



# PRODUCT DATA SHEET

## Sikadur Combiflex® CF Adhesive Normal

### 2-PART EPOXY ADHESIVE FOR THE SIKADUR COMBIFLEX® SYSTEM

#### PRODUCT DESCRIPTION

Sikadur Combiflex® CF Adhesive Normal is a 2-part epoxy based thixotropic adhesive for bonding the modified flexible Polyolefin (FPO) waterproofing tapes covered by the Sikadur Combiflex® SG System to different substrates. Internal and external use. Temperature range +10 °C to +30 °C.

#### USES

- As adhesive for:
- Sikadur Combiflex® SG System
- As a structural adhesive for:
- Concrete
  - Masonry and Bricks
  - Steel
  - Hard natural stone

#### CHARACTERISTICS / ADVANTAGES

- Easy to mix and apply
- Excellent adhesion to many materials
- Performs well within a wide temperature range
- Good resistance to many chemicals
- No primer needed
- High mechanical resistance

#### APPROVALS / STANDARDS

CE Marking and Declaration of Performance to EN 1504-4 - Structural bonding

#### PRODUCT INFORMATION

Chemical Base	Epoxy resin and selected fillers	
Packaging	Part A	20 kg containers
	Part B	10 kg containers
	Pallets of 600 kg: (20 × 20 kg Part A) + (20 × 10 kg Part B)	
Colour	Resin-Part A	White
	Hardener-Part B	Dark grey
	Part A+B mixed	Light grey
Shelf Life	24 months from date of production	
Storage Conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging.	

Density	Part A	~1,5 kg/l
	Part B	~1,5 kg/l
	Mixed resin	~1,5 kg/l

All Density values at +23 °C.

Product Declaration	EN 1504-4 - Structural bonding
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## TECHNICAL INFORMATION

Compressive Strength	Curing time	Curing temperature			(ASTM D 695-96)
		+10 °C	+23 °C	+30 °C	
	3 days	~35 N/mm <sup>2</sup>	~48 N/mm <sup>2</sup>	~52 N/mm <sup>2</sup>	
	7 days	~41 N/mm <sup>2</sup>	~50 N/mm <sup>2</sup>	~54 N/mm <sup>2</sup>	
	14 days	~43 N/mm <sup>2</sup>	~54 N/mm <sup>2</sup>	~55 N/mm <sup>2</sup>	

Modulus of Elasticity in Compression	~ 4200 N/mm <sup>2</sup> (+5 °C) ~ 3500 N/mm <sup>2</sup> (+23 °C)	(ASTM D 695)
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Tensile Adhesion Strength	Substrate	Adhesion strength	(EN 1542)
	Concrete dry	> 4 N/mm <sup>2</sup> *	
	Concrete (mat damp)	> 4 N/mm <sup>2</sup> *	
	Steel (blast cleaned)	>10 N/mm <sup>2</sup>	

\*failure in concrete

Coefficient of Thermal Expansion	$5,3 \times 10^{-5}$ ( $\pm 0,2 \times 10^{-5}$ ) 1/K (linear expansion between -20 °C and +40 °C)	(EN ISO 1770)
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Chemical Resistance	Refer to Sikadur Combiflex® SG System system data sheet or contact Sika Technical Services for specific information.
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Service Temperature	-30 °C min. / +60 °C max.
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## SYSTEM INFORMATION

System Structure	Refer to Sikadur Combiflex® SG System data sheet or contact Sika Technical Services for specific information.
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## APPLICATION INFORMATION

Mixing Ratio	Part A : B = 2 : 1 parts by weight or volume		
Consumption	Refer to Sikadur Combiflex® SG System data sheet. Depends on type of tape or strip.		
Product Temperature	+10 °C min. / +30 °C max.		
Ambient Air Temperature	+10 °C min. / +30 °C max.		
Dew Point	Beware of condensation. Steel substrate temperature during application must be at least 3 °C above dew point.		
Substrate Temperature	+10 °C min. / +30 °C max.		
Substrate Moisture Content	Cementitious substrates: Substrate must be dry or matt damp (no standing water). Brush the adhesive well into the substrate if matt damp.		
Pot Life	Temperature	Potlife*	Open time
	+10 °C	~125 minutes	—
	+23 °C	~50 minutes	~70 minutes
	+30 °C	~25 minutes	—

(EN ISO 9514)

If larger quantities are being mixed the temperature of Sikadur Combiflex® CF Adhesive Normal will increase due to the chemical reaction, resulting in a reduced potlife.

## APPLICATION INSTRUCTIONS

### SUBSTRATE QUALITY

#### Concrete/masonry/mortar/stone

Concrete and mortar must be at least 3–6 weeks old. Substrate surfaces must be sound, clean, dry or matt damp. Free from standing water, ice, dirt, oil, grease, coatings, laitance, efflorescence, old surface treatments, all loose particles and any other surface contaminants that could affect adhesion of the adhesive.

#### Steel

Surfaces must be clean, dry, free from oil, grease, coatings, rust, scale, all loose particles and any other surface contaminants that could affect adhesion of the adhesive.

### SUBSTRATE PREPARATION

#### Concrete/masonry/mortar/stone

Substrates must be prepared mechanically using suitable abrasive blast cleaning, needle gunning, light scabbling, bush hammering, grinding or other suitable equipment to achieve an open textured gripping surface profile.

#### Steel

Surfaces must be prepared mechanically using suitable abrasive blast cleaning, grinding, rotating wire brush or other suitable equipment to achieve a bright metal finish with a surface profile similar to aluminium oxide paper medium grade. Avoid dew point conditions before and during application.

#### All substrates

All dust and loose material must be completely removed from all substrate surfaces before application of the product by vacuum / dust removal equipment.

### MIXING

#### Pre-batched units

Prior to mixing all parts, mix part A (resin) briefly using a mixing spindle attached to a slow speed electric drill (max. 300 rpm). Add part B (hardener) to part A and mix Part A+B continuously for at least 3 minutes until a uniformly coloured smooth consistency mix has been achieved. To ensure thorough mixing pour materials into a clean container and mix again for approximately 1 minute. Over mixing must be avoided to minimise air entrainment. Mix full units only. Mixing time for A+B = 4,0 minutes. Mix only the quantity which can be used within its pot life.

#### Bulk packaging, not pre-batched

Mix each Part separately before mixing together. Add the Parts in the correct proportions into a suitable mixing pail and stir correctly using an electric low speed mixer as above for pre-batched units. For large volume mixing a suitable pan mixer can be used.

### APPLICATION METHOD / TOOLS

Refer to Sikadur Combiflex® SG System data sheet.

### CLEANING OF TOOLS

Clean all tools and application equipment with Thinner C immediately after use. Hardened or cured material can only be removed mechanically.

### VALUE BASE

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

### LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

### ECOLOGY, HEALTH AND SAFETY

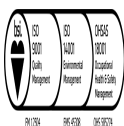
For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

### 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 written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. 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.

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**Product Data Sheet**

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