



PRODUCT DATA SHEET

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Sika AnchorFix®-800

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HIGH-STRENGTH ANCHORING ADHESIVE FOR FAST LOADING

Description	Sika AnchorFix®-800 is a two-part, epoxy/acrylate, styrene- and solvent-free anchoring adhesive. It can be used in horizontal and vertical applications, tolerates damp or wet conditions and cures at temperatures as low as -10 °C (14 °F) to produce high bond and loading strengths. Sika AnchorFix®-800 is used in applications including the anchoring of dowels, threaded rod or rebar into concrete, and anchoring guard rails, support brackets, tilt-up wall braces and other equipment.
Where to Use	For concrete highway and bridge construction: <ul style="list-style-type: none"> As an adhesive gel for anchoring dowels, bolts and threaded bars into solid concrete (pavement slabs, decks, etc.) and solid rock. As a rigid adhesive to bond concrete building materials together.
Advantages	<ul style="list-style-type: none"> Available as 10:1 ratio, side-by-side cartridges. Non-sag consistency allows application on horizontal and vertical surfaces. Suitable for uncracked concrete applications. Sets up in dry, damp or wet conditions. Fast curing, without shrinkage. Cures down to -10 °C (14 °F) when material is pre-conditioned to 5 °C (41 °F). Achieves high tensile and shear strengths. Excellent resistance to vibration of anchors. Provides corrosion protection to embedded materials.
Approvals / Certifications	<ul style="list-style-type: none"> ANSI/NSF Standard 61 approved for contact with potable water. ES to AC308 by IAPMO - in progress Evaluation in progress for <i>The Road Authority</i> (TRA) and Ministry of Transportation of Ontario (MTO) - 9.30.25 prequalification list for Structural Dowel Adhesives - Acrylic and Epoxy Resins. Ministère des Transports du Québec approval in progress. IBC/IRC

Technical Data		
Packaging	825 mL (27.8 US fl.oz) 10:1 ratio, side-by-side cartridges / 6 per case	
Colour	Grey	
Shelf Life	12 months if stored properly in original and unopened packaging, in cool and dry conditions, out of direct sunlight, and at temperatures between 5 and 20 °C (41 and 77 °F). Pre-condition product to 23 °C (73 °F) to ease application when using hand dispensers and working at low temperatures.	
Mix Ratio	A:B = 10:1 by volume	
Properties at 23 °C (73 °F) and 50 % R.H.		
Density	1.67 kg/L (part A + B mixed)	
Sag Flow	Non-sag	
Layer Thickness	5 mm (6/32 in)	
Temperature Resin & Substrate	Working Time	Loading Time
-10 → -5 °C (14 → 23 °F)*	40 - 60 min	12 - 14 h
-5 → 0 °C (23 → 32 °F)*	30 - 10 min	6 - 8 h
0 → 5 °C (32 → 41 °F)	20 - 30 min	3 - 4 h
5 → 10 °C (41 → 50 °F)	10 - 20 min	2 - 3 h
10 → 20 °C (50 → 68 °F)	6 - 10 min	1 h 30 - 2 h
20 → 30 °C (68 → 86 °F)	4 - 6 min	40 - 50 min
> 30 °C (> 86 °F)	3 - 4 min	30 to 40 min
*Adhesive maintained at 5 °C (41 °F) minimum.		
VOC Content	< 50 g/L	
Chemical Resistance	Consult Sika Canada	
<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>		

HOW TO USE

Surface Preparation

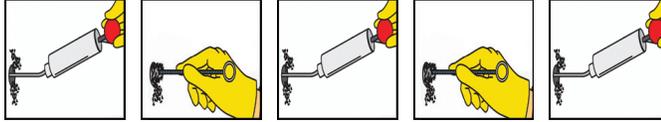
Surfaces must be clean and sound. Surfaces / holes may be dry, damp or wet. Remove dust, laitance, grease, oil, curing compounds, impregnations, waxes, foreign particles and disintegrated materials. Substrate strengths must be verified, with pull-out tests being conducted if strength is unknown.

Application

Solid Substrate Installation

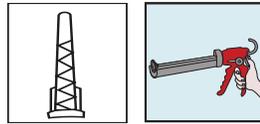


1. Drill the hole to the correct diameter and depth to suit the anchor, using a rotary percussion drill and carbide-tipped bit.



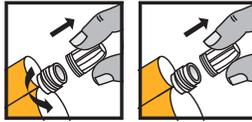
2. Thoroughly clean the hole in the above sequence. Use an air lance inserted into the back of the hole with the trigger depressed for two (2) seconds, blow out all debris. The compressed air must be free from oil and water with a minimum pressure of 6 bar (90 psi). If using a hand pump for holes of 400 mm (16 in) deep or less, pump twice to achieve clean holes. If the hole collects water after the initial cleaning this water must be removed before injecting the resin.

3. Select an appropriate sized nylon brush, ensuring it is in good condition and suited to the diameter of the drilled hole. Insert the brush to the back of the hole and pull out using a back and forth rotating motion to remove all loose friable material. Repeat the brushing operation. Repeat the steps 2 and 3, finishing with step 2.

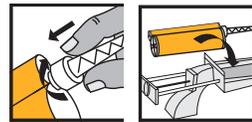


4. Select the appropriate static mixer nozzle for the installation. Also, prepare a good quality dispensing gun, ensuring it is in good working order to extrude the anchoring gel. Wherever practical, use pneumatic dispensers for optimum ease of dispensing.

825 mL cartridge installation

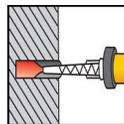


5. Unscrew and remove the threaded cap. Pull out the exposed and wire tied plastic film and cut below location of tie.



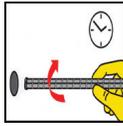
6. Screw the static mixer nozzle to the cartridge, secure with the integral nut and insert the assemblage into the dispensing gun. Trigger the dispenser until a uniform colour (no streaking) and consistency are achieved with unmixed material going to waste.

If necessary, cut an extension tube to the depth of the hole and push onto the end of the static mixer, and (for rebars 16 mm (5/8 in) diameter or more) fit the correct resin stopper to the other end.

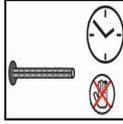


7. Insert the static mixer tip (resin stopper / extension tube if applicable) to the base of the hole. Begin to extrude the resin, under constant and uniform pressure, and slowly withdraw the static mixer from the hole. Fill the hole to approximately $\frac{1}{2}$ to $\frac{3}{4}$ full and remove the static mixer completely.

Note: If dispensing is interrupted or altered, re-establish consistency of resin prior to continuing. When using a manual dispenser, release piston pressure by pressing thumb plate at every pause in extrusion



8. Insert the threaded bar or reinforcing bar (both should be free from oil or other release agents) to the back of the hole using a back and forth rotating motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time. Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full. This excess resin should be removed from around the opening to the hole before it sets.



9. Leave the anchor undisturbed until the appropriate loading time has been achieved, which will be dependent upon the substrate conditions and ambient temperatures.

10. Attach the fixture and tighten the nut to the recommended torque, DO NOT OVERTIGHTEN.

Clean Up

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

Limitations

- Sika AnchorFix®-800 is not intended as a cosmetic or decorative material and when anchoring into porous substrates or reconstituted stone, staining may occur. Where this is of concern, consult Sika Canada for advice and undertake discrete trial applications before proceeding.
- Store material to above 5 °C (41 °F) and, for ease of application by manual dispensers, precondition to higher temperatures, for example 23 °C (73 °F) when working at low temperatures; the higher the temperature the easier to dispense. Take into consideration reduced working times.
- Minimum age of concrete must be 28 days, depending on curing and drying conditions.
- Maximum adhesive thickness: 5 mm (6/32 in).
- Do not thin; solvents will prevent proper cure.
- Do not use in overhead applications.
- Standard and quality of dispenser will impact upon ease of extrusion, especially when using manual equipment; ensure the mechanical advantage is appropriate, pistons are correctly aligned and even pressure is achievable.
- Sika AnchorFix®-800 must only be applied on or into substrates when they are frost-free.

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

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