

PRODUCT DATA SHEET

Sika MaxTack® Invisible

Transparent high strength adhesive with high initial tack

DESCRIPTION

Sika MaxTack® Invisible is a 1-component, solvent-free high tack adhesive that becomes transparent while curing.

USES

Sika MaxTack® Invisible is designed for the indoor and sheltered outdoor bonding of building materials such as skirting boards, wood frames, panels, terracotta tiles, anodised aluminum, PVC profiles, polystyrene moldings and panels, polystyrene ceiling tiles and wood moldings.

Sika MaxTack® Invisible adheres well to various porous materials such as concrete, mortar, fiber cement, wood and the painted substrates of decorative pieces.

CHARACTERISTICS / ADVANTAGES

- High initial tack
- Fixing without tapes, nails or screws
- Good adhesion to many substrates
- Good workability
- Water-based
- Transparent after drying (depending on thickness)
- Does not leave traces or smudges
- Over-paintable with an emulsion waterborne paint
- For interior use on walls and ceilings
- For sheltered outdoor use on walls (canopies, balconies)

ENVIRONMENTAL INFORMATION

- LEED EQc. 4.1

APPROVALS / STANDARDS

- Émissions dans l'air intérieur A+

PRODUCT INFORMATION

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| Chemical Base | 1-Component water-based acrylic dispersion |
| Packaging | 300 ml cartridge, 12 cartridges per box |
| Colour | White, becomes transparent while curing |
| Shelf Life | Sika MaxTack® Invisible has a shelf life of 12 months from the date of production, if it is stored properly in undamaged, original, sealed packaging, and if the storage conditions are met. |
| Storage Conditions | Sika MaxTack® Invisible shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C. |
| Density | 1.00 kg/l approx. (ISO 1183-1) |

TECHNICAL INFORMATION

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| Shore A Hardness | 75 approx. (after 28 days) (ISO 868) |
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Shear Strength 3.0 N/mm² approx., 0.5 mm adhesive thickness (EN 1465)

Service Temperature -15 °C to +60 °C

APPLICATION INFORMATION

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| Consumption | Using a nozzle with a 5 mm diameter, bead yield is approx. 15 m in length per 300 ml cartridge (approx. 20 ml per linear meter). | |
| Sagging | Very low | (ISO 7390) |
| Ambient Air Temperature | +5 °C to +40 °C, min. 3 °C above dew point temperature | |
| Substrate Temperature | +5 °C to +40 °C | |
| Curing Rate | 2 mm/24 hours approx. (23 °C / 50% r.h.) | (CQP 049-2) |
| Skin Time | 100 minutes approx. (23 °C / 50% r.h.) | (CQP 019-1) |

APPLICATION INSTRUCTIONS

For the application of Sika MaxTack® Invisible all standard construction guidelines apply.

SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. Paint, cement laitance and other poorly adhering contaminants must be removed. Paint and other materials must be hardened (e.g. wood chip-board, cardboard plaster panel), adhered to their substrates and resistant to pull out. At least one substrate must be porous. Sika MaxTack® Invisible adheres without primers and/or activators.

Non-porous substrates

Anodised aluminium has to be cleaned with acetone or isopropanol using a clean towel or cloth. Allow a flash-off time of > 30 minutes (< 6 hours).

Porous substrates

Wood has to be sanded, concrete and mortar have to be scrubbed and sanded to remove laitance. Clean with an industrial vacuum.

For more detailed advice and instructions please contact our Technical Service Department.

APPLICATION METHOD / TOOLS

After the necessary substrate preparation, apply Sika MaxTack® Invisible in round shaped cordons with 5 mm in diameters in intervals of a few centimetres each. If necessary, use a notched trowel to distribute Sika MaxTack® Invisible evenly. Press or tap bonded parts together firmly to ensure good adhesion before a skin occurs. An incorrectly positioned element can easily be unfastened and repositioned during the first few minutes after application. If necessary, use adhesive tapes, wedges, or props to hold the assembled elements together during the initial curing hours. The recommended adhesive layer thickness (depending on surface evenness) is 0.5–2 mm. For immediate fixing, the thickness of the bonding adhesive layer

must be ≤ 1 mm. Adhesive applied with a thickness of ≤ 2 mm will become transparent after drying for 24 hours at 23 °C and 50% r.h.

Fresh, uncured adhesive remaining on the surface must be removed immediately.

Final strength will be obtained after complete curing of Sika MaxTack® Invisible.

CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with water. Once cured, residual material can only be removed mechanically.

FURTHER DOCUMENTS

- Safety Data Sheet
- Pre-treatment Chart Sealing and Bonding

LIMITATIONS

- For good workability, the adhesive temperature shall be +20 °C.
- For proper curing of the adhesive, sufficient ambient humidity / moisture is necessary.
- Before bonding, check adhesion and resistance of paints and coatings by carrying out a trail.
- Trials shall be carried out to test for overpaint ability and paint compatibility. When overcoating Sika MaxTack® Invisible, compatibility of coatings must be tested individually.
- For optimal bonding, one of the two substrates must be porous.
- Do not use Sika MaxTack® Invisible on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might bleed oils, plasticizers or solvents that could attack the sealant.
- Do not use outside on easily corroding substrates such as blank steel or iron.
- Do not use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE / Teflon), and certain plasticized synthetic materials (pre-trials shall be carried out or contact our Technical Service Department).
- Application during high temperature changes is not recommended (movements during the curing).
- Do not use Sika MaxTack® Invisible as glass sealer, in

- floor joints, in sanitary joints and structural bonding.
- Do not use Sika MaxTack® Invisible for joints under water pressure or for permanent water immersion.

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

ECOLOGY HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTES

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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request. It may be necessary to adapt the above disclaimer to specific local laws and regulations. Any changes to this disclaimer may only be implemented with permission of Sika® Corporate Legal in Baar.

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