

Roofing Adhesive

SIKA-TROCAL® C-400® Spray

Spray Applied Adhesive for Sika-Trocal® SGK® Felt and SG® roof waterproofing membranes

PRODUCT DESCRIPTION

Multi-Purpose moisture-curing PU based contact adhesive in a pressurized canister system.

USES

Sika-Trocal® C-400® is a spray applied contact adhesive to bond Sika-Trocal® SGK Felt and SG (upstand and detail work) roof waterproofing membranes onto approved substrates.

CHARACTERISTICS / ADVANTAGES

- Quick and professional application
- Less stress on operatives

SUITABLE SUBSTRATES

- PIR insulation boards
- OSB/Plywood
- Specific mineral wool
- Galvanized steel, aluminum, PVC-coated metal sheet

TESTS

APPROVAL / STANDARDS

- Quality management system EN ISO 9001/14001

PRODUCT DATA

FORM

CONSISTENCY / COLOUR

- Liquid
- Colour: Red

PACKAGING

- One way canister: 19.7 kg (Adhesive 13.6 kg)
- Packaging unit: single canister
- Packaging dimension: Cardboard box 320 mm x 320 mm x 460 mm



STORAGE**STORAGE CONDITIONS**

Store in dry conditions at temperatures between +5 °C to +25 °C

SHELF-LIFE

12 months from date of production if stored properly in original, unopened and undamaged sealed container. Expiry date on container. The adhesive will have a limited lift once the container is opened.

TECHNICAL DATA**CHEMICAL BASIS**

Moisture-curing PU based contact adhesive.

APPLICATION GUIDANCE TIME

Temperature	Open Time T _{gel}
+30°C	10 minutes
+20°C	20 minutes
+10°C	30 minutes
+5°C	40 minutes

These times may vary due to application conditions.

SYSTEM INFORMATION**APPLICATION DETAILS****CONSUMPTION**

Consumption depends on the roughness and absorbency of the substrate and ranges approx. from 150g/m² – 200 g/m² on closed substrates to 400 g/m² on very absorbent substrates. One single canister can cover approx. 80-100 m².

SUBSTRATE QUALITY

The substrate must offer sufficient strength and adhesion to resist the forces generated by wind suction.

SUBSTRATE PREPARATION

The substrate must be resistant to solvent, firm, clean, dry and free of oil and grease. Sheet metal must be cleaned with L100 Cleaner before adhesive is applied.

COMPATIBILITY

Shall not be used on substrates:

- EPS/XPS insulation boards
 - Copper plate
 - Bituminous substrates
 - Waterproofing membranes (thermoplastics/elastomers)
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INSTALLATION INSTRUCTIONS**APPLICATION GUIDLINE**

Based on the valid installation instructions of the relevant roof waterproofing membrane.

SIKA-TROCAL® SGK® FELT BACKED MEMBRANE (WET BONDING)

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1. Apply on coat of Sika-Trocal® C-400® Spray (approx. 100 g/m²) directly to the substrate as a priming coat. Allow the Sika-Trocal® C-400 Spray to dry completely. Apply two coats of adhesive on absorbent substrates. Prime only that area of the roofing where membrane will be laid out on the same day.
 2. Lay out Sika-Trocal® SGK® Felt or Sika-Trocal®, align and fold back to approximately half its length.
 3. Apply a second coat of Sika-Trocal® C-400 Spray (approx. 100 g/m²) evenly to the underside of the membrane, there should be an approximately 50mm spray overlap.
 4. The Sika-Trocal® SGK® Felt is laid directly on substrate adhesive and press down using a heavy roller (approx. 50 kg).
 5. Fold back the second half and repeat as above.

SIKA-TROCAL® SG® BARE BACKED MEMBRANE FOR UPSTANDS & DETAIL WORK (CONTACT BONDING)

1. Apply an even coat of Sika-Trocal® C-400® Spray (approx. 100 g/m²) directly to the substrate as a priming Coat. There should be an approximately 50mm spray overlap. Allow the Sika-Trocal® C-400® Spray to dry completely. Apply two coats of adhesive as a priming coat on absorbent substrates. Prime only the area of the roof where membrane will be installed on the same day.
2. Lay out the Sika-Trocal® SG® membrane, align and fold back to approximately half its length.
3. Apply Sika-Trocal® C-400® Spray (approx. 100g/m²) evenly on the underside of the membrane with an approximate 50mm spray overlap. Once the adhesive has been allowed to evaporate sufficiently (gloved finger test), install the sheet. The time to be allowed for evaporation depends on the temperature, air, humidity, condition of the substrate and quantity of adhesive.

Important note:

Welding overlap section needs to be protected during spray application. Use L100 Cleaner to remove adhesive residues on the roof membrane.

APPLICATION METHOD

GENERAL INFORMATION








Based on the valid installation instructions of the relevant roof waterproofing membrane.

The canister and gun will remain usable for 2 weeks after opening. If you do not intend to use the system within this time the adhesive in the hose and gun should be renewed by purging approx. 250ml of adhesive through the system every 2 weeks. If the system is not going to be used for longer than 2 weeks we recommend flushing the gun and hose with the Sika Canister Flushing System.

Once canister is use is empty, the gun/hose can be transferred to a new canister.



CANISTER SET-UP

It is important to set-up your Sika-Trocal® C-400 Spray Canister Adhesive correctly before use to ensure the best possible performance and to avoid leakage or system failure.



01.		Remove the black cap from the canister valve.
02.		Attach the rubber hose to the canister valve (using the small nut) and attach the other end of the braided-hose to the spray-gun (using the large nut). Tighten with a spanner.
03.		Attach the other end of the rubber hose to the spray-gun (using the large nut). Tighten with a spanner.
03.		Using the locking-nut provided, attach the spray-tip to the end of the spray-gun.
04.		Fully open the valve on the canister.
05.		Pull the trigger on the spray-gun to apply adhesive.
06.		Adjust the spray pattern by turning the black valve on the spray-gun anti-clockwise until you have a spray pattern approximately 300mm in width.




CANISTER MAINTENANCE GUIDE

Once work has been completed, ensure the valve on the canister remains open. Failure to do this may cause the adhesive to block the hose.


01.		Turn the spray-gun off by turning the black valve clockwise until it is fully closed.
02.		Unscrew the spray-tip and the end of the spray-gun. Clean the spray-tip and the end of the spray-gun with Sika Spray Cleaner or L100 Cleaner using a soft nylon brush to ensure that the aperture is clear. This is essential. Failure to clean the spray-tip and the end of the spray-gun may result in damage to the aperture and prevent the system from working. Place the spray-tip and locking-nut in a container with a small amount of Sika Spray Cleaner or L100 Cleaner until it is needed again. Ensure the container is closed and airtight.

CANISTER FLUSHING SYSTEM

01.		Ensure the valve on the canister is completely turned off before attaching the assembly.
02.		Unscrew the hose from the canister valve.

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| 03. |  | Attach the assembly to the valve. Ensure the assembly remains upright whilst you tighten the nut on it. Attach the hose to the assembly. Ensure the assembly remains upright whilst you tighten the hose. |
| 03. |  | Check the tap on the assembly is off before applying the Sika Spray Cleaner. Screw the Sika Spray Cleaner into the hose and open the red valve. |
| 04. |  | Aiming the gun into a waste container, apply pressure to the trigger on the gun to push Sika Spray Cleaner through the hose and gun until the adhesive starts to dispense. Keep pressure on the trigger until the hose and gun are thoroughly cleaned. |

CANISTER DISPOSAL SYSTEM

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| 01. |  | <p>The Sika-Trocal® C-400 Spray canister contains compressed gas. It should be emptied by carefully opening the valve, which will release any excess adhesive and/or pressure.</p> <p>Allow any excess adhesive and/or pressure to fully escape into a suitable container. Leave the valve open.</p> <p>Once the canister is empty and completely depressurized, the circular disk can be pierced using a non-ferrous bar/rod.</p> <p>Allow any remaining adhesive to cure. The empty depressurized canister should be disposed/recycled in accordance with regulatory requirements.</p> |
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TOOL CLEANING

Tools and equipment must be cleaned with Sika Spray Cleaner or L100 Cleaner immediately after use.

Purge the adhesive through the hose & application gun (approx. 250ml) as necessary before and after use.

TOOL CLEANING

Installation works to be carried out only by Licensed Trocal Roofing Contractors.

Temperature limits for the installation of the adhesive:

- Substrate temperature: At least +5 °C
- Ambient temperature: At least +5 °C

Installation of some ancillary products, e.g. contact adhesives / cleaners is limited to temperatures above +5 °C. Please observe information given by Product Data Sheets.

Special measures may be compulsory for installation below +5 °C ambient temperature due to safety requirements in accordance with national regulations.

VALUE BASE

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.

**HEALTH AND SAFETY
INFORMATION**

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet 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.

