

# PRODUCT DATA SHEET

## Sikaflex® High Tack

### DESCRIPTION

Sikaflex® High Tack is a 1-component, solvent-free high tack adhesive with powerful initial tack.

### USES

Sikaflex® High Tack is designed for the indoor and outdoor bonding of various objects in and around houses such as cable channels, acoustic tiles, door sills, roof and wall coverings and cover plates.

Sikaflex® High Tack has good adhesion on concrete, mortar, clinker, fiber cement, natural stone (e.g. granite), ceramic, wood, metal (galvanized and stainless steel, aluminum).

### CHARACTERISTICS / ADVANTAGES

- Powerful initial tack
- Fixing without tapes, nails or screws
- Very good adhesion to many substrates
- High load capacity
- Good workability
- Fast curing
- Can be used on damp concrete
- Very low emissions

### ENVIRONMENTAL INFORMATION

- EMICODE EC1<sup>PLUS</sup> R

### APPROVALS / STANDARDS

- Émissions dans l'air intérieur A+

### PRODUCT INFORMATION

<b>Chemical Base</b>	<i>i</i> -Cure Technology polyurethane
<b>Packaging</b>	300 ml cartridge, 12 cartridges per box
<b>Colour</b>	White

<b>Shelf Life</b>	Sikaflex® High Tack 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.
<b>Storage Conditions</b>	Sikaflex® High Tack shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C.
<b>Density</b>	1.30 kg/l approx. (ISO 1183-1)

## TECHNICAL INFORMATION

<b>Shore A Hardness</b>	50 approx. (after 28 days) (ISO 868)
<b>Tensile Strength</b>	2.5 N/mm <sup>2</sup> approx. (ISO 37)
<b>Elongation at Break</b>	600% approx. (ISO 37)
<b>Tear Propagation Resistance</b>	8.0 N/mm approx. (ISO 34)
<b>Service Temperature</b>	-40 °C to +80 °C

## APPLICATION INFORMATION

<b>Consumption</b>	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).
<b>Ambient Air Temperature</b>	+5 °C to +40 °C, min. 3 °C above dew point temperature
<b>Substrate Temperature</b>	+5 °C to +40 °C
<b>Curing Rate</b>	3 mm/24 hours approx. (23 °C / 50% r.h.) (CQP 049-2)
<b>Skin Time</b>	15 minutes approx. (23 °C / 50% r.h.) (CQP 019-1)

## APPLICATION INSTRUCTIONS

For the application of Sikaflex® High Tack 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. Sikaflex® High Tack adheres without primers and/or activators. However, for optimum adhesion and critical, high performance applications, such as on multi-story buildings, highly stressed joints, extreme weather exposure or water immersion, 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 have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. Before sealing, allow a flash-off time of > 15 minutes (< 6 hours). Other metals, such as copper, brass and titanium-zinc, also have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. After the necessary flash-off time, use a brush to apply Sika® Primer-3 N and allow a further flash-off time of > 30 minutes (< 8 hours) before sealing the joints.

#### Porous substrates

Concrete, aerated concrete and cement based

renders, mortars and bricks shall be primed using Sika® Primer-3 N applied with a brush. Before sealing, allow a flash-off time of > 30 minutes (< 8 hours).

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

Note: Primers are adhesion promoters. They are neither a substitute for the correct cleaning of a surface, nor do they improve the strength of the surface significantly.

## APPLICATION METHOD / TOOLS

After the necessary substrate preparation, insert a cartridge into the sealant gun and extrude Sikaflex® High Tack into the joint making sure that it comes into full contact with the sides of the joint and avoids any air entrapment. Apply Sikaflex® High Tack in round shaped cordons with 5 mm in diameters in intervals of a few centimetres each. If necessary, use a notched trowel to distribute Sikaflex® High Tack 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. The recommended adhesive layer thickness (depending on surface evenness) is < 3 mm. Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be obtained after complete curing of Sikaflex® High Tack.

## CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208 and/or Sika® Top-Clean T. 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 Sikaflex® High Tack, compatibility of coatings must be tested individually.
- 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.
- Do not use Sikaflex® High Tack 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 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).

## 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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