

PRODUCT DATA SHEET

SikaBond®-115 Strong Fix

Interior grab adhesive

DESCRIPTION

SikaBond®-115 Strong Fix is a 1-part construction adhesive with high final strength which bonds most construction material substrates. Internal and sheltered outdoor use.

USES

An adhesive to bond most construction components such as:

- Skirting boards
- Wooden frames
- Battens
- Mouldings
- Panels,
- Terracotta tiles
- Anodised aluminium
- Polystyrene mouldings and ceiling tiles

An adhesive to bond most construction materials such as:

- Concrete, mortar, fibre cement, wood and paint

CHARACTERISTICS / ADVANTAGES

- Easy to apply
- Easy to clean
- Rapid build-up of strength
- High final strength
- Very low emissions

ENVIRONMENTAL INFORMATION

- Conformity with LEED v4 EQc 2: Low-Emitting Materials
- VOC emission classification GEV-EMICODE EC 1^{PLUS}
- VOC emission classification of building materials RTS M1
- Class A+ according to French Regulation on VOC emissions

PRODUCT INFORMATION

Chemical Base	Acrylic dispersion
Packaging	290 ml cartridge, 12 cartridges per box
Colour	White
Shelf Life	18 months from the date of production.
Storage Conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +25 °C. Always refer to packaging.
Density	~1,40 kg/l (ISO 1183-1)

TECHNICAL INFORMATION

Shore A Hardness	~94 (after 28 d)	(ISO 868)
Tensile Strength	~6,0 N/mm ²	(ISO 37)
Elongation at Break	~35 %	(ISO 37)
Shear Strength	~4,4 N/mm ² , 0,1 mm adhesive thickness	(EN 1465)
Service Temperature	-15 °C min. / +60 °C max.	

APPLICATION INFORMATION

Yield	Yield	Dimension
	1 Cartridge (290 ml)	
	~100 spots	Diameter = 30 mm Thickness = 4 mm
	~15 m bead	Nozzle diameter = 5 mm (~20 ml per linear meter)

Sag Flow	0 mm (20 mm profile, 23 °C)	(ISO 7390)
Ambient Air Temperature	+5 °C min. / +35 °C max.	
Substrate Temperature	+5 °C min. / +35 °C max., ≥ 3 °C above dew point temperature	
Curing Rate	~6 mm/24 h (23 °C / 50 % r.h.)	Sika Corporate Quality Procedure (CQP 049-2)
Skin Time	~30 min (23 °C / 50 % r.h.)	(CQP 019-1)

APPLICATION INSTRUCTIONS

For the application of SikaBond®-115 Strong Fix all generally accepted rules of building and construction apply.

SUBSTRATE PREPARATION

The substrate must be sound, clean, dry and free of all contaminants such as dirt, oil, grease, cement laitance, old sealants and poorly bonded paint coatings which could affect adhesion of the adhesive.

Removal techniques such as wire brushing, grinding, sanding or other suitable mechanical tools can be used.

All dust, loose and friable material must be completely removed from all surfaces before application of primers or adhesive.

For optimum adhesion and critical, high performance applications the following priming and/or pre-treatment procedures shall be followed:

Non-porous substrates

Aluminium, anodised aluminium, stainless steel, PVC, galvanised steel, powder coated metals or glazed tiles. Slightly roughen surface with a fine abrasive pad.

Clean and pre-treat using Sika® Aktivator-205 applied with a clean cloth.

Before application of adhesive, allow a waiting time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, cleaned and pre-treat using Sika® Aktivator-205 applied with a clean cloth. After a waiting time of > 15 minutes (< 6 hours). Apply Sika® Primer-3 N applied by

brush. Allow a further waiting time of > 30 minutes (< 8 hours) before application of adhesive.

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks. Prime surface using Sika® Primer-3 N applied by brush.

Before application of adhesive, allow a waiting time of > 30 minutes (< 8 hours).

For more detailed advice and instructions contact Sika Technical Services.

Note: Primers are adhesion promoters and not an alternative to improve poor preparation / cleaning of the bonded surface. Primers also improve the long term adhesion performance of the bonded surfaces.

MIXING

Ready to use product

APPLICATION METHOD / TOOLS

After the necessary substrate preparation, prepare the end of the SikaBond®-115 Strong Fix cartridge, insert into the sealant gun and fit the nozzle.

Apply in beads, strips or spots at intervals of a few centimetres each. If necessary, use a notched trowel to distribute SikaBond®-115 Strong Fix evenly.

Use hand pressure only to fix the components to be bonded into position before skinning of the adhesive occurs. Incorrectly positioned components can easily be unbonded and repositioned during the first few minutes after application. If necessary, use temporary adhesive tapes, wedges, or supports to hold the as-

sembled components together during the initial curing time. The recommended adhesive layer thickness (depending on surface evenness) is < 3 mm. For immediate grab fixing, the thickness of the adhesive layer must be ≤ 1 mm.

Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be reached after complete curing, i.e. 24 to 48 hours at +23 °C, depending on the environmental conditions and adhesive layer thickness.

CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208. Once cured, hardened material can only be removed mechanically. For cleaning skin use Sika® Cleaning Wipes-100.

FURTHER DOCUMENTS

- Pre-treatment Sealing and Bonding Chart

LIMITATIONS

- For good workability, the adhesive temperature should be +20 °C.
- Application during high temperature changes is not recommended (movement during curing).
- Before bonding, check adhesion and resistance of paints and coatings by carrying out a trial.
- SikaBond®-115 Strong Fix can be overpainted with most conventional water-based coating and paint systems. However, paints must first be tested to ensure compatibility by carrying out preliminary trials. The best over-painting results are obtained when the adhesive is allowed to fully cure first. Note: non-flexible paint systems may impair the elasticity of the adhesive and lead to cracking of the paint film.
- Colour variations may occur due to exposure to chemicals, high temperatures and/or UV-radiation (especially with the colour shade white). However, a change in colour is purely of aesthetic nature and does not adversely influence the technical performance or durability of the product.
- Always use SikaBond®-115 Strong Fix in conjunction with mechanical fixings for overhead applications of heavy components.
- For very heavy components provide temporary support until SikaBond®-115 Strong Fix has fully cured.
- For optimum bonding, at least one of the two substrates must be porous.
- Before using on natural stone, contact Sika Technical Services.
- Do not use on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might leech oils, plasticisers or solvents that could degrade the adhesive.

- Do not use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE / Teflon), and certain plasticised synthetic materials (pre-trials shall be carried out or contact Sika Technical Services).
- Do not use for bonding glass if the bond line is exposed to sunlight.
- Do not use for structural bonding.

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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