

SikaSense[®]-4600

Fast contact adhesive

Technical Product Data:

Chemical Base	1C polychloroprene
Colour	Yellowish-brown
Solid content (CQP 002-0)	26% approx.
Density (CQP 006-0)	0,9 kg / l approx.
Viscosity, 20 °C (Brookfield RVT, Sp 5/20 Rpm)	1200 mPas approx.
Flash point (SQP007-0)	<21 °C
Bonding process	- One side, fitting wet - Both sides, fitting dry
Coverage	100 - 150 g / m ² , wet (depends on substrate)
Method of application	Spray gun, roller, brush or tooth-comb
Time ¹⁾ to fit wet	60 - 150 sec
Open time (SQP567-0)	30 min approx.
Resistance of the film	Not dissoluble in water
Shelf life	6 Months at the storage temperature of 5 - 25 °C

¹⁾ 23 °C and 50% relative humidity

Description

SikaSense[®]-4600 is an approved, multipurpose, fast drying 1C polychloroprene contact adhesive.

SikaSense[®]-4600 is manufactured in accordance with the ISO 16949/14001 quality assurance system.

Product benefits

- 1C adhesive
- Very short flash-off time
- High initial strength
- Free of toluene
- Resistant against aging
- Not dissoluble in water
- Broad adhesion range

Areas of application

SikaSense[®]-4600 has a very broad adhesion range and gives an elastic, strong and lasting bond. Suitable substrates are wood, rubber sheets and painted metal sheets.

In the production of utility vehicles SikaSense[®]-4600 is suitable for the room temperature contact bonding of different covering materials e.g. PVC floor coverings and for adjoining steps, wheel arches, seat brackets and side walls, especially for covering materials with high spring-back forces, like cover trims and edging profiles.

Industry



Cure mechanism

SikaSense®-4600 cures primarily due to the evaporation of the solvent. Final strength is attained in three days after the completion of a chemical curing process. At elevated temperatures the chemical curing is significantly quicker.

Chemical resistance

SikaSense®-4600 is resistant to water, limewater, temporarily resistant to weak acids and caustic solutions, fuels, mineral oils, vegetable and animal fats and oils, not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions and paint thinners.

These are only general indications. In case of expected chemical or thermal exposure, we recommend a project related testing or refer to the Technical Service Industry.

Method of application

Surface preparation.

The adhesion surfaces must be clean, dry and free of oils and fats. The adhesive generally is applied with suitable roller, tooth-comb, brush or spray gun. For the use in automatic application systems a suitable filter system is recommended.

Application.

In case of one side contact bonding the parts are fitted and pressed together within the open time.

In case of wet bonding the parts are fitted and pressed together within 60 to 150 sec.

Care must be taken to avoid the formation of little adhesive pools on the bonding surfaces. Entrapped solvent causes weak bond.

Once the container is opened, the material must be used up in a short time.

The processing temperature must be at least 5°C and less than 35°C. Optimal temperature range is 15°C to 25°C.

Cleaning of tools.

Solvent can be used to clean the tools from uncured adhesive residues.

Cured adhesive only can be removed by laborious mechanical means.

Further information

Copies of the following publications are available on request:

- Material Safety Data Sheet

Packaging information

Pail	5 kg
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Important

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

For specific advice concerning preparation of the substrates or the choice of appropriate application devices, please contact our Technical Service.



Sika Schweiz AG
Tüffenwies 16
8048 Zürich
Switzerland
Tel: +41 1 436 40 40
Fax: +41 1 436 45 30

Sika Limited
Watchmead
Welwyn Garden City
Herts., AL7 1BQ, UK
Tel: +44 1707 39 44 44
Fax: +44 1707 32 91 29

Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
USA
Tel: +1 248 577-0020
Fax: +1 248 577-0810