



PRODUCT DATA SHEET

Sika® Armatec®-110 EpoCem

BONDING PRIMER AND REINFORCEMENT CORROSION PROTECTION

PRODUCT DESCRIPTION

Sika® Armatec®-110 EpoCem is a cementitious epoxy resin compensated 3-component, solvent-free, coating material with corrosion inhibitor, used as bonding primer and reinforcement corrosion protection.

USES

- Suitable in concrete repair as corrosion protection for reinforcement
- Suitable as a bonding primer on mortar, steel, and on placing fresh, plastic concrete to existing hardened concrete
- Protection to reinforcing steel in areas of thin concrete cover

CHARACTERISTICS / ADVANTAGES

- Contains EpoCem® technology - improved bonding agent
- Extended open times for repair mortars
- Excellent adhesion to concrete and steel
- Contains corrosion inhibitor
- Good resistance to water and chloride penetration
- High shear strength
- Long pot life
- Can be brushed on or applied using spray gun
- Can be used exterior on-grade
- Excellent bonding bridge for cement or epoxy based repair mortars
- High strength, unaffected by moisture when cured
- Non-flammable, solvent free

PRODUCT INFORMATION

Chemical Base	Portland cement, epoxy resin, selected aggregates and additives.				
Packaging	Unit	A	B	C	ABC
	3.5 gal (13.2 L)	47.6 oz (1.4 L)	122.1 oz (3.6 L)	46.82 lb (21.3 kg)	A + B in carton, C in bag
	1.65 gal (6.2 L)	22.7 oz (0.67 L)	57.6 oz (1.7 L)	5.5 lb (2.5 kg) (4 bags)	Factory-proportioned units in a pail
Appearance / Color	Component A		White liquid		
	Component B		Colorless liquid		
	Component C		Gray powder		
Shelf Life	12 months from date of production if stored properly in original, unopened and undamaged sealed packaging				
Storage Conditions	Store dry at 40–95 °F (4–35 °C)				

Product Data Sheet
 Sika® Armatec®-110 EpoCem
 March 2020, Version 01.02
 020302020050000003

Protect Component A and B from freezing. If frozen, discard.
Protect Component C from moisture. If damp, discard.

TECHNICAL INFORMATION

Compressive Strength	3 days	4,500 psi (31.0 MPa)	(ASTM C-109)
	7 days	6,500 psi (44.8 MPa)	73 °F (23 °C)
	28 days	8,500 psi (58.6 MPa)	50 % R.H.
Flexural Strength	28 days	1,250 psi (8.6 MPa)	(ASTM C-348) 73 °F (23 °C) 50 % R.H.
Splitting Tensile Strength	28 days	600 psi (4.1 MPa)	(ASTM C-496) 73 °F (23 °C) 50 % R.H.
Tensile Adhesion Strength	Bond of steel reinforcement on concrete		
	Sika® Armatec® 110	625 psi (4.3 MPa)	(ASTM C-1583)
	EpoCem coated		73 °F (23 °C)
	Epoxy coated	508 psi (3.5 MPa)	50 % R.H.
	Plain reinforcement	573 psi (4.0 MPa)	
Slant Shear Strength	Bonding agent properties (14 d. moist cure, plastic to hardened concrete)		
	Wet on wet	2,800 psi (19.3 MPa)	(ASTM C-882)
	24 hr. open time	2,600 psi (17.9 MPa)	73 °F (23 °C) 50 % R.H.
Permeability to Water Vapor	Control	7.32 x 10 ⁻¹⁰ ft/sec	
	145 psi (10 bar)	8.92 x 10 ⁻¹⁵ ft/sec	
Diffusion Resistance to Water Vapor	μ H ₂ O ~100		
Permeability to CO₂	μ CO ₂ ~14,000		
Corrosion Test	Time-to-Corrosion Study		
	▪ Sika® Armatec®-110 EpoCem more than tripled the time to corrosion		
	▪ Reduced corrosion rate by over 40 %		

APPLICATION INFORMATION

Fresh Mortar Density	A+B+C ~125 lb/ft ³ (~2.0 kg/l)		
Coverage	Bonding agent	80 ft ² /gal (7.4 m ² /l)	
	Corrosion Protection	40 ft ² /gal (3.7 m ² /l)	
(Coverage figures do not include allowance for surface profile and porosity or material waste)			
Layer Thickness		Min. thickness of 1 coat	Coat
	Bonding agent	20 mils	1
	Corrosion Protection	20 mils	2
Product Temperature	65°-75°F (18°-24°C)		
Ambient Air Temperature	40-95 °F (5-35 °C)		
Substrate Temperature	40-95 °F (5-35 °C)		
Pot Life	~ 90 minutes		
Waiting / Recoat Times	Sika repair mortars and non-fast setting concrete can be applied on Sika® Armatec®-110 EpoCem within a maximum time of:		

Product Data Sheet
Sika® Armatec®-110 EpoCem
March 2020, Version 01.02
020302020050000003

BUILDING TRUST



Temperature	Maximum Waiting Time
80°- 95 °F (26°- 35 °C)	6 hours
65°-79 °F (18°- 26 °C)	12 hours
50°- 64° F (10°- 17° C)	16 hours
40°- 49° F (4°- 9° C)	wet-on-wet

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Concrete

- Free from dust, loose material, surface contamination and materials which reduce bond or prevent suction or wetting by repair materials.
- Delaminated, weak, damaged and deteriorated concrete and where necessary sound concrete shall be removed by suitable means.
- Substrate must be Saturated Surface Dry (SSD) with no standing water.

Steel reinforcement

- Rust, scale, mortar, concrete, dust and other loose and deleterious material which reduces bond or contributes to corrosion shall be removed by blast cleaning or other means of mechanical abrasion and reinforcement.
- Should be fully exposed and have all corrosion removed.

MIXING

- Sika® Armatec®-110 EpoCem can be mixed with a low-speed (< 250 rpm) electric drill mixer.
- Shake components A and B thoroughly before opening.
- Pour liquid components A and B into a suitable mixing vessel and mix for 30 seconds.
- While still mixing components A and B slowly add powder component C.
- Mix the three components together for a minimum 3 minutes until blend is uniform and free of lumps, minimizing addition of air.
- Mix only the quantity that you can be applied within the pot life.
- DO NOT ADD WATER.

APPLICATION

As reinforcement corrosion protection

- Apply by stiff-bristle brush or spray at 80 ft² /gal.
- Take special care to properly coat the underside of the totally exposed steel.
- Allow coating to dry 2-3 hours at 73 °F, then apply a second coat at the same coverage.
- Allow to dry again before the repair mortar or concrete is applied.
- Pour or place repair within 7 days

As a bonding primer

- Apply using a stiff-bristle brush or broom. To achieve good bond, Sika® Armatec®-110 EpoCem must be applied well into the substrate, filling all pores and ensure complete coverage of all surface irregularities (minimum layer thickness 1/64" (0.5 mm).
- Spray apply with Goldblatt Pattern Pistol or equal equipment.
- Apply the freshly mixed patching mortar or concrete wet on wet, or up to the maximum recommended open time, onto the bonding slurry.

CURING TREATMENT

Sika® Armatec®-110 EpoCem must be protected against contamination and rain until application of the repair mortar.

CLEANING OF TOOLS

Clean all tools and application equipment with water immediately after use. Hardened material can only be mechanically removed.

LIMITATIONS

- Avoid application in direct sun and/or strong wind and/or rain.
- Do not add water.
- Not a vapor barrier.
- Apply only to sound, prepared substrates.
- Not recommended for use with expansive grouts and SikaQuicks
- Use of semi-dry mortars onto Sika® Armatec®-110 EpoCem must be applied "wet on wet"
- When used in overhead applications with hand placed patching mortars, use "wet on wet" for maximum mortar built thickness.
- Substrate profile as specified by the overlay or repair material is still required.
- As with all cement based materials, avoid contact with aluminum to prevent adverse chemical reaction and possible product failure. Insulate potential areas of contact by coating aluminum bars, rails, posts etc. with an appropriate epoxy such as Sikadur® Hi-Mod 32.

Product Data Sheet
Sika® Armatec®-110 EpoCem
March 2020, Version 01.02
020302020050000003



BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

OTHER RESTRICTIONS

See Legal Disclaimer.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

DIRECTIVE 2004/42/CE - LIMITATION OF EMISSIONS OF VOC

A+B+C combined 50 g/l

LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates (“SIKA”), the user must always read and follow the warnings and instructions on the product’s most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA’s Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product’s shelf life. User determines suitability of product for intended use and assumes all risks. User’s and/or buyer’s sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling 1-800-933-7452.

Sika Corporation
 201 Polito Avenue
 Lyndhurst, NJ 07071
 Phone: +1-800-933-7452
 Fax: +1-201-933-6225
usa.sika.com

Sika Mexicana S.A. de C.V.
 Carretera Libre Celaya Km. 8.5
 Fracc. Industrial Balvanera
 Corregidora, Queretaro
 C.P. 76920
 Phone: 52 442 2385800
 Fax: 52 442 2250537



Product Data Sheet
 Sika® Armatex®-110 EpoCem
 March 2020, Version 01.02
 020302020050000003

SikaArmatex-110EpoCem-en-US-(03-2020)-1-2.pdf

