

SikaBond® Construction Adhesive

One-Part Advanced Polyurethane, Elastomeric Sealant/Adhesive

Description SikaBond® Construction Adhesive is a one-component, gun-grade adhesive and sealing compound of permanent elasticity. This dual-purpose material is based on a special moisture-cured polyurethane with an accelerated curing time.

Where to Use

As an elastic adhesive for:

- Paver caps, masonry veneer, faux stone and landscaping blocks.
- Cover plates, gaskets and coverings.
- Acoustic ceiling tiles.
- Floor moldings and door sills.
- Light weight construction materials.
- Wood, metal, or plastic window and door frames.
- Roof tiles.
- Ceramic and glass.

As an elastic joint sealer for:

- Air ducts and high vacuum systems.
- Containers, tanks, and silos.
- Gaskets in openings in walls or floors for ducts, piling, etc.
- Reservoirs or water retaining structures.
- Aluminum fabrication.
- Bolted lap joints.

Advantages

- Excellent adhesion on all cement-based materials, brick, ceramics, glass, metals, wood, epoxy, polyester, acrylic resin, and plastic (not PVC).
- Fast cure rate.
- Good weathering and water resistance.
- Non-corrosive.
- Can be painted over with water, oil, and rubber-based paints. (Preliminary tests recommended).
- High durability.
- Non staining.
- Movement capability ± 12.5%.
- Permanent elasticity.
- Impact/vibration resistant.
- Freeze-thaw resistant.
- Meets Fed Spec TT-S-00230C
- Meets USDA Approvals.
- Meets CFIA Approvals.
- Meets NSF/ANSI 61 for potable water.

Technical Data	
Packaging	Disposable 300 mL (10.1 fl. oz), moisture-proof composite cartridges, 12/case.
Colour	Grey
Yield	300 mL (10.1 fl. oz) cartridge seals 3.72 m (12 ft.) of 12.7 mm (1/2 in) x 6.35 mm (1/4 in) joint.
Shelf Life	9 months in unopened container. Store at 4° - 35°C (40° - 95°F). Condition material to 18° - 24°C (65° - 75°F) before using.
Properties at 23°C (73°F) and 50% R.H.	
Application Temperature	4° - 38°C (40° - 100°F). Sealant should be installed when joint is at midrange of its anticipated movement.
Service Range	-40° to 77°C (-40° - 170°F)
Curing Rate	Tack-free time (TT-S-00230C) 1 to 2 hours depending on climate Final cure 5 to 8 days
Recovery ASTM C 719	> 90%
Shore A Hardness ASTM D 2240	40 - 45
Tensile Properties ASTM D 412	
Tensile stress	225 psi
Elongation at break	600 %
Lap-Shear Strength ASTM D 1002 modified, glass substrate	
23°C (73°F)/50% R.H.	165 psi
Weathering Resistance	Excellent
VOC (EPA Method 24)	< 50 g/L
Chemical Resistance	Good resistance to water, weak acids, weak alkalis, sewage, mineral oils, vegetable oils, fats, fuels. (Not resistant to organic solvents, paint thinner, strong acids, strong alkalis.) Consult Technical Services for specific data.



How to Use

Surface Preparation	Clean all surfaces. Joint interfaces must be sound, clean, dry, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter must be thoroughly removed. Bond breaker tape or backer rod must be used in bottom of joint for all moving joints.
Priming	Priming is not usually necessary for anodized aluminum, steel, non-absorbent materials such as glass, ceramics, stoneware and tiles. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure. Consult Technical Service for additional information on priming.
Application	Recommended application temperatures: 4° - 38°C (40° - 100°F). For cold weather application, condition material to 18° - 24°C (65° - 75°F) before using. Cut plastic tip on cartridge to desired joint size. Puncture air tight seal at base of tip. Place nozzle of gun into bottom of the joint and fill entire joint. Keep the nozzle in the sealant; continue on with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping of sealant to eliminate entrapment of air. Tool as required. Joint dimension should allow for 6 mm (1/4 in) minimum and 13 mm (1/2 in) maximum thickness for sealant. Proper design is 2:1 width to depth ratio.
Storage	Store in dry warehouse conditions between 4° and 27°C (40° - 80°F). Shelf life under these conditions is 9 months.
Clean Up	Uncured material can be removed with Sika® Equipment Cleaner/Epoxy Thinner or Sika® Hand Cleaner. Cured material can only be removed mechanically.
Limitations	<ul style="list-style-type: none"> ■ Allow 3-day cure at standard conditions when using SikaBond® Construction Adhesive in total water immersion situations and prior to painting. ■ Avoid exposure to high levels of chlorine (Maximum level is 5ppm). ■ Maximum depth of sealant must not exceed 13 mm (1/2 in); minimum depth is 6 mm (1/4 in). ■ Maximum expansion and contraction should not exceed 12.5% of average joint width. ■ Avoid contact with alcohol and other solvent cleaners during cure. ■ Do not apply when a moisture-vapour-transmission condition exists from the substrate as this can cause bubbling within the sealant. ■ Use opened cartridges the same day. ■ When applying sealant, avoid air-entrapment. ■ Since system is moisture-cured, permit sufficient exposure to air. ■ White colour tends to yellow slightly when exposed to ultraviolet rays. ■ The ultimate performance of SikaBond® Construction Adhesive depends on proper application, good design and proper preparation of joints surfaces. ■ Not for use in expansion joints. ■ Heavier substrates may require additional support during the cure period.
Caution	<p>Combustible - Keep away from open flames and high heat. Contains xylene; avoid breathing vapours. Use with adequate ventilation.</p> <p>Irritant; Sensitizer - Contains polyisocyanate prepolymer, xylene. Avoid breathing vapours. Use with adequate ventilation. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. Overexposure to xylene may cause headaches, dizziness or other CNS effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. If TLVs are exceeded, use an appropriate, properly fitted NIOSH approved respirator. Remove contaminated clothing.</p>
First Aid	In case of skin contact, wash immediately and thoroughly with soap and water. If symptoms persist, consult physician. For eye contact, flush immediately with plenty of water for at least 15 min. Contact a physician. For respiratory problems, transport victim to fresh air; if symptoms persist, contact a physician. In case of ingestion, dilute with water and consult physician. Remove contaminated clothing and wash before re-use.

For more information, consult Sika Material Safety Data Sheet.

**KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY**

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, within their shelf life. 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 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 or can be accessed in the Internet under www.sika.ca.

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