Construction

Sikadur® 41 CF Normal (formerly Sikadur 741)

3-part thixotropic epoxy patching mortar

Product Description

Sikadur®-41 CF Normal is a solvent-free, thixotropic, three part patching and repair mortar, based on a combination of epoxy resins and special fillers, designed for use at temperatures between +10℃ and +30℃.

Uses

As repair and bonding mortar for:
- Concrete elements
- Hard natural stone
- Ceramics, fiber cement
- Mortar, Bricks, Masonry
- Steel, Iron, Aluminium
- Wood
- Polyester, Epoxy
- Glass

As a repair mortar:
- Filling of cavities and voids
- Vertical and overhead use

As an abrasion and impact resistant wearing course.
- Joint and crack arris / edge repair

Characteristics / Advantages

Sikadur®-41 CF Normal has the following advantages:
- Easy to mix and apply
- Suitable for dry and damp concrete surfaces
- Very good adhesion to most construction materials
- High strength
- Thixotropic: non-sag in vertical and overhead applications
- Solvent free
- Hardens without shrinkage
- Different coloured components (for mixing control)
- No primer needed
- High initial and ultimate mechanical strength
- Good abrasion resistance
- Good chemical resistance

Tests

Approval / Standards

Testing according to ASTM, C881M-02, Type I, Grade 3, Class B+C.
Testing according to EN 1504-4.

Product Data

Form

Appearance /Colours

Part A:	white
Part B:	dark grey
Part C:	sand
Parts A+B+C mixed:	concrete grey

Packaging

11 kg (A+B+C) Pre-batched unit

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Storage

Storage Conditions/ Shelf-Life	24 months from date of production if stored properly in original unopened, sealed and undamaged packaging, in dry conditions at temperatures between +5℃ and +30℃. Protect from direct sunshine.

Technical Data

Chemical Base	Epoxy resin.
Density	1.90 + 0.1 kg/l (Part A) (at +23℃) 1.90 + 0.1 kg/l (Part B) (at +23℃) 1.50 + 0.1 kg/l (Part C) (bulk density at +23℃) 1.85 + 0.1 kg/l (Part A+B+C mixed) (at +23℃) (evac uated)
Sag Flow	On vertical surfaces it is non-sag up to 20 mm thickness. (according to EN 1799)
Layer Thickness	60 mm max. When using multiple units, one after the other. Do not mix the following unit until the previous one has been used in order to avoid a reduction in handling time.
Change of Volume	Shrinkage: Hardens without shrinkage.
Thermal Expansion Coefficient	Coefficient W: 35 x 10^{-6} per ℃ (Temp. range +23℃ - +60℃) (according to EN 1770)
Thermal Stability	Heat Deflection Temperature (HDT): HDT = +49℃ (7 days / +23℃) (according to ISO 75) (thickness 10 mm)

Mechanical / Physical Properties

Compressive Strength (according to DIN EN 196)

Curing time	+10℃	+23℃	+30℃
1 day	13 – 23 N/mm²	57 – 67 N/mm²	67 – 77 N/mm²
3 days	45 – 55 N/mm²	74 – 84 N/mm²	76 – 86 N/mm²
7 days	59 – 69 N/mm²	77 – 87 N/mm²	77 – 87 N/mm²

Flexural Strength (according to DIN EN 196)

Curing time	+10℃	+23℃	+30℃
1 day	6 – 12 N/mm²	17 – 27 N/mm²	20 – 30 N/mm²
3 days	14 – 24 N/mm²	21 – 31 N/mm²	25 – 35 N/mm²
7 days	26 – 36 N/mm²	33 – 43 N/mm²	33 – 43 N/mm²

Tensile Strength (according to ISO 527)

Curing time	+10℃	+23℃	+30℃
1 day	2 – 6 N/mm²	13 – 19 N/mm²	12 – 22 N/mm²
3 days	12 – 18 N/mm²	15 – 21 N/mm²	14 – 24 N/mm²
7 days	13 – 19 N/mm²	16 – 22 N/mm²	16 – 26 N/mm²

Bond Strength (according to EN ISO 4624, EN 1542 and EN 12188)

Curing time	Temperature	Substrate	Bond strength
1 day	+10℃	Concrete dry	> 4 N/mm² *
1 day	+10℃	Concrete moist	> 4 N/mm² *
1 day	+10℃	Steel	4 – 8 N/mm²
1 day	+23℃	Steel	13 – 17 N/mm²

*100% concrete failure.

E-Modulus	Tensile:	
	~ 4'000 N/mm² (14 days at +23℃)	(according to ISO 527)
	Compressive:	
	~ 9'000 N/mm² (14 days at +23℃)	(according to ASTM D695)
Elongation at Break	0.2 ± 0.1% (7 days at +23°C)	(according to ISO 75)

System Information

Application Details	
Consumption / Dosage	The consumption of Sikadur®-41 CF Normal is ~ 2.0 kg/m² per mm of thickness.
Substrate Quality	Mortar and concrete must be older than 28 days (dependent on environment and strength). Verify the substrate strength (concrete, masonry, natural stone). The substrate surface (all types) must be clean, dry and free from contaminants such as dirt, oil, grease, existing surface treatments and coatings etc. Steel substrates must be de-rusted similar to Sa 2.5. The substrate must be sound and all loose particles must be removed.
Substrate Preparation	Concrete, mortar, stone, bricks: Substrates must be sound, dry, clean and free from laitance, ice, standing water, grease, oils, old surface treatments or coatings and loosely adhering particles to achieve a laitance and contaminant free, open textured surface. Steel: Must be cleaned and prepared thoroughly to an acceptable quality i.e. by blastcleaning and vacuum. Avoid dew point conditions. Other surfaces (polyester, epoxy, glass, ceramic): On these substrates pre-apply Sikadur®-31CF Slow and then, "wet on wet" apply Sikadur®-41 CF Normal. In all cases, Sikadur 31 CF is recommended to be applied as primer prior to application of Sikadur 41 CF Normal.
Application Conditions / Limitations	
Substrate Temperature	+10℃ min. / +30℃ max.
Ambient Temperature	+10℃ min. / +30℃ max.
Material Temperature	Sikadur®-41 CF Normal must be applied at temperatures between +10℃ and +30℃
Substrate Humidity	When applied to mat moisture concrete, brush the adhesive well into substrate.
Dew Point	Beware of condensation! Ambient temperature during application must be at least 3℃ above dew point.
Application Instructions	
Mixing	Part A : B : C = 2 : 1 : 2.5 by weight Part A : B : C = 2 : 1 : 3.4 by volume
Mixing Time	 Pre-batched units Mix parts A+B together for at least 3 minutes with a mixing spindle attached to a slow speed electric drill (max. 600 rpm) until the material becomes smooth in consistency and a uniform grey colour. Avoid aeration while mixing. Then, pour the whole mix into a clean container and stir again for approx. 1 more minute at low speed to keep air entrapment at a minimum. Mix only that quantity which can be used within its potlife.

Construction

Application Method / Tools

When using a thin layer adhesive, apply the mixed adhesive to the prepared surface with a spatula, trowel, notched trowel, (or with hands protected by gloves).

When applying as a repair mortar use some formwork.

When using for bonding metal profiles onto vertical surfaces, support and press uniformly using props for at least 12 hours, depending on the thickness applied (not more than 5 mm) and the room temperature.

Once hardened check the adhesion by tapping with a hammer.

Cleaning of Tools

Clean all tools and application equipment with Sika® Colma Cleaner immediately after use. Hardener / cured material can only be mechanically removed.

Potlife

Potlife (200 g) (according to EN ISO 9514)

+10℃	+23℃	+30℃
~ 180 minutes	~ 60 minutes	~ 40 minutes

The potlife begins when the resin and hardener are mixed. It is shorter at high temperatures and longer at low temperatures. The greater the quantity mixed, the shorter the potlife. To obtain longer workability at high temperatures, the mixed adhesive may be divided into portions. Another method is to chill parts A+B and C before mixing them (not below +5℃).

Notes

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.

Protective Measures

To avoid rare allergic reactions, use of protective gloves. Changes soiled work clothes and wash hands before breaks and after finishing work. When uncured, Sikadur®-41 CF Normal parts A+B, are water-pollutants and must not be discharge into drains, waterways or the ground.

Local regulation as well as health and safety advice on packaging labels must be observed.

Important Notes

Uncured / unmixed material must be removed according to local regulations. Fully cured material can be disposed of as household waste under 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 material safety data sheet.

Legal Notes

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