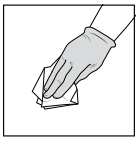
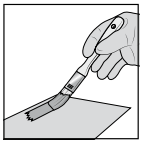
APPLICATION TIPS

PROCEDURE

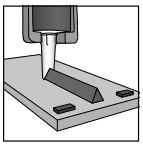


Bonding surfaces must be clean, dry and free of oil and grease. If necessary, sand bonding surfaces with a scouring pad and remove the dust. Remove heavy soiling with Sika® Remover-208 or Sika® Cleaner P. See the primer chart for more information

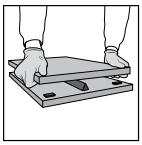
If necessary (see primer chart), wipe bonding surfaces with a clean, lint-free paper tissue moistened with an activator (Sika® Aktivator-100, Sika® Aktivator-205 or Sika® ADPrep). Observe the corresponding curing time



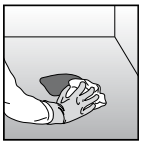
If necessary (see primer chart), apply primer to bonding surfaces with a brush, wool felt applicator or foam applicator. Observe the corresponding curing time



When bonding with non-sag products, apply the adhesive as a triangular bead. Cut the nozzle according to the printed scale and hold the gun perpendicular while applying. With two-component products, use a static mixer and apply the adhesive in dots or as a bead. Observe the minimum layer thickness and use spacers as needed



Position and press both plates so that they adhere to one another. If necessary, fix the component and leave it to polymerise. Respect handling time



Use a scraper and Sika® Remover-208 to remove any excess uncured adhesive. Other cleaners may interfere with the curing process

THINGS TO OBSERVE FOR APPLICATION

WORKING WITH A MATCHED SYSTEM
Using a matched system of pre-treatment agents and adhesives is recommended in order to ensure easy application of the products and trouble-free bonding.

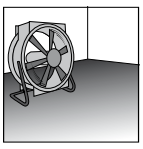
NO ALCOHOL ON UNCURED ADHESIVE
Once the adhesive has been applied, avoid contact between the freshly applied adhesive and products containing alcohol until a skin has formed. Alcohol disrupts the reaction and causes the adhesive to stay pasty or sticky instead of curing. Use Sika® Remover-208 to remove adhesive residue.

SILICONE ON SUBSTRATE OR ADHESIVE
Skin creams and products containing silicone can degrade adhesion and lead to debonding and water ingress.

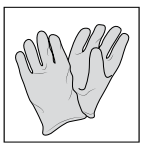
GLUING OF SPACERS
Gluing spacers with cyanoacrylate adhesives (super glue) can cause bonding problems in the surrounding area, leading to leaks. Self-adhesive spacers can be used without problems. Spacers should not be embedded in the adhesive bead, but should be as close as possible to the adhesive to avoid leaks. To avoid high local stresses, the hardness of the spacers should correspond to the hardness of the adhesive.

The application instructions and procedure must be followed precisely to ensure durable bonded joints.

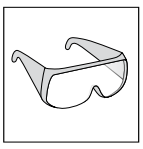
RESPECT SAFETY AT ALL TIME



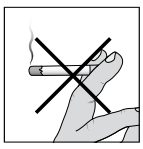
Ensure good ventilation



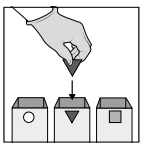
Wear protective gloves



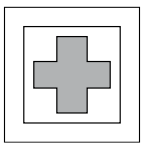
Wear protective glasses



Do not smoke, no fire, no food



Correct disposal of waste and residues



Be prepared for emergencies