



**PRODUCT DATA SHEET**

Edition 12.2017/v1  
CSC Master Format™ 03 64 23  
EPOXY INJECTION GROUTING

# Sikadur®-624 LE

## LOW EXOTHERM, TWO-COMPONENT, HIGH STRENGTH, EPOXY RESIN FOR INJECTION GROUTING AND CRACK SEALING

<b>Description</b>	Sikadur®-624 LE, is a two-component, 100% solids modified epoxy resin. It is designed to be used as an injection resin to fill, seal and structurally bond wider cracks in dry or damp concrete and masonry structures, restoring structural integrity and protecting against the ingress of water or harmful substances.
<b>Where to Use</b>	<ul style="list-style-type: none"> <li>Pressure injection of fine dry or damp cracks (&gt; 0.2 mm [0.008 in]) in structural concrete, masonry and other suitable substrates.</li> <li>Use at temperatures down to 10 °C (50 °F).</li> <li>Gravity feeding of fine dry or damp cracks in horizontal concrete and masonry to seal against penetration of water and detrimental solutions.</li> <li>In larger cracks or voids where exotherm and thermal movement may be a concern for other materials.</li> </ul>
<b>Advantages</b>	<ul style="list-style-type: none"> <li>Deep penetration and tenacious crack bonding in dry or damp substrates.</li> <li>Long pot life allows the use of pressure pots or other types of one component injection equipment.</li> <li>Low exotherm allows larger cracks and voids to be injected.</li> </ul>

**Technical Data**

<b>Packaging</b>	3.5 L (0.9 US gal.) unit [2.94 L (0.8 US gal.) Component A; 0.56 L (0.1 US gal.) Component B] Supplied in cartons each containing 2 x 2.94 L (0.8 US gal.) pails and 2 x 0.56 L (0.1 US gal.) cans
<b>Colour</b>	Component A: white Component B: black Mixed (A + B): light grey
<b>Yield</b>	1 L = 1 m <sup>2</sup> of resin at 1 mm thick (1 US gal. = 231 in <sup>3</sup> )
<b>Shelf Life</b>	2 years in original, unopened packaging. Store dry between 5 and 32 °C (41 and 89 °F). Do not allow to freeze. Condition product to 18 and 29°C (65 and 84 °F) to suit injection.
<b>Mix Ratio</b>	A:B = 84:16 by volume , 91:9 by weight
<b>Properties at 23 °C (73 °F) and 50 % R.H.</b>	
<b>Viscosity</b>	A: 2400 cps B: 100 cps 25 °C (77 °F) A + B: 2100 cps 4 °C (39 °F) A + B: 5000 cps
<b>Pot Life (Mixed Resin)</b>	25 °C (77 °F) 110 +/- 10 min
<b>Tack-Free Time</b>	(10/25 °C [50/77 °F]) 18/24 hrs
<b>Full Cure</b>	(10/25 °C [50/77 °F]) 14/7 days
<b>Slant Shear Adhesion ASTM C882</b>	2/14 days 17 MPa (2480 psi)/18 MPa (2670 psi)
<b>Tensile Strength ASTM D412</b>	7 days 78 MPa (11 310 psi)
<b>Tensile Modulus ASTM D638</b>	21 days 4.09 GPa (5.93 x 10 <sup>6</sup> psi)
Elongation	1.08%
<b>Flexural Strength ASTM D790</b>	14 days 65 MPa (9425 psi)
<b>Flexural Modulus</b>	1.3 GPa (1.8 x 10 <sup>5</sup> 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

**General:** Proper preparation and a suitable substrate condition are fundamental to achieving the best results and durable performance from injection grouting and crack sealing. Foreign material in a crack, an anchor hole or horizontal fracture may be a major factor in successful injection or grouting works. **Note:** Substrates must be clean, sound and can be dry or damp. Optimum penetration and adhesion are obtained in dry conditions.

**Concrete:** Where cracks are to be injected or gravity fed, clean the concrete surface along the length of the crack to approx 20 mm (3/4 in) on either side to remove existing coatings or surface treatments, dirt, dust, debris, loose friable material and other such contaminants which will impede penetration and impact upon adhesion. Sandblasting or other such mechanical methods are considered most suitable to remove all deleterious material and provide an open, roughened texture. Where a deeply contaminated concrete exists, ie, containing oils, grease or similar such substances, chip out the affected substrate and vacuum any preparation residue to achieve a suitable surface condition. If possible, clean the crack with a wire brush to clear the way for resin to penetrate. Blow out the crack or defect with clean, dry and filtered (oil-free) compressed air or vacuum to remove all contaminants.

**Steel:** Where cracks are to be injected and steel is present, clean the steel surface around the fracture to approx. 20 mm (3/4 in) to remove existing coatings or surface treatments, dirt, dust, debris, loose friable material and other such contaminants. Sandblasting or other such mechanical methods are considered most suitable to remove all deleterious material and provide a white-metal finish. Blow out the prepared crack, where possible, with clean, dry and filtered (oil-free) compressed air or vacuum to remove all contaminants.

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### Injection Set-Up

When using automated or manual injection equipment, set appropriate injection ports, tees etc. as required by the system being used. The intervals at which injection ports, tees or drilled ports are set will be governed by the severity and extent of the crack together with the nature of the structure. Space the injection points in accordance with the thickness of the element being injected (100 to 200 mm [4 to 8 in]). The spacing can be increased or decreased as determined by the rate of injection of the specific resin.

Where substrates are relatively flat and can accommodate them, injection tees are installed over the crack, taking care not to block the passage way for the injected resin. Where substrates are not flat or cannot be cleaned to the required standard to allow adequate adhesion of the injection ports, install drilled ports. Create drill holes approximately 25 mm (1 in) deep and 10 mm (3/8 in) diameter or to suit the ports being used using a vacuum drill. Ensure the passage way is not blocked and insert the injection ports.

Where a crack is accessible on both faces of a structural element or the substrate is greater than 500 mm (20 in) in its cross-section, the crack should be capped and injection points may need to be located on both faces. Bond the injection tees or ports, using Sikadur®-31 Hi-Mod Gel<sup>CA</sup> or Sika AnchorFix®-3001, depending upon prevailing conditions (refer to specific Product Data Sheet). Ensure that the injection tees or ports are securely fixed to prevent leakage or displacement but that the adhesive does not obstruct the path through which the injection resin is to pass.

Seal or 'cap' the face of the crack, defect or void using Sikadur®-31 Hi-Mod Gel<sup>CA</sup> or Sika AnchorFix®-3001, depending upon prevailing conditions. The capping can be applied by a manual dispenser, trowel or with a palette knife, ensuring a consistent thickness (6 mm [1/4 in]) and complete seal over the crack (25 mm [1 in] wide) in order to prevent leakage when injection begins. Extra care should be paid to this step as this is the most likely place for problems and/or delays due to "break outs" in the capping. When a break out happens, injection often has to be stopped until the crack can be re-capped to prevent leakage.

It is sometimes possible to flush cracks or voids to remove contaminants or foreign particles prior to injection, introducing water or compressed air through the injection tees or ports in succession and subsequently inserting a plastic plug or cap into the injection port to close them off and prevent further contamination. A thorough study in this regard is always necessary. **Note:** If flushing the crack with water, always allow the crack to dry out sufficiently before injecting. Be aware that injecting into a wet crack may not produce a structural repair, depending on the technique employed.

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### Mixing

Prior to mixing, pre-stir Components A and B separately to achieve an even consistency. Proportion 16 parts Component B (hardener) to 84 parts Component A (base) by volume and empty into a clean, suitably sized container in which the material can be thoroughly mixed without loss. Mix the combined components thoroughly for at least two (2) minutes, using a slow-speed drill (300 - 450 rpm) to minimise entrapping air. Use an *Exomixer*® type mixing paddle (recommended model) suited to the volume of the mixing vessel. During the mixing operation, scrape down the sides and the bottom of the container with a flat or straight edge trowel at least once to ensure complete mixing. When completely blended Sikadur®-624 LE should be uniform in appearance and consistency. Mix only that quantity that can be used within its pot life, approximately 1 hour 40 minutes, depending on the volume mixed and prevailing temperatures. Transfer the mixed resin into a suitable injection device or gravity feed container.

<b>Application</b>	<p><b>To pressure inject cracks:</b> Once the sealing (capping) paste has cured, inject Sikadur®-624 LE with slow, steady pressure. The very low viscosity of the product allows it to be injected at high pressure (approx. 1380 kPa [200 psi]) or lower pressure (approx. 275 kPa [40 psi]). Injection pressure is based upon the resin, the structure, location, width, depth and extent of the crack to be filled.</p> <p>Start the injection process at the widest section of the crack if working horizontally or where the injection is to a vertical surface, begin at the lowest port and work upwards. Keep all ports opened and close or plug the ports once there is free flowing resin from that port. Continue injecting into the open and clear port until the pressure builds up and resin flows freely and uniformly from the next port in the sequence. Maintain the injection pressure for 1 to 5 minutes to maximise penetration and then close the port being injected and release pressure. Continue until the crack or void is completely filled with resin.</p> <p>Test samples of the resin being injected should be taken before, during and after injection is completed to ensure that the resin is properly mixed and will cure satisfactorily. Following a waiting time of 24 hours after injection work has been completed, remove all injection ports, fill any resulting cavities and, where necessary, grind down the sealing (capping) paste. Unless the site of the injection works is being overlaid or overcoated, there will be a limit to the degree to which an aesthetic appearance can be achieved. Where this is an issue, a sample installation should be undertaken and assessed.</p>
<b>Clean Up</b>	<p>Uncured material can be removed with Sika® Epoxy Cleaner. Cured product can only be removed mechanically. Wash soiled hands and skin thoroughly in hot soapy water or use Sika® Hand Cleaner towels.</p>
<b>Limitations</b>	<ul style="list-style-type: none"> <li>▪ Sikadur®-624 LE must not be thinned; solvents will prevent proper cure.</li> <li>▪ Minimum age of concrete must be 21 to 28 days depending on curing and drying conditions.</li> <li>▪ Injection of fine cracks becomes difficult below 10 °C (50 °F).</li> <li>▪ Minimum in place curing temperature: 0 °C (32 °F).</li> <li>▪ Maximum neat resin thickness: 6 mm (1/4 in).</li> <li>▪ Not for injection of cracks under hydrostatic pressure/flowing water conditions.</li> <li>▪ Sikadur®-624 LE is a moisture vapour barrier when cured.</li> </ul>
<b>Health and Safety Information</b>	<p>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.</p>

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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