



SikaBond® T2

Elastic Bonding Adhesive

Technical Data Sheet

DESCRIPTION

SikaBond T2 is a high performance single part gun grade, elastic polyurethane resin adhesive.

APPLICATIONS

SikaBond T2 is used for permanent elastic bonding of elements with differing coefficient of expansion and is particularly suited to timber flooring

SikaBond T2 will bond to most building substrates including concrete, ceramic tiles, wood, thermoplastic, non-ferrous metal, normally without the need for priming.

SikaBond T2 has very high grab characteristics and thus provides instant grip of medium weight elements such as plastisol coated panels, brick slips or timber cladding. Heavier items may need temporary support while the adhesive cures.

For direct application of timber flooring to substrates, **SikaBond T2** (Liquid Battens) is suitable for use with:

- * Solid wood planks or blocks.
- * Structured or engineered timbers.
- * Laminated sheets or panels, plywood, HDF and chipboard.
- * Pre-formed nosing and skirtings.
- * Thresholds, step nosings, sills to openings.

MAIN CHARACTERISTICS AND ADVANTAGES

- * No need to raise floor levels with timber battens.
- * Long open time up to 1 hour.
- * Absorbs sound vibration up to 23db.
- * Absorbs movement associated with seasonal climatic change.
- * Very fast cure rate (4 mm per day).
- * Excellent adhesion to all mineral based building materials.
- * Permanently elastic.
- * Allows equalised stress transfer due to permanent elasticity.

HOW TO USE

Preparing the surface

Substrate to be bonded must be clean, dry, sound and free of dust, oil, grease or other contaminants.

Priming

Excellent adhesion, without primer to concrete, cement screeds, tiles, timber and all mineral substrates.

On inferior quality cement screeds or poorly compacted concrete, apply **SikaBond Primer 2**, observing a minimum waiting time of 30 minutes to a maximum of five hours, before the application of **SikaBond T2** adhesive.

For Anhydrite Screeds, the surface should be ground to remove surface laitance, vacuumed to extract dust residue and primed with **Sikafloor® 156 Primer**. (See separate technical data sheet).

On Mastic Asphalt substrates a trial is advisable. Prime with two coats of **Sikafloor 156 Primer**. Final coat blinded with kiln dried quartz sand (0.1-0.3 mm).

Allow primer to dry before applying **SikaBond T2**.

Installation

- * Break inner seal of extrusion end of cartridge. Fix nozzle and cut as figure 1. Install cartridge into a conventional or air/battery powered sealant gun.

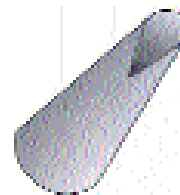
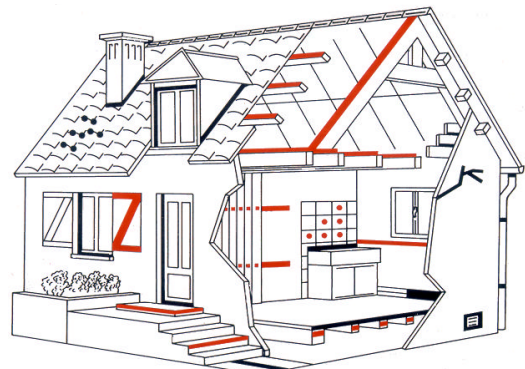


Figure 1

- * Apply a triangular section bead of **SikaBond T2** adhesive, ensuring air entrapment is avoided. With the exception of timber flooring, it does not matter whether the adhesive is applied to the element to be bonded or the intended substrate.



APPLICATION WITH TIMBER FLOORS

- * It is paramount that the timber manufacturers recommendations in respect of moisture content of the substrate are adhered to.
- * Gun apply triangular beads of **SikaBond T2** adhesive at approximately 250 mm centres. The minimum profile of the extruded **SikaBond T2** should be as Figure 2.

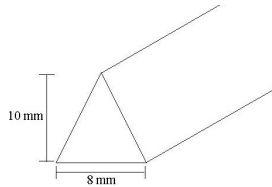


Figure 2

- * Within a maximum of 1 hour after application, place the element to be bonded into the adhesive and apply firm pressure to line and level.
- * Check the final bonding thickness and ensure that a minimum of 1 mm of **SikaBond T2** is maintained between element and substrate.

READY FOR SERVICE

An effective bond is achieved in a few hours. Final cure is achieved in approximately 12 hours depending upon temperature and humidity.

CLEANING

Use **Sika® Thinner C** to remove uncured sealant from tools. Hardened material can only be removed mechanically. **SikaBond T2** whilst still uncured can be removed with **Sika Hand Cleanser** or **Sikawipes**.

PACKAGING, STORAGE AND SHELF LIFE

SikaBond T2 is supplied in 310 ml cartridges in boxes of 12.

Colour: White.

Store **SikaBond T2** in a dry and cool location at a temperature between +5°C and +25°C. Protected from frost. If stored as indicated, **SikaBond T2** has a shelf life of 9 months in original unopened containers.

CONSUMPTION

One cartridge of **SikaBond T2** yields the following amounts:

- * Bonding in beads approximately 100 x 3 cm³ beads.
- * Bonding in strips with a triangular section @ 250 mm centres, one 310 cc cartridge will adhere approximately 1m² of timber flooring, depending upon surface profile.

IMPORTANT CONSIDERATIONS

- * With exposed substrates, ensure there is no moisture condensation on the surfaces to be bonded.
- * Full surface bonding between two non-porous materials is not recommended due to a slower cure rate being achieved.
- * Do not bring **SikaBond T2** into direct contact with bitumen or asphalt without first carrying out adhesion trials (see notes on priming).



Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

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SikaBond® T52

Elastic Timber Flooring Adhesive

Technical Data Sheet

DESCRIPTION

A high performance, solvent free, one-part gun and trowel grade elastic timber flooring adhesive.

APPLICATIONS

Permanent elastic bonding for:

- * Solid or engineered strips
- * Parquet blocks
- * Structured planks and laminate floorings
- * **Sika® Acoubond** acoustic system

MAIN CHARACTERISTICS AND ADVANTAGES

- * Ready to use.
- * Solvent and moisture free.
- * Excellent adhesion even with problematic timber.
- * No raising of floor levels due to batten fixing.
- * Long open time up to 1 hour.
- * Dramatically reduces vertical sound transfer.
- * Absorbs sound vibration (up to 23db) when used in conjunction with **Sika Silent Layer Mat**.
- * Absorbs movement associated with seasonal climatic changes.
- * Allows equalised stress transfer due to permanent elasticity.
- * Can be used with underfloor heating system.
- * Gun or trowel applied.
- * Service temperature -40°C to +80°C.
- * No wastage.

HOW TO USE

Preparing the surface

Substrate to be bonded must be clean, dry, sound and free of dust, oil, grease or other contaminants.

Screeds, clay and stone surfaces may require mechanical preparation and vacuuming to produce a sound, firm, gripping surface.

Vinyl floor tiles should be sound fully bonded, cleaned and degreased.

Priming

Excellent adhesion, without primer to concrete, cement screeds, tiles, timber and all mineral substrates.

For Anhydrite Screeds, the surface should be ground to remove surface laitance, vacuumed to extract dust residue and primed with **Sikafloor® 156 Primer**. (See separate Technical Data Sheet).

On Mastic Asphalt substrates a trial is advisable. Prime with two coats of **Sikafloor 156 Primer**. Final coat blinded with kiln dried quartz sand (0.1-0.3 mm).

Allow primer to dry before applying **SikaBond T52**.

Installation

- * When using trowelable **SikaBond T52**, apply material directly out of the container and uniformly distribute onto the substrate.
- * Spread the adhesive using a Type 24 square notched trowel avoiding air entrapment.
- * Check the final bonding thickness, for example by means of spacers. Minimum thickness of **SikaBond T52** trowel grade, 1 mm.
- * Within a maximum of 60 minutes of application, press the timber elements into the **SikaBond T52** adhesive, press firmly ensuring the contact face is fully bonded. A minimum clearance of 10 mm from walls must be observed using wedges etc.
- * Fresh adhesive on unbonded or pre-finished surfaces of the timber must be removed immediately with a clean cloth and, if necessary, **Sika Thinner C**.
- * When using the **Sika Acoubond** system, lay the **Sika Silent Layer Mat** flat on substrate and apply the **SikaBond T52** gun grade between pre-cut slots.
- * When using **SikaBond T52** gun grade, install sausage into a bulk gun, fit nozzle and cut length to suit. A 'V' shape should be cut into nozzle to produce a triangular shaped extrusion bead approximately 8 mm (W) x 10 mm (H).

READY FOR SERVICE

Resistance to sanding foot traffic and loading is achieved after approximately 18 hours with **SikaBond T52** trowel grade and approximately 24 hours with **SikaBond T52** gun grade.

CLEANING

Use **Sika Thinner C** to remove uncured sealant from tools. **SikaBond T52** whilst still uncured can be removed with **Sika Hand Cleanser** or **Sikawipes**.

PACKAGING, STORAGE AND SHELF LIFE

SikaBond T52 is supplied in 13 kg metal pails (10.1 litres) and 600 ml sausages (20 per box).

Colours: Parquet brown.

Store **SikaBond T52** in a dry and cool location at a temperature between +10°C and +25°C. Protected from frost. If stored as indicated, **SikaBond T52** has a shelf life of 9 months in original unopened containers.

CONSUMPTION

Full Surface Bonding:

One 13 kg pail of **SikaBond T52** trowel grade applied at the:

- * Minimum coverage rate of 0.5-0.6 kg/m², onto an evenly prepared floor substrate, will cover approximately 21-25 m². Consumption will increase dependent upon surface profile.

Sika Acoubond system:

- * One 600cc sausage of **SikaBond T52** gun grade, when used within the pre-cut slots of **Sika Silent Layer Mat** covers approximately 1.5 m². Figures based on extruded triangular beads 8 mm (W) x 10 mm (H).
- * Adhesive density approximately 1.29 kg/ltr.

IMPORTANT CONSIDERATIONS

- * When full surface bonding between two non-porous materials is not recommended as curing rate is reduced then there is no contact between the adhesive and atmospheric or substrate moisture.
- * Do not bring **SikaBond T52** into direct contact with bitumen or asphalt. Mastic asphalt must be isolated with **Sikafloor 156** blinded with sand or a levelling compound.
- * All previous floor finishes should be checked for soundness and be fully bonded before applying **SikaBond T52**.
- * The laying instructions of the timber manufacturer/supplier must be adhered to at all times.
- * Special notice of substrate moisture content must be taken (see table for permissible screed moisture levels). If the moisture content is above recommended levels then further advice should be sought from timber manufacturers/suppliers.
- * When removing uncured **SikaBond T52** from pre-finished boards carry out a trial area on the timber flooring with **Sika Thinner C** to ensure staining or stripping of final floor finish is prevented.

Permissible screed moisture levels		
Cement Flooring	Anhydrite Flooring	Magnesia Flooring
≤ 2.5%	≤ 0.5%	3-12% depending on the proportion of organic components
Permissible screed moisture levels in the case of heating strips		
≤ 1.5%	≤ 0.5%	3-12% depending on the proportion of organic components

NB All figures are % by volume

Handling Precautions

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SikaLastomer®-TF

One Part Adhesive and Sealant Based on Butyl Rubber

Technical Data Sheet

DESCRIPTION

SikaLastomer-TF is a one part plastic adhesive and sealant based on butyl rubber.

USES

SikaLastomer-TF is suitable for fixing **Sikaplan® Membran** to bitumen based roofing and underground dampproofing systems.

ADVANTAGES

- * Excellent adhesion to wide variety of substrates including EPDM.
- * Easy, quick application.
- * Suitable for uneven substrates.
- * Solvent free.
- * Allows repositioning of **SikaPlan** rubber membranes upto 30 minutes.
- * Tolerant to uneven surfaces.

Technical Data (typical)

Colour:	Grey
Density:	18 kg/litre
Service temperatures: Range:	-40°C to +60°C
Application temperature:	+5°C min, +40°C max (Substrate and ambient)

All above values are approximate.



SURFACE PREPARATION

All surfaces must be sound, clean, dry and free from any surface contaminants.

All loose particles, paint, laitance and other poorly adhering materials should be removed with a rotary mechanical wire brush, grinding or grit blasting.

PRIMING

Priming is not normally required except on moist substrates. When using Sika Primer 3 on moist substrate, maximum substrate moisture content must not exceed 8% by wt. Allow primer to become touch dry before applying **SikaLastomer-TF**.

APPLICATION

Insert sausage into sealant gun and cut nozzle to a diameter of not less than 8 mm, and firmly extrude bead of adhesive. Spread **SikaLastomer-TF** by means of a spatula to approx 4 - 5 cm width @ 1mm thickness (dependant on substrate profile).

Place **SikaPlan** rubber membrane onto the **SikaLastomer-TF** and apply pressure along membrane using a plastic roller. Ensure excess extruded **SikaLastomer-TF** is tooled off by trowel.

IMPORTANT CONSIDERATIONS

- * **SikaLastomer-TF** should not be used for structural glazing.
- * Protect the finished joint from water for at least 1 hour.
- * In instances where the dead weight of the membrane is carried by **SikaLastomer-TF**, the connection must be additionally secured with an aluminium profile.

CLEANING

Clean tools immediately with **Sika Thinner C**.

PACKAGING

Refer to latest price list.

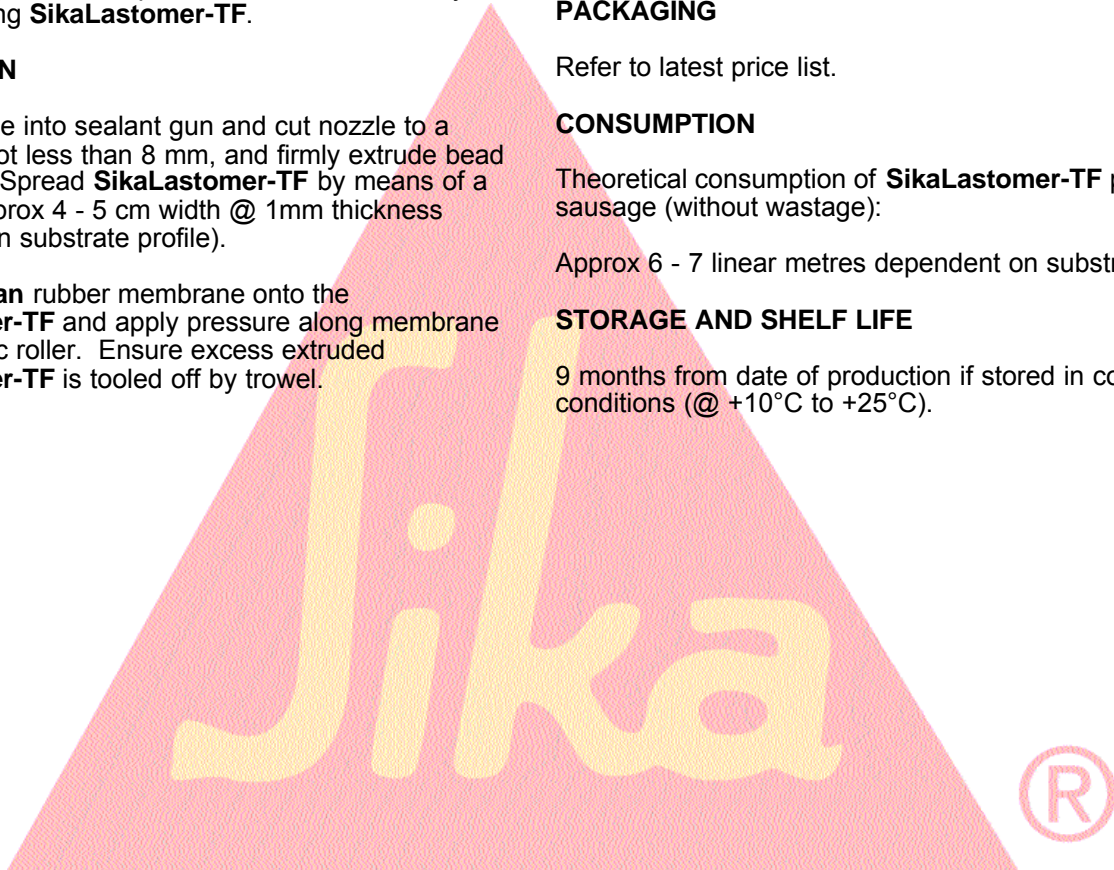
CONSUMPTION

Theoretical consumption of **SikaLastomer-TF** per 600cc sausage (without wastage):

Approx 6 - 7 linear metres dependent on substrate.

STORAGE AND SHELF LIFE

9 months from date of production if stored in cool, dry conditions (@ +10°C to +25°C).



Handling Precautions

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SikaBond®-TF plus

One Part Sag Resistant Polyurethane Adhesive

Technical Data Sheet

DESCRIPTION

SikaBond-TF plus is a one part permanently elastic adhesive/sealant based on polyurethane.

USES

SikaBond-TF plus is suitable for bonding **SikaPlan® Membran** on to:

- * Concrete.
- * Wood.
- * Aluminium including powder coated.
- * Most construction materials.
- * EPDM gaskets to substrates.

ADVANTAGES

- * Easy, quick application.
- * Solvent free.
- * No pre-treatment of membrane needed.
- * Suitable for uneven substrates.
- * Highly adaptable.
- * Waterproof.
- * Durable.
- * No additional mechanical fixing.
- * Allows repositioning of **SikaPlan** rubber membranes upto 30 minutes.

Technical Data (typical)

Colour:	Black
Density:	1.25 kg/litre
Service temperatures: Range:	-40°C to +90°C
Cure rate:	4 mm/day (+23°C / 50% RH)
Application temperature:	5°C min, 35°C max (Substrate and ambient)
Shore A hardness:	35 after 28 days (+23°C / 50% RH)
Tack free time:	1 to 1½ hours (+23°C / 50% RH)
Tensile strength at break:	1.8 N/mm ²
Peeling resistance:	1.0 N/mm ²
Elongation at break:	> 500%

All above values are approximate.

SURFACE PREPARATION

All surfaces must be sound, clean, dry and free from any surface contaminants.

All loose particles, paint, laitance and other poorly adhering materials should be removed with a rotary mechanical wire brush, grinding or grit blasting.

PRIMING

Priming is not normally required except on moist substrates. When using Sika Primer 3 on moist substrate, maximum substrate moisture content must not exceed 8% by wt. Allow primer to become touch dry before applying **SikaBond-TF plus**.

APPLICATION

Insert sausage into sealant gun and cut nozzle to a diameter of not less than 8 mm, and firmly extrude bead of adhesive. Spread **SikaBond-TF plus** by means of a spatula to approx 4 - 5 cm width @ 1mm thickness (dependant on substrate profile).

Place **SikaPlan** rubber membrane onto the **SikaBond-TF plus** and apply pressure along membrane using a plastic roller. Ensure excess extruded **SikaBond-TF plus** is tooled off by trowel.

IMPORTANT CONSIDERATIONS

- * **SikaBond-TF plus** should not be used for structural glazing.
- * Protect the finished joint from water for at least 1 hr.
- * Large elements may require additional holding or support during curing period.
- * Do not use **SikaBond-TF plus** in contact with materials containing bitumen or pitch.

CLEANING

Clean tools immediately with **Sika Thinner C**.

PACKAGING

Refer to latest price list.

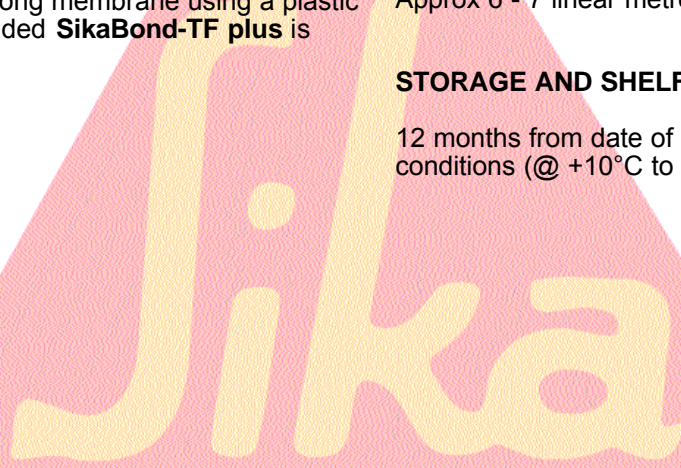
CONSUMPTION

Theoretical consumption of **SikaBond-TF plus** per 600cc sausage (without wastage):

Approx 6 - 7 linear metres dependant on substrate.

STORAGE AND SHELF LIFE

12 months from date of production if stored in cool, dry conditions (@ +10°C to +25°C).



Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

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SikaTack® -Panel

The mounting system for ventilated façade panels

Description The SikaTack-Panel System is an adhesive system for economic, concealed mounting of ventilated façade panels.

The system consists of the permanently-elastic adhesive SikaTack-Panel and SikaTack-Panel-fixing tape, adhesive on both sides, for attaching panels as well as the corresponding products for pre-treating the substrates. With the SikaTack-Panel-System, façade panels are invisibly attached to normal substructures.

Uses Concealed attachment of ventilated façade panels for the following areas:

- Residential and commercial buildings
- New buildings and renovations
- Interior finishing work

Generally suitable are:

- Trespa Meteon
- Max Exterior
- Plastica (subject to preliminary test)
- Abet (subject to preliminary test)
- Resoplan
- Alucobond
- Megaceram
- Perstop Exteriör (subject to preliminary test)

If new or other untested panels are used, they must be checked first .

Project-related DIN A4-size specimen panels must be sent to our technical department in good time.

Advantages

- General approval from Construction Supervision, Germany „ Deutsches Institut für Bautechnik“ Berlin, Reg. No.: Z-36.4-18
- 1-component products, ready to use
- Economical, rapid mounting
- Uniform tension over the whole façade panel
- Resistant to weather and ageing
- Movement-absorbing fixing
- Free and creative look for façades
- Aesthetic, easy-to-maintain façade surfaces, free of irregularities
- Silicon-free

System components

SikaTack-Panel Technical characteristics:

	Characteristic values	Remarks
Chemical basis	1-comp. polyurethane, moisture curing	
Density	1.18 kg/l	DIN 53 479
Tensile strength	4.0 MPa	Stress failure DIN 53 504, DIN EN 1465
Tensile-shear strength	2.5 MPa	Failure stress, DIN EN 53 283
Application temperature	+ 5 to + 35°C	
Tack free time	20 mins.	23°C/ 50% r. h,
Curing speed	4 mm/24h	23°C/ 50% r. h,
Service temperature	- 40 to + 90°C	
Building-material class	B2 DIN 4102 part 1	
Colour	Ivory	

Packaging: Cartridges à 310 ml (12 cartridges per box) / Unipacs à 310 ml (12 cartridges per box)
Unipacs à 600 ml (20 unipacs per box)

Shelf life: 9 months, stored in original sealed containers and dry conditions at temperatures between + 10°C and + 25°C.

SikaTack-Panel pre-treatment products:

	SikaCleaner 205	SikaTack-Panel Primer
Chemical basis	Bonding agent in alcohol solution	Solvent-containing, pigmented epoxy resin formulation
Colour	Transparent, colourless	Black
Density (DIN 51 757)	0.8 g/cm ³	1.0 g/cm ³
Application temperature	+ 5°C to +35°C	
Flash point	+ 14°C	- 4°C
Packaging	1000 ml bottle	1000 ml bottle
Shelf life	12 months from date of production, stored in original sealed containers and dry conditions at temperatures between + 10°C and + 25°C	

SikaTack-Panel fixing tape:

A double-faced self-adhesive fixing tape is used for immediate fixation of façade panels until final curing of the actual adhesive SikaTack-Panel and to assure that the minimum film-thickness of the adhesive is 3 mm.

Characteristic values	Remarks	
Chemical basis	Closed-cell polythene foam tape	
Colour	White	
Dimension	12 x 3 mm	
Density	0.05 g/cm ³	DIN 51 757
Tensile strength	approx. 0.3 MPa	
Tensile-shear strength	approx. 0.3 MPa	
Application temperature	+5°C to + 35°C	
Service temperature	- 20°C to + 50°C	
Packaging	25 x 33 m rolls / carton	



Important Long-term strength is provided by SikaTack-Panel adhesive. *It is not permissible to include the mechanical values of the tape in the calculation of strength applicable over the long term.* It must be applied onto the full length of the substructure.

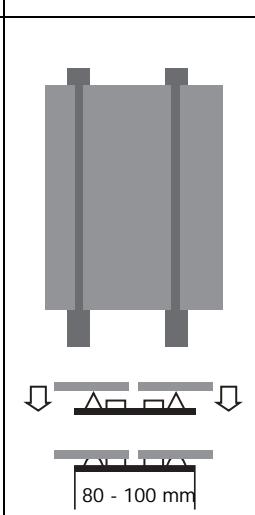
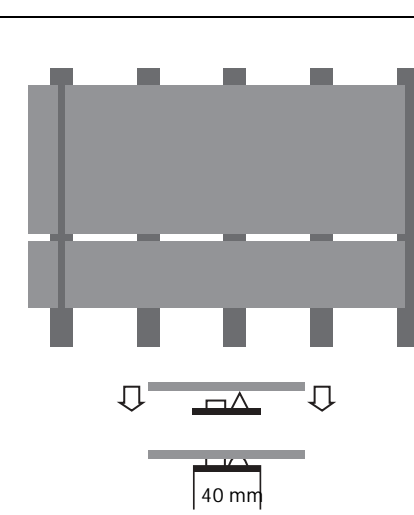
Planning

Aluminium substructure: Substructure approved by the construction supervisory authority (L, or T or H shapes or equivalent) consisting of the alloy AlMgSi 0.5 F 22 at least in accordance with DIN 1748-1.

Timber substructure: Perpendicular battens made of spruce or pine, planed, max. moisture in wood 15 % in accordance with DIN 1052. The adhesive area must be untreated and free of wood-treating agents. Any coatings on the surface must be removed with a 1 mm plane. The joints between the individual battens must be at least 1 cm.

Dimensioning: The dimensioning of the perpendicular substructure depends on the façade construction. The distances between the (substructure elements) and their width are determined by the statics requirements and by the requirements arising from the information on the type of panel used.

Each construction project requires individual planning.

Construction examples	Single field	Multiple field
Required width of substructure elements for applying SikaTack-Panel		

The whole height of the façade panel must be glued.

Calculated permissible values of load-bearing capacity:

- Width of adhesive joint 10 mm
 - Tensile stress: 0.15 MPa
 - Shear stress: 0.15 MPa
- (permissible reduction factor S = 1.0)

For correct dimensioning of the façade and for correct anchoring of the vertical **aluminium or timber substructure**, the known technical building regulations which are relevant are to be applied.

The vertical shaped aluminium sections or the wooden battens must be parallel and even in order to ensure uniform, force-free adhesion of the facade panels to all shaped sections and over the whole length of each shaped section. The joints of the vertical shaped substructure sections must not be glued over by façade panels.

Expansion joints: The distances between the panels at the butt joint must be sufficiently wide to avoid compression of the panels in the case of maximum expansion due to thermal movement. The data of the panel manufacturer are to be complied with as well as the expansion coefficient of the substructure battens. At top and bottom edge of the project leave a sufficiently large opening for ventilation.

Performance

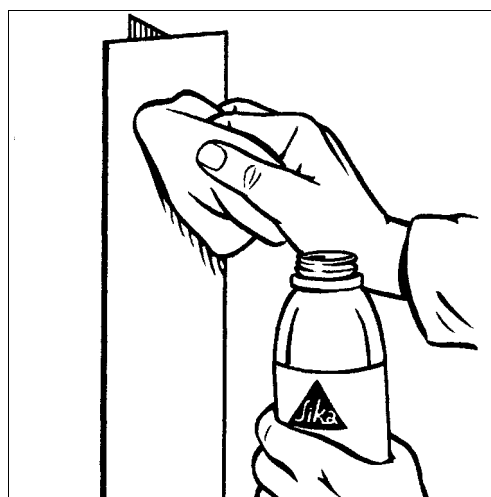
Application conditions Bonding work can be carried out in a workshop or at site. The work must, however, be protected against weathering and dust. During application, the air temperature must not fall below + 5°C or exceed + 35°C. The relative air humidity must not be more than 75 %. For 5 hours after mounting, the temperature should not fall below the minimum temperature of +5°C. The temperature of the building components to be bonded (facade panels, subconstruction) must be at least 3°C higher than the dewpoint temperature of the air in order to avoid the formation of condensation on the surfaces. Applicators must have appropriate technical training. Records must be kept.

Pre-treatment of adhesive surfaces The adhesive surfaces must be clean, dry and free of oil and grease. After application of the primer, the surface to be bonded must be protected against dirt, dust, grease etc.

Aluminium substructure Grind with grinding fleece e.g. Scotch Brite very fine)

Aluminium substructure

- Clean the surface with a clean, grease- and fluff-free cellulose cloth or cleaning paper soaked in **SikaCleaner-205** by wiping the surface in one direction (dirty cloths must be replaced).
- Ventilation time 10 minutes.
- Shake the **SikaTack-Panel Primer** thoroughly (the steel balls in the container must be clearly audible).
- Apply one thin coat of **SikaTack-Panel Primer** uniformly all over the surface by brush or felt
- Ventilation time at least 30 minutes, maximum 8 hours



Timber substructure

- Remove dust
- Shake **SikaTack-Panel Primer** thoroughly (the steel balls in the container must be clearly audible).
- Apply one thin coat of **SikaTack-Panel Primer** uniformly over the whole surface with a brush or felt.
- Ventilation time at least 30 minutes, maximum 8 hours.

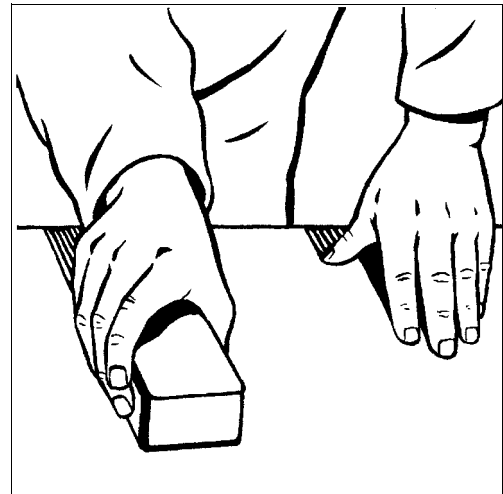


Caution

Don't use cloudy or whitish Sika Cleaner 205 or gelled or non-homogeneous Primer anymore. Fully-cured Primer can only be removed mechanically. Sika Cleaner 205 leaves a cloudy film. Only treat the adhesive surface. Under all circumstances minimum ventilation times for Sika primers and cleaners must be complied to. Splashes on visible surfaces must be removed immediately with a clean cloth or cleaning paper.

Pretreatment of façade panels

- The adhesive surfaces must be clean, dry and free from grease.
- Manual grinding with grinding fleece (e.g. Scotch Brite very fine) or mechanical grinding of the surfaces to be bonded with an eccentric grinder, grain 80.



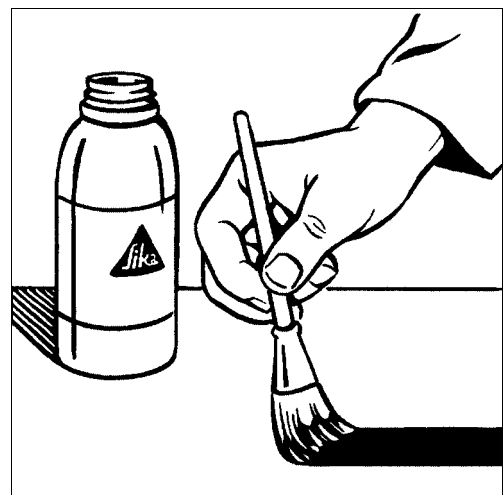
- Clean the adhesive surface with a clean, grease-free and fluff-free cloth or cleaning paper soaked in **Sika Cleaner-205** by wiping in one direction (dirty cloths must be replaced)
- Ventilation time 10 minutes.
- CAUTION: Contamination on the adhesive surface of the large MEGACERAM ceramic tiles must be removed with a cloth and
- **Sika Colma Cleaner**, ventilation time 10 minutes.

Ceramics and cementitious panels do not clean with Sika Cleaner-205.



- Shake **SikaTack-Panel Primer** thoroughly (the steel balls in the container must be clearly audible).
- Apply one thin coat of **SikaTack-Panel Primer** uniformly over the whole surface with a brush or felt.
- Ventilation time min. 30 minutes, max. 8 hours.

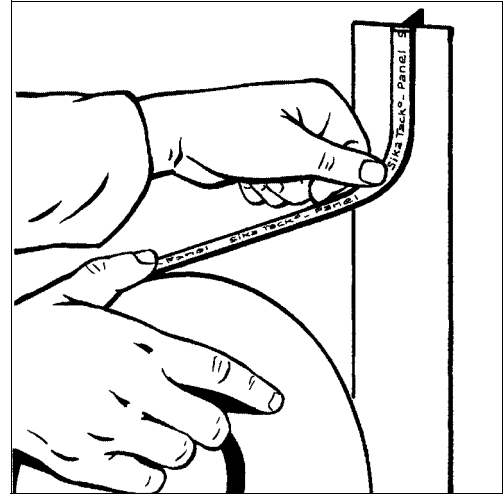
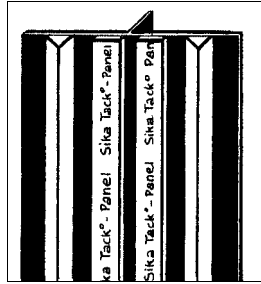
Please comply to the information provided by the panel manufacturer with regard to storage (prevention of distortion). Prior to bonding the panels avoid exposure to direct sun light.



Important: This are just general pretreatment instructions for each type of façade panel are differences possible.

Bonding

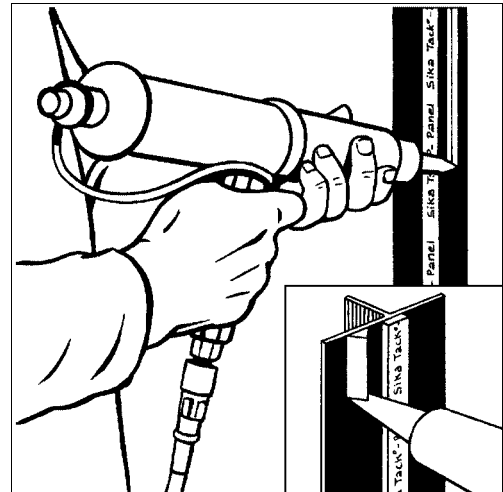
- Apply **SikaTack-Panel fixing tape** over the whole length of the vertical shaped sections and parallel to the edges. Do not pull off the protective foil yet.



- Application of adhesive

SikaTack Panel as a triangular bead by means of the supplied triangular nozzle (width 8 mm, height 10 mm) in at least 5 mm distance to the fixing tape and the side edge of the shaped section.

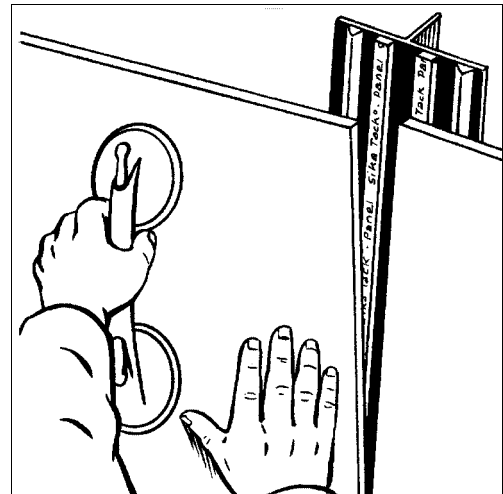
Application with Sika hand-pressure gun or Sika compressed-air gun



- Panel mounting

Remove the protective foil of the SikaTack Panel fixing tape. Place the façade panel to be fixed in the required position on the adhesive bead without the façade panel touching the fixing tape. In order to simplify mounting, the panels can be placed on aligned rulers or setquares. Position the façade panels exactly and press them firmly on until they contact the SikaTack Panel fixing tape.

Mounting of the panels must be completed within 10 minutes after application of the adhesive on the shaped sections



Removal of adhesive remnants

For cleaning tools and in order to remove not fully cured adhesive, we recommend Cleaning Agent-5 or Sika Colma-Cleaner. Fully cured adhesive can only be removed mechanically.

Material consumption

Material	Application	Consumption
Sika Tack -Panel Cartridge à 310 ml Unipac à 600 ml	Triangular bead 8 x 10 mm	~ 44 ml/m ¹ , corresponds to 7 m ¹ /cartridge, 13 m ¹ /unipac
SikaCleaner 205 250 ml bottle 1000 ml bottle	Width 50 mm	~ 3,5 ml/m., corresponds to ~ 285 m ¹ /1000 ml bottle
SikaTack-Panel Primer 1000 ml bottle	Width 50 mm	~ 8 ml/m ¹ , corresponds to 125 m ¹ /1000 ml bottle
SikaTack-Panel Fixing Tape Roll à 33 m		1m ¹ /1m.

**Precautionary
measures/ Disposal**

Detailed precautionary measures e.g. physical, toxicological and ecological data can be obtained from the safety data sheets.

In liquid state the products as well as the Thinner contaminate water and should not get into drains, water or ground.

In any case remnants of thinner and material must be removed according to local regulations. Fully cured material can be disposed of as household waste.

Handling Precautions

Sika products are generally harmless provided that certain precautions normally taken when handling chemicals are observed. The materials must not, for instance, be allowed to come in contact with foodstuffs or food utensils and measures should also be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The use of protective clothing, goggles, barrier creams and rubber gloves is required. The skin should be thoroughly cleaned at the end of each working period either by washing with soap and warm water or by using a resin-removing cream - the use of powerful solvents is to be avoided. Disposable paper towels - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. In case of accidental eye or mouth contact, flush with water - consult a doctor immediately. Health and Safety information on Sika Products is available and we strongly advise that this is read prior to their use. Sika products are for professional use and should be stored in sealed containers away from the reach of children.

Important Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Please consult our Technical Sales Department for further information

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