Construction

Icosit® KC 330 FK

2-pack Polyurethane adhesive

Product-description

Icosit® KC 330 FK is a 2-component, solvent-free, flexible polymer based on Polyurethane.

Uses

- **Icosit® KC 330 FK** Icosit KC 330 FK is a thixotropic (sag-resistant) flexible adhesive designed for e.g. fixing machinery in industry, for joining various construction materials, in particular metal and concrete, e.g. for fixing stainless steel cladding to the running surface of clarifiers in sewage treatment plant.
- Particularly suited for fixing (concrete) filler blocks to the web of grooved rails for in-street installation of trackwork.

Characteristics / advantages

- Excellent weathering and ageing resistance
- Usually no need for temporary fixation
- High initial adhesion
- Levels out tolerances
- Vibration reducing
- Sound absorbing

Product Data

Colour shades

Black

Packaging

Component A:	9.0 kg pail
Component B:	1.0 kg tin
A + B composite unit	10 kg

Conditions of storage / shelf-life

12 months from date of manufacture in cool and dry storage in unopened original containers, protected from direct sun radiation, at temperatures between + 10 °C and + 25 °C. Protect from frost.

Technical Data

Chemical base

2-component polyurethane adhesive

Density

Component A:	approx. 1.40 kg/l	(ISO 2811-1)
Component B:	approx. 1.23 kg/l	(ISO 2811-1)
A + B	approx. 1.40 kg/l	(ISO 1183-1)

Viscosity

Component A:	approx. 4.00 Pa s	mit Z 3 DIN, 20 °C
Component B:	approx. 0.26 Pa s	mit Z 3 DIN, 20 °C

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Layer thickness	Minimal 3 mm Maximal 30 mm	
Temperature resistance	From - 40 °C to + 80 °C (temporarily up to + 150 °C)	
Tensile strength	Approx. 3.0 N/mm²	(ISO 527)
Shore A hardness	85 ± 5 (after 28 days)	(ISO 868)
Elongation at break	Approx. 50 %	(ISO 527)
Tear strength	Approx. 8.5 N/mm²	(ISO 34 B)
Chemical resistance	**Long-term resistant against:** ■ Water ■ Most detergents ■ Sea water **Temporary resistant against:** ■ Mineral oil, Diesel fuel **Not or only short-term resistant against:** ■ Organic solvents (ester, ketone, aromates) and alcohol ■ Concentrated acids and lyes **For more details contact our technical service centre.**	

System Information

Consumption	Approx. 1.4 kg per litre of volume.
Substrate quality	Substrate must be solid, dry, free from oil, fat, dust and loose particles.
Substrate preparation	**Icosit® KC 330 Primer:** If a particularly good adhesion is required, absorbent substrates (concrete) should be primed. Waiting time between application of **Icosit® KC 330 Primer** and application of **Icosit® KC 330 FK** min. 1 hour and max. 3 days. **SikaCor® 277:** If a waiting time of more than 3 days is to be expected between priming and application of **Icosit® KC 330 FK** or if a solvent-free primer or an efficient corrosion protection is required, **SikaCor® 277** shall be used for priming. The freshly applied coating should immediately be blinded (broadcasted) with quartz sand 0.4 – 0.7 mm granulometry. Minimum waiting time between application of **SikaCor® 277** and **Icosit® KC 330 FK** is 24 hours. See individual data sheets for these products.

Application Conditions

Material temperature	Before application preferably between + 15 °C to + 25 °C.
Substrate temperature	Minimal + 5 °C Maximal + 35 °C
Ambient temperature	Minimal + 5 °C Maximal + 35 °C
Substrate humidity	Dry
Relative air humidity	Maximal 70 %

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Application Instructions

Application methods / Tools

Mixing proportion component A : component B = 100 : 11 (parts by weight).

Icosit® KC 330 FK is supplied in pre-weighed composite units consisting of A + B component.
Component A must be stirred up thoroughly before being mixed with component B.
Whilst mixing 10 kg units, observe the following instructions:

- electric or pneumatic stirrer, approx. 600 - 800 rpm
- mixing time approx. 60 to 80 seconds
- make sure to properly reach walls and bottom of container.

During mixing until approx. 3 minutes afterwards, material remains liquid (pourable) and subsequently turns into a thixotropic, sag-resistant, trowel-applicable consistency.

For 10 kg units, we recommend mixer CX 40 stirrer WK 140 of Messrs. Collomix or mixer MXP 1000 EQ with stirrer HS 2, 140 x 160, of Messrs. PROTOOL.

Caution: Material is moisture-sensitive.
Do not warm up in water. Apply only on absolutely dry surfaces.

Cleaning of tools

Mixing and application tools must be cleaned at regular intervals and immediately after use with **Sika® Cleaner 5**. Cured material can only be removed mechanically.

Pot life

Approx. 15 minutes at + 20 °C (68 °C).

After this time, the mixture becomes unserviceable.

Do not add any solvents!

Higher temperatures will shorten pot life!

Waiting time

Tack-free after approx. 3 h at + 20 °C.

Fully chargeable after approx. 24 hours at + 20 °C (2 to 3 days at + 5°C).

Notes on application

For easier application we recommend a material temperature of +15°C.

Layer thickness should not be less than 3 mm and should not exceed 30 mm.

Application of Sika Primers increases pull-off values considerably, in particular on porous substrates.

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.

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Health and Safety Information

Protective Measures

Component B of **Icosit® KC 330 FK** contains Isocyanate.

Isocyanate containing material may cause irritation and – under permanent exposure – sensitization of skin, eyes and respiratory tract and may also lead to allergic reactions. Allergic persons and persons tending to illness of respiratory tract should not come into contact with this kind of materials. Therefore avoid direct contact with the liquid components (chemical resistant gloves/goggles/clothing) to prevent direct contact with skin and eyes. Use only in presence of adequate general and local exhaust ventilation to prevent concentration of vapours. Use properly fitted NIOSH respirator if ventilation is poor. Cured product (as combined with companion component) is chemically inert but very difficult to remove from skin or any objects to which it adheres. Cured product must be mechanically removed. In case of spill, avoid direct contact. Wearing protective equipment, contain and collect spill with absorbent material and place in suitable container. Ventilate enclosed area. Do not dispose of in sewer or drain. Dispose of spilled or excess product and container in accordance with applicable federal, state and local environmental regulations.

Prior to as well as after application use fat-free barrier cream. After completion of work clean skin with plenty of soap and water and again protect with fat-containing barrier cream.

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

Notes

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Important Notes

Residues of material must be removed according to local regulations. Fully cured material can be disposed of as household waste in agreement with the responsible local authorities.

Detailed health and safety information as well as detailed precautionary measures e.g. physical, toxicological and ecological data can be obtained from the safety data sheet.

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 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 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 Product Data Sheet for the product concerned, copies of which will be supplied on request.

Sika Deutschland GmbH
Kornwestheimer Str. 107
D-70439 Stuttgart/Germany
Phone +49 711 8009-0
Fax +49 711 8009-321

Stuttgarter Str. 139
D-72574 Bad Urach/Germany
Phone +49 7125 940-0
Fax +49 7125 940-321

Rieter Tal
D-71665 Vaihingen/Enz/Germany
Phone +49 7042 109-0
Fax +49 7042 109-180