and secure injection ports.

It is always necessary to flush the drilled holes with water to remove debris and drill dust from the holes and crack. This will also insure that the crack is wet enough to react with the grout when it is injected into the crack.

When the crack is contaminated on the outside, it will be necessary to clean the surface so that the crack can be located exactly. If the crack is wide or high water flows are encountered, it will be necessary to seal the surface of the crack with a surface sealing material (SikaSet® Plug, Sikadur®-31 Hi Mod Gel<sup>CA</sup> or a preformed open cell polyurethane foam cord saturated with SikaFix® HH+). The surface sealing can be carried out before or after drilling injection holes, depending on the particular situation.

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### Mixing

Prior to injection, SikaFix® HH+ should be thoroughly agitated by either vigorously shaking the 18.9 L (5 US gal.) pail or by mixing with a low-speed drill (200 - 300 rpm) fitted with a *Jiffy* or *bung* type paddle until a uniform consistency is produced. If mixing, scrape the sides and bottom of the pail to ensure a complete mix is achieved.

Prior to using SikaFix® Accelerator, the container should be shaken vigorously as the contents may settle during storage. For regular use, each 18.9 L (5 US gal) unit of SikaFix® HH+ should be used with 473 mL (1 US pint) container of SikaFix® HH Accelerator, a dosage of 2.5 %. The grout should never be used without SikaFix® HH Accelerator, but never with dosage exceeding the 2.5 % maximum. Excess acceleration will cause uncontrolled expansion which is prone to shrinkage.

Pour the desired quantity of SikaFix® HH+ into a clean, suitably sized mixing vessel and measure the amount of accelerator required and add into the SikaFix® HH+ and stir until adequately mixed.

It is advisable to mix and inject just a part of the prepared material initially (1L [2 pints] would be approximate) to determine the rate of resin travel and confirm how much product can be used within its pot life.

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### Application

**Injection:** Injection of the grout is then carried out, starting at the lowest packer or port installed on a vertical crack and working upwards, or at the first packer or port flushed for a horizontal crack and moving forwards. As SikaFix® HH+ moves into the crack or void, water is displaced ahead of it. Continue injecting until all the water exits and the grout appears at the adjacent packer hole. Stop injecting and move to the next packer/port in the adjacent hole. Insert and tighten the zerk fitting into packers or caps into ports, moving the injection hose to the second packer/port and start injecting once again. Continue the process until 3 or 4 packers/ports have been grouted. Disconnect and go back to the first packer/port and inject all the packers or ports for the second time. Some packers/ports may take additional grout, which will fill up and further densify the material in the crack. Continue this process until the length of the prepared crack is injected.

**Note:** Injection pressure will vary from 1380 - 17240 KPa (200 - 2500 psi) depending on the width of the crack, thickness and condition of the substrate.

**Finishing:** When finished with the injection process, re-inject each installed packer/port with a small quantity of water. This will react with the resin left in the drill hole. After the injection, the packers or injection ports can be cut flush with the concrete surface or can be removed from the injection holes. Let SikaFix® HH+ completely cure before removing the packers/ports. Packer/port holes can be filled with Sikadur® 31 Hi Mod Gel<sup>CA</sup> or SikaSet® Plug and trowelled smooth.

**Removal:** Residual resin that has foamed from the crack can be removed with a scrapper provided that is not cured to a solid on the surface. If the material has cured, remove with a wire brush or hand held grinders. SikaFix® HH+ will aggressively bond to concrete surfaces.

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### Storage Conditioning

Store in a dry area using original resealable containers.

Low temperatures will affect viscosity. To minimize this effect, store the product at normal room temperature for a minimum period of 24 hours prior to use. If site temperatures are extremely low, heat bands or heated water baths may be used on the pails, before and during use to maintain the products temperature. Immerse only the lower 2/3 of the pails. Avoid splashing water into open containers.

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### Clean Up

Use SikaFix® Pump Flush, a non-flammable solvent, to clean tools, lines and equipment of uncured product. Cured material can only be removed mechanically.

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### Limitations

- SikaFix® HH+ is best installed by skilled and experienced applicators, especially in instances where water infiltration is under pressure. Consult Sika Canada for advice and recommendations.
- Low temperatures will significantly affect viscosity; if SikaFix® HH Accelerator is allowed to freeze, it will lower performance of the product.
- Avoid splashing water into open containers, as material is water activated.
- Water used to activate SikaFix® HH+ must be in a pH range of 3 - 10 for optimum foam quality.
- Low temperatures will significantly affect reaction time. To minimize this effect, materials must be stored at 4 - 32 °C (40 - 90 °F) and then preconditioned to 16 - 32 °C (60 - 90 °F) for a minimum of 24 hours prior to use. If site temperatures are extremely low, heat bands or heated water baths may be used on the pails, before and during use to maintain the products temperature. Immerse only the lower 2/3 of the pails.

- Ambient temperature must be between 4 - 32 °C (40 - 90 °F) for use.
- Grout should only be used in confined spaces.
- SikaFix® HH Accelerator must always be added to SikaFix® HH+ but never in dosages exceeding the 2.5 % maximum.
- The reaction may be affected by the presence of hydrocarbons. Pretesting is recommended.

## 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

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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