

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 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 shade Black

Packaging

component A	9,0 kg pail
Component B	1,0 kg tin
A + B	10 kg

Conditions of storage / shelf life

12 months (3 kg cartridges 6 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..



Chemical basis	2-component polyurethane adhesive		
Density	component A	~ 1,40kg/l	ISO 2811-1
	component B	~ 1.23 kg/l	ISO 2811-1
	A + B	~ 1,40 kg/l	ISO 1183-1
Viscosity	component A	~ 4,00 Pa s	With Z 3 DIN, 20°C
	component B	~ 0,26 Pa s	With Z 3 DIN, 20°C
Layer thickness	minimum 3 mm maximum 30 mm		
Temperature resistance	from -40°C to +80°C (temporary up to 150°C)		
Tensile strength	Approx. 3,0 N/mm ²		(ISO 527)
Shore A hardness	85 ± 5 (after 28 days)		(ISO 868)
Elongation at break	~ 50%		(ISO 527)
Tear strength	~ 8,5 N/mm		(ISO 34 B)

Chemical resistance

Long-term resistant against:

- Water
- Most detergents
- Sea water

Temporary resistant against:

- Mineral oils, 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	<p>Icosit KC 330 Primer:</p> <p>If a particularly good adhesion is required, absorbent substrates (concrete) should be primed. Waiting time between application of Icosit KC 330 Primer and pouring of Icosit KC 340/7 min. 1 hour and max. 3 days.</p> <p>SikaCor 277:</p> <p>If a waiting time of more than 3 days is to be expected between priming and pouring Icosit KC 340/7 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.</p> <p>Minimum waiting time between application of SikaCor 277 and Icosit KC 330/FK is 24 hours.</p> <p>See individual data sheets for these products.</p>
Material temperature	Before application preferably between approx. +15 to 25°C
Substrate temperature	+5°C min. / +35°C max
Ambient temperature	+5°C min. / +35°C max.
Substrate humidity	Dry
Relative air humidity	70% maximum

Application methods / Tools	<p>Mixing proportion component A : component B = 100 : 11 (parts by weight)</p> <p>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:</p> <ol style="list-style-type: none"> 1. electric or pneumatic stirrer, approx. 600-800 rpm 2. mixing time approx. 60 to 80 seconds 3. make sure to properly reach walls and bottom of container. <p>During mixing until approx. 3 minutes afterwards, material remains liquid (pourable) and subsequently turns into a thixotropic, sag-resistant, trowel-applicable consistency.</p> <p>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.</p> <p>Caution: Material is moisture-sensitive. Do not warm up in water. Apply only on absolutely dry surfaces.</p>
Cleaning of tools	<p>Mixing and application tools must be cleaned at regular intervals and immediately after use with Cleaner 5. Cured material can only be removed mechanically.</p>
Potlife	<p>Approx. 15 minutes at + 20 °C (68 °F)</p> <p>After this time, the mixture becomes unserviceable.</p> <p>Do not add any solvents!</p> <p>Higher temperatures will shorten potlife!</p>
Waiting time	<p>Tack-free after approx. 3 hours at + 20 °C</p> <p>Fully chargeable after approx. 24 hours at + 20 °C (2 to 3 days at + 5 °C)</p>
Notes on application	<p>For easier application we recommend a material temperature of +15 °C.</p> <p>Layer thickness should not be less than 3 mm and should not exceed 30 mm.</p> <p>Application of Sika Primers increases pull-off values considerably, in particular on porous substrates.</p>
Value Base	<p>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.</p>
Local Restrictions	<p>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.</p> <p>Component B of Icosit KC 330/FK contains Isocyanate.</p>
Health and Safety Information	<p>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.</p> <p>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.</p> <p>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.</p>

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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