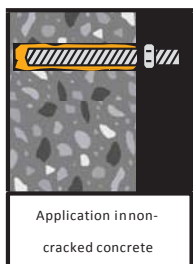
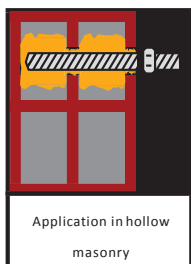


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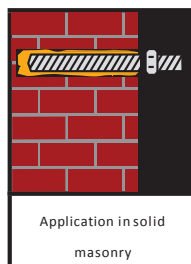
2K Reaction resin mortar based on Polyester styrene free



Application in non-cracked concrete



Application in hollow masonry



Application in solid masonry

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2K Reaction resin mortar based on Polyester styrene free

Product description



The PSF is a 2-component reaction resin mortar based on a styrene free polyester and will be delivered in a 2-C cartridge (ST - standard cartridge; PM - Pre-Mix cartridge; SF-foil tube cartridge) system. This product may be used in combination of a hand-, battery-, or pneumatic tool and a static mixer. It was designed as a cost-effective alternative for the anchoring of threaded rods and internal threaded rod sleeves for non-approved applications. By using a screen sleeve, an easy and save application in hollow bricks is guaranteed. The PSF product is characterised by good applications with an ambient temperature up to 80°C.

Properties and benefits



- Application in uncracked concrete, solid brick and hollow brick with commercial threaded rods
- overhead application
- Suitable for attachment points close to the edge, since anchoring is free of expansion forces
- styrene free
- reduced chemical resistance
- high bending- and pressure strength
- Cartridge can be reused up to the end of the shelf life by replacing the static mixer or resealing cartridge with the screw cap
- Mechanical properties acc. to EN 196 Part1
 - + Density: 1,74 kg/dm³
 - + Compressive strength: 75 N/mm²
 - + Bending strength: 30 N/mm²
 - + Dynamic modulus of elasticity: 4000 N/mm²



Applications samples

Suitable for the fixation of facades, roofs, wood construction, metal construction; metal profiles, console, railing, sanitary devices, cable trays, piping, etc.



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Applications and intended use

- **Underground:**
non-cracked concrete, light-concrete, porous-concrete, solid masonry, hollow brick, natural stone (Attention! natural stone, can discolour; shall be checked in advance); hammer drilled holes
- **Anchor elements:**
Threaded rods (zinc plated or hot dip, stainless steel and high corrosion resistance steel), reinforcing bars, internal threaded rods, profiled rod, steel section with undercuts (e.g. perforated section)
- **Temperature range:**
5°C up to +35°C installation temperature
cartridge temperature min. +5°C; optimal +20°C
-40°C to +80°C base material temperature after full curing

Handling and storage

- **Storage:**
store in a cold and dark place, storage temperature: from +5°C up to +25 °C
- **Shelf life:**
18 months for standard cartridge (ST); 12 months for foil tube cartridge (SF)

Reactivity

Temperature of base material	Gelling- and working time	Full curing time in dry base material	Full curing time in wet base material
+5°C	25 Min.	120 Min	240 Min.
+10°C	15 Min.	80 Min	160 Min
+20°C	6 Min	45 Min.	90 Min.
+30°C	4 Min.	25 Min.	50 Min.
+35°C	2 Min	20 Min	40 Min.

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2K Reaction resin mortar based on Polyester styrene free

Usage instructions - concrete

	<p>1. Drill with hammer drill mode a hole into the base material to the size and embedment depth required by the selected anchor.</p>
	<p>2a. Standing water must be removed before cleaning. Starting from the bottom or back of the bore hole, blow the hole clean with compressed air or a hand pump a minimum of four times. If the bore hole ground is not reached an extension shall be used. The hand-pump can be used for anchor sizes up to bore hole diameter 20 mm.</p>
<p>or</p>	<p>For bore holes larger than 20mm or deeper than 240mm, compressed air (min. 6 bar) must be used.</p>
	<p>2b. Check brush diameter acc. to table 5 and attach the brush to a drilling machine or a battery screwdriver. Brush the hole with an appropriate sized wire brush of four times. If the bore hole ground is not reached with the brush, a brush extension shall be used.</p>
	<p>2c. Finally blow the hole clean again with compressed air or a hand pump a minimum of four times. If the bore hole ground is not reached an extension shall be used. The hand-pump can be used for anchor sizes up to bore hole diameter 20 mm. For bore holes larger than 20mm or deeper than 240mm, compressed air (min. 6 bar) must be used.</p>
<p>or</p>	<p>For bore holes larger than 20mm or deeper than 240mm, compressed air (min. 6 bar) must be used.</p>
	<p>3. Attach a supplied static-mixing nozzle to the cartridge and load the cartridge into the correct dispensing tool. For every working interruption longer than the recommended working time as well as for new cartridges, a new static-mixer shall be used.</p>
	<p>4. Prior to inserting the anchor rod into the mortar filled bore hole, the position of the embedment depth shall be marked on the anchor rods.</p>

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2K Reaction resin mortar based on Polyester styrene free

Usage instructions - concrete

	<p>5. Prior to dispensing into the anchor hole, squeeze out separately a minimum of three full strokes and discard non-uniformly mixed adhesive components until the mortar shows a consistent grey colour.</p>
	<p>6. Starting from the bottom or back of the cleaned anchor hole fill the hole up to approximately two-thirds with adhesive. Slowly withdraw the static mixing nozzle as the hole fills to avoid creating air pockets. Observe the gel-/ working times given.</p>
	<p>7. Push the threaded rod or reinforcing bar into the anchor hole while turning slightly to ensure positive distribution of the adhesive until the embedment depth is reached. The anchor should be free of dirt, grease, oil or other foreign material.</p>
	<p>8. Be sure that the anchor is fully seated at the bottom of the hole and that excess mortar is visible at the top of the hole. If these requirements are not maintained, the application has to be renewed.</p>
	<p>9. Allow the adhesive to cure to the specified time prior to applying any load or torque. Do not move or load the anchor until it is fully cured.</p>
	<p>10. After full curing, the add-on part can be installed with the max. torque by using a calibrated torque wrench.</p>

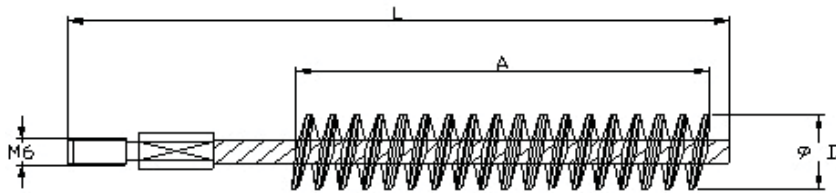
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Cleaning of the drill hole - concrete



Brush:

Ø 0,20 mm (A2) Steel wire
 Brush length: 80 mm
 M6 thread for drilling machine connection



Blower

Threaded rod	Bore hole-Ø	Brush-Ø	min. brush-Ø	Brush length
(mm)	(mm)	(mm)	b _{,min} (mm)	L (mm)
M 8	10,	12,	0,	70
M 10	12,	4,0	12,	70
M 1	14,0	16,0	14,	0
M 16	18,0	0,0	18,5	30
M 20	24,0	26,0	24,	30

Setting parameter - concrete

Anchor size				M8	M10	M1	M16	M20
Edge distance	1,0 x h _{ef}		mm	0	90	1	25	170
Min. edge distance	5,0 x d	mi	mm	40	0	60	0	
Axial distance	2,0 x h _{ef}		mm	160	18	22	250	340
Min. axial distance	5,0 x d	mi	mm	40	0	60	0	
Embedment depth		ef	mm	0	90	1	25	70
Min. part thickness		mi	mm	ef + 30 m			ef + 2d	
Anchor diameter			mm			1	16	
Drill diameter			mm	1	2	14	1	24
Installation torque		T _{nst}	Nm	1	2	40	60	12

TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Performance data - concrete

TENSION LOADS - Design method A acc. to ETAG 001 Annex C, characteristic values for tension loading

Anchor size				M8	M10	M12	M16	M20
Steel failure								
Characteristic tension resistance, Steel, zinc plated or hot dip, property class 5.8		$N_{Rk,s}$	[kN]	18	29	42	78	122
Characteristic tension resistance, Steel, zinc plated or hot dip, property class 8.8		$N_{Rk,s}$	[kN]	29	46	67	125	196
Partial safety factor		$\gamma_{Ms,N}$		1,50				
Characteristic tension resistance, Stainless steel A4 and HCR		$N_{Rk,s}$	[kN]	26	41	59	110	172
Partial safety factor		$\gamma_{Ms,N}$		1,87				
Pullout and concrete cone failure ¹⁾								
Characteristic bond resistance in concrete C20/25								
50°C/80°C ²⁾	uncracked concrete	$N_{Rk,p} = N_{Rk,c}^0$	[kN]	12	18	25	28	47
Partial safety factor (dry and wet)		$\gamma_{Mp} = \gamma_{Mc}$		1,8				
Embedment depth		h_{ef}	[mm]	80	90	110	125	170
Edge distance		$c_{cr,N}$	[mm]	80	90	110	125	170
Axial distance		$s_{cr,N}$	[mm]	$2 \times c_{cr,N}$				
Increasing factors for non-concrete concrete Ψ_c				$(f_{ck}^{0,30})/2,63$				
Splitting failure								
Edge distance		$c_{cr,sp}$	[mm]	$c_{cr,N} \bullet 2 h_{ef} (2,5 - h/h_{ef}) \bullet 2,4 h_{ef}$				
Axial distance		$s_{cr,sp}$	[mm]	$2 \times c_{cr,sp}$				
Partial safety factor (dry and wet)		γ_{Msp}		1,8				

The data in this table are intended to use together with the design provisions of ETAG 001 Annex C

1) shall be determined acc. this table or acc. to 5.2.2.4, Annex C of ETAG 001. The smaller value is decisive.

2) short term temperature / Long term temperature . Long term concrete temperatures are roughly constant over significant periods of time. Short term elevated temperatures are those that occur over brief intervals, e.g. as a result of diurnal cycling.

TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Performance data - concrete

SHEAR LOADS - Design method A acc. to ETAG 001 Annex C, characteristic values for shear loading

Anchor size			M8	M10	M12	M16	M20
Steel failure without leverarm							
Characteristic shear resistance, Steel, zinc plated or hot dip, property class 5.8	$V_{Rk,s}$	[kN]	9	15	21	39	61
Characteristic shear resistance, Steel, zinc plated or hot dip, property class 8.8	$V_{Rk,s}$	[kN]	15	23	34	63	98
Partial safety factor	$\gamma_{Ms,V}$		1,25				
Characteristic shear resistance, Stainless steel A4 and HCR	$V_{Rk,s}$	[kN]	13	20	30	55	86
Partial safety factor	$\gamma_{Ms,V}$		1,56				
Steel failure with leverarm							
Characteristic bending moment, Steel, zinc plated or hot dip, property class 5.8	$M^0_{Rk,s}$	[Nm]	19	37	65	166	324
Characteristic bending moment, Steel, zinc plated or hot dip, property class 8.8	$M^0_{Rk,s}$	[kN]	30	60	105	266	519
Partial safety factor	$\gamma_{Ms,V}$		1,25				
Characteristic bending moment, Stainless steel A4 and HCR	$M^0_{Rk,s}$	[kN]	26	52	92	232	454
Partial safety factor	$\gamma_{Ms,V}$		1,56				
Concrete Pryout failure							
Factor k			2,0				
Partial safety factor	γ_{Mcp}		1,5				
Concrete edge failure							
Effective length of anchor in shear loading	l_f	[mm]	80	90	110	125	170
Outside diameter of anchor	d_{nom}	[mm]	10	12	14	18	24
Partial safety factor	γ_{Mc}		1,5				

The data in this table is intended to used together with the design provisions of ETAG 001 Annex C.

TILCA TIM SP - Polyester styrene free



TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Recommended loads - concrete

The recommended loads are only valid for single anchor for a roughly design, if the following conditions are valid:

dry or wet bore hole, uncracked concrete C20/25, steel 5.8

$c \geq c_{cr,N}$

$s \geq s_{cr,N}$

$h \geq 2 \times h_{ef}$

If the conditions are not fulfilled the loads must be calculated acc. to ETAG 001 Annex C.

The safety factors are already included in the recommended loads.

Anchor size			M8	M10	M12	M16	M20
Embedment depth	h_{ef}	[mm]	80	90	110	125	170
Edge distance	$c_{cr,N}$	[mm]	1,5 x h_{ef}				
Axial distance	$s_{cr,N}$	[mm]	3,0 x h_{ef}				
Recommended tension load 50°C/80°C ²⁾	N_{Rec}	[kN]	4,7	7,1	10,0	11,2	18,8
Recommended shear load without lever arm for Steel property class 5.8 ¹⁾	V_{Rec}	[kN]	5,1	8,6	12,0	22,3	34,9

1) Shear load with lever arm acc. Annex C of ETAG 001.

2) short term temperature / Long term temperature. Long term concrete temperatures are roughly constant over significant periods of time. Short term elevated temperatures are those that occur over brief intervals, e.g. as a result of diurnal cycling.

TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Usage instructions - hollow bricks

	<p>1. Drill without hammer drill mode a hole into the base material to the size and embedment depth required by the selected anchor.</p>
	<p>2. In case of a water filled bore hole, the water has to be removed from the hole (e.g. by compressed air or vacuum cleaner). Starting from the bottom or back of the hole, blow the hole clean with a hand pump a minimum of two times. Then brush the hole with nylon brush a minimum of two times. Finally clean the hole again with a hand pump a minimum of two times.</p>
	<p>3. Attach a supplied static-mixing nozzle to the cartridge and load the cartridge into the correct dispensing tool. After every working interruption longer than the recommended working time as well as for new cartridges, a new static-mixer shall be used.</p>
	<p>4. Prior to inserting the anchor rod into the filled bore hole, the position of the embedment depth shall be marked on the anchor rods.</p>
	<p>5. Prior to dispensing the mortar into the bore hole, squeeze out separately a minimum of three full strokes and discard non-uniformly mixed adhesive components until the mortar shows a consistent grey colour.</p>
	<p>6. Insert the perforated sleeve into the bore hole. Make sure that the sleeve fits well into the hole. Never cut the sleeve! Only use sleeves that have the right length.</p>
	<p>7. Starting from the back fill the sleeve completely with adhesive. Observe the gel-/ working times.</p>
	<p>8. Push the threaded rod or reinforcement bar into the sleeve while turning it slightly to ensure a distribution of the adhesive until the back of the sleeve is reached. The anchor should be free of dirt, grease, oil or other foreign material.</p>

TILCA TIM SP - Polyester styrene free

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2K Reaction resin mortar based on Polyester styrene free

	<p>9. Allow the adhesive to cure to the specified time prior to applying any load to torque. Do not move or load the anchor until it is fully cured.</p>
	<p>10. After full curing, the add-on part can be installed with the max. torque by using a calibrated torque wrench.</p>

TILCA TIM SP - Polyester styrene free

Cleaning - masonry



- Brush:
20 mm Nylon; Length: 80 mm



- Blower

TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Performance data - masonry

Stone	Strength class	Recommended loads		Standard sleeves				Wing sleeve	
				M6	M8	M10	M12	M8	M10
Hollow brick	Hlz 4	F_{rec}	[kN]	0,3	0,3	0,3	0,3	0,3	0,3
	Hlz 6			0,4	0,4	0,4	0,4	0,4	0,4
	Hlz 12			0,7	0,8	0,8	0,8	0,8	0,8
Sand -limehol- low brick	KSL 4	F_{rec}	[kN]	0,3	0,3	0,3	0,3	0,3	0,3
	KSL 6			0,4	0,4	0,4	0,4	0,4	0,4
	KSL 12			0,7	0,8	0,8	0,8	0,8	0,8
Sand -lime solid brick ¹⁾	KS 12	F_{rec}	[kN]	0,5	1,7	1,7	1,7	1,7	1,7
Solid brick ¹⁾	Mz 12	F_{rec}	[kN]	0,5	1,7	1,7	1,7	1,7	1,7
Light concrete hollow brick	Hbl 2	F_{rec}	[kN]	0,3	0,3	0,3	0,3	-	-
	Hbl 4			0,5	0,6	0,6	0,6	-	-
Concrete hollow brick	Hbn 4	F_{rec}	[kN]	0,5	0,6	0,6	0,6	-	-

Installation parameters										
Axial distance pluggroup		$S_{cr,N Group}$	[mm]	Hlz, KSL, MZ, KS = 100 Hbl, Hbn = 200				100		
Min. axial distance pluggroup ²⁾		$S_{min Group}$	[mm]	Hlz, KSL, MZ, KS = 50 Hbl, Hbn = 200				50		
Axial distance between single plugs		$S_{cr,N Single}$	[mm]	250				250		
Edge distance		$C_{cr,N}$	[mm]	250				200 (250) ³⁾		
Min. edge distance ⁴⁾		C_{min}	[mm]	250				50 (60) ³⁾		
Embedment depth of rod	with sleeve	h_{ef}	[mm]	50	85	85	85	80	90	
	without sleeve	h_{ef}	[mm]	60	80	90	110	80	90	
Drilling depth	with sleeve	h_0	[mm]	55	90	90	90	105	105	
	without sleeve	h_0	[mm]	65	85	95	115	85	95	
Minimum part thickness		h_{min}	[mm]	110				125	110	
Drill diameter		d_o	[mm]	11	16	16	16	14	16	
Hole diameter in fixed element		d_f	[mm]	7	9	12	14	9	12	
Installation torque		T_{inst}	[Nm]	3	8	8	8	2	2	

1) Anchoring in masonry of solid lime-sand bricks (KS) and masonry bricks (Mz) does not require perforated sleeve.

2) It is permissible to go below the axial spacing to the minimum value for anchor pairs and groups of four, if the permissible loads are reduced. The maximum loads must not be exceeded.

3) Value in brackets applies to solid bricks (Mz and KS).

4) Applies to masonry with top load or proof of tilt. Does not apply to shear loads directed towards a free edge.



TECHNICAL DATA SHEET

TILCA TIM SP

2K Reaction resin mortar based on Polyester styrene free

Performance data - masonry

Reduced permissible loads with reduced axial spacing per anchor in anchor groups

$$s_{cr,N \text{ Group}} \geq s > s_{min}$$

Anchor pairs:

$$red F = \chi s \cdot F_{rec}$$

$$\chi s = \frac{1}{2} (1 + s/s_{cr,N \text{ Group}}) \leq 1,0$$

Groups of four:

$$red F = \chi s_1 \cdot \chi s_2 \cdot F_{rec}$$

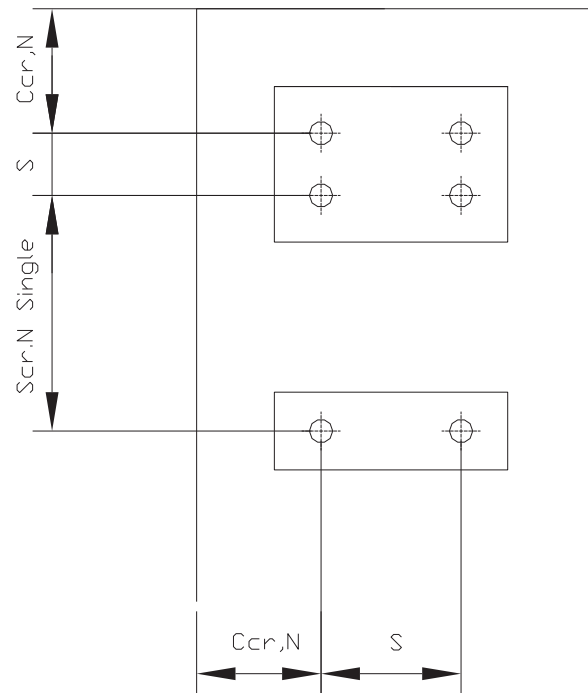
$$\chi s_{1,2} = \frac{1}{2} (1 + s_{1,2}/s_{cr,N \text{ Group}}) \leq 1,0$$

F_{rec} = Permissible load per anchor

red F = Reduced load per anchor

$s_{cr,N \text{ Group}}$ = Axial spacing

s = Reduced axial spacing



Permissible load in [kN] for each single brick				
Brick format		<4 DF	4 bis 10 DF	≥ 10DF
Without top load	max F [kN]	1,0	1,4	2,0
With top load	max F [kN]	1,4	1,7	2,5

TILCA TIM SP - Polyester styrene free