

# Keyfix E

Epoxy resin cartridge system for anchoring



## DESCRIPTION

Keyfix E is a two component high strength pure epoxy resin anchoring grout pre-packed in dual cartridge system with fast curing rate.

Keyfix E is formulated for permanent installation of steel reinforcement bars and threaded rods into concrete substrates in structural applications.

## APPLICATIONS

Keyfix E is ideally designed for use in the following applications:

- » Permanent installation of reinforcement starter bars and dowel bars.
- » Permanent installation of hand rails, safety fence, wall ties, railway tracks and ground anchors.

## ADVANTAGES

- » Exceptional rapid strength development.
- » Resistant to dynamic loading.
- » Exceptional high compressive.
- » Extremely dense.
- » Exceptional bond to concrete and steel surfaces.
- » Suitable for dry and damp concrete holes.
- » Good chemical resistance.
- » High ultimate and early strengths.
- » Non-sag consistency suitable for overhead applications.

## STANDARDS

- » Keyfix E evaluated in accordance with the EOTA TR023 "Assessment of post-installed rebars connections".
- » Keyfix E when tested at normal temperature complies with the requirements of ASTM C881, Type I, II\*, IV and V\*, Grade 3, Class C.

\*Except for gel time.

## METHOD OF USE

### SUBSTRATE PREPARATION

Substrate should be sound, clean and free from grease or any contamination. Bars should be free from any loose rust deposits. Holes can be drilled using a hammer drill to produce a rough surface or by coring to produce a smooth surface.

## TECHNICAL PROPERTIES:

|                                                           |                                           |
|-----------------------------------------------------------|-------------------------------------------|
| Colour:                                                   | Red                                       |
| Bond strength:<br>ASTM C882-99                            | ≥ 10 MPa @ 2 days<br>≥ 13.5 MPa @ 14 days |
| Compressive yield strength:<br>ASTM D695-02a              | ≥ 70 MPa @ 7 days                         |
| Linear coefficient of shrinkage on cure:<br>ASTM D2566-86 | ≈ 0.005 @ 7 days                          |
| Compressive modulus:<br>ASTM D695                         | ≥ 1400 MPa @ 7 days                       |
| Elongation at break:<br>ASTM D638-03                      | > 1.5% @ 7 days                           |
| Water absorption:<br>ASTM D570-98                         | < 1%                                      |

Keyfix E bond strength will be the same in both cases. Deformed or ribbed bars will give a higher performance than smooth or other bar types. After drilling, holes should be brushed and blown out twice, to remove all drilling debris.

## APPLICATION

- » Unscrew the protective cap, remove the insert plug and attach the static mixing nozzle.
- » Insert the cartridge into the cartridge gun and dispense sufficient material until an even colour is achieved.
- » Usually 10 ml of extruded material should be adequate.
- » Insert the nozzle into the base of the hole, apply pressure to the gun and slowly withdraw the nozzle as the hole fills.
- » Normally, it is enough to fill the hole approximately two-third full.
- » Insert the stud/steel bar into the hole with a twisting action, ensuring that is fully embedded.
- » Allow the resin to cure fully before loading.

*When filling holes overhead or in porous block work, the use of plastic sleeves is recommended in order to hold the reinforcing bar in place and ensure proper embedded length.*

Partly used cartridge are reusable, Remove the static mixer and surplus base and catalyst components from the cartridge nozzle, insert the plug and screw on the protective cap.

## Don Construction Chemicals India Private Limited

Kaveripettai, Thiruvallur Dist., Chennai, Tamil Nadu

RIICO Industrial Area, Manda Chomu, Jaipur

India

[info.india@dcp-int.com](mailto:info.india@dcp-int.com); [marketing.india@dcp-int.com](mailto:marketing.india@dcp-int.com)

[www.dcp-int.com](http://www.dcp-int.com)

## WORKING AND CURING TIMES

| Resin Cartridge Temperature | Base Material Temperature | Working Time | Curing time |
|-----------------------------|---------------------------|--------------|-------------|
| 35 to 40°C                  | 35 to 40°C                | 8 min        | 4 hr        |
| 25 to 30°C                  | 25 to 30°C                | 13 min       | 10 hr       |
| 20 to 25°C                  | 20 to 25°C                | 25 min       | 12 hr       |
| 10 to 15°C                  | 10 to 15°C                | 100 min      | 24 hr       |
| 10 to 15°C                  | 5 to 10°C                 | 120 min      | 45 hr       |

*Always ensure that the cartridge temperature is > 10°C prior to using it .*

## CLEANING

All tools should be cleaned immediately after finishing by DCP Solvent. Hardened materials can be cleaned mechanically.

## ESTIMATING

The required quantity of Keyfix E depends on the hole diameter and depth. Normally, it is enough to fill the hole two-thirds full. The estimated volume of Keyfix E can be calculated using the following equation:

$$\text{Volume (ml)} = (\pi/6000) \cdot \Phi_n^2 \cdot H_D$$

Where:

$\Phi_n$ : Hole diameter (mm).

$H_D$ : Hole depth in (mm).

**TABLE I**

| Bar diameter (mm) | Hole diameter (mm) | Embedded length (mm) | Bar area (mm <sup>2</sup> ) | Maximum pull out force (kN)* | Needed quantity of Keyfix E per hole (ml) |
|-------------------|--------------------|----------------------|-----------------------------|------------------------------|-------------------------------------------|
| 10                | 12                 | 110                  | 79                          | 36                           | 8.3                                       |
| 12                | 14                 | 130                  | 113                         | 51                           | 13.3                                      |
| 14                | 16                 | 150                  | 154                         | 69                           | 20.1                                      |
| 16                | 20                 | 180                  | 201                         | 94                           | 37.7                                      |
| 18                | 24                 | 200                  | 254                         | 117                          | 60.3                                      |
| 20                | 26                 | 230                  | 314                         | 150                          | 81.4                                      |
| 25                | 31                 | 280                  | 491                         | 228                          | 140.9                                     |
| 32                | 40                 | 360                  | 804                         | 376                          | 301.6                                     |

*\* Maximum pull-out force that yield a concrete splitting failure pattern.*

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# Keyfix E

## PACKAGING

Keyfix E is available in 400 ml or 380 ml twin cartridge system.

## STORAGE

Keyfix E has a shelf life of 12 months from the date of manufacture if stored in its original packaging at temperatures above 8°C and away from direct sunlight.

If crystallization has occurred due to low temperature storage conditions (typically below 5°C), condition the product at temperatures around 30°C for several days before application.

If these conditions are exceeded, DCP Technical Department should be contacted for advise.

## CAUTIONS

### HEALTH AND SAFETY

Keyfix E is irritant to eyes, skin and respiratory system. Wear suitable gloves and eye protection.

For further information refer to the Material Safety Data Sheet.

### FIRE

Keyfix E is nonflammable.  
DCP Solvent is flammable, do not use near a naked flame and do not smoke during use.

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*info.india@dcp-int.com; marketing.india@dcp-int.com*

*www.dcp-int.com*



# Keyfix E

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- » Sealants.
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- » Tile adhesives and grouts.
- » Building products.
- » Structural strengthening.

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*www.dcp-int.com*

**Note:**

We endeavour to ensure that any information, advice or recommendation we may give in product literature is accurate and correct. However, because we have no control over where and how products are applied, we cannot accept any liability arising from the use of the products.

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