

## PRODUCT DATA SHEET

## Sika® Icosit® KC 250/80

Fast-curing, flexible, semi self-levelling construction adhesive for noise and vibration reduction

## PRODUCT DESCRIPTION

Sika® Icosit® KC 250/80 is a flexible, two-part, polyurethane structural adhesive. It combines a long open time with rapid curing and strength development. In its uncured state, the Product is semi self-levelling, making it easy to apply and fill with.

## USES

Sika® Icosit® KC 250/80 may only be used by experienced professionals.

Sika® Icosit® KC 250/80 is used as a:

- Liquid-applied gasket to reduce impact noise from road manhole covers.
- Construction adhesive for flexibly bonding most construction materials.
- Means of reducing noise and vibration from traffic.
- Fast return to service adhesive.

## CHARACTERISTICS / ADVANTAGES

- Easy to use and apply.
- Consistent workability throughout the long open time.
- Pasty, semi self-levelling consistency for optimal application and form fit.
- Fast curing speed and rapid strength development result in a very short return to service time.
- Very good noise and vibration reduction due to a combination of structural strength and flexibility.
- Excellent tensile adhesion / bonding to most construction materials.

## PRODUCT INFORMATION

Chemical Base	Two-part polyurethane		
Packaging	400 ml dual cartridge. 12 cartridges per box. Pallet: 50 boxes with 600 cart- ridges.		
Colour	Part A	Black	
	Part B	Black	
	Part A+B	Black	
Shelf Life	6 months from date of production		
Storage Conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +15 °C and +25 °C. Always refer to the packaging. Protect the Product from direct sunlight.		
Density	Part A	1.16 kg/L	(EN ISO 2811-1)
	Part B	1.27 kg/L	
	Part A+B	1.21 kg/L	

**Volatile organic compound (VOC) content**

Does not contain solvents or PVC

Viscosity	Conditions	Part	Viscosity	(CQP029-4)
	At +20°C and 10 s <sup>-1</sup>	Part A	22 Pa·s	
	At +20°C and 10 s <sup>-1</sup>	Part B	60 Pa·s	
Consistency	Pasty, semi self-levelling			

## TECHNICAL INFORMATION

Shore A Hardness	Cured 1 day, at +23 °C and 50 % r.h.	95	(ISO 48-4)
Tensile Strength	Cured 7 days at +23 °C and 50 % r.h.	15 N/mm <sup>2</sup>	(EN ISO 527-1)
Tensile Modulus of Elasticity	Cured 7 days at +23 °C and 50 % r.h. Elongation 0.05–0.25 %	350 N/mm <sup>2</sup>	(EN ISO 527-3)
Lap Shear Strength	Cured 7 days at +23 °C and 50 % r.h.	15 N/mm <sup>2</sup>	(ISO 4587)
Glass transition temperature	Cured 7 days at +23 °C and 50 % r.h.	+45 °C	(ISO 6721-11)
Elongation at break	Cured 7 days at +23 °C and 50 % r.h.	100 %	(EN ISO 527-2)

## APPLICATION INFORMATION

Mixing Ratio	Part A : Part B by weight	100 : 109.5	
	Part A : Part B by volume	100 : 100	
Layer Thickness	1 mm to 15 mm maximum		
Product Temperature	Maximum	+30 °C	
	Minimum	+10 °C	
Ambient Air Temperature	Maximum	+30 °C	
	Minimum	+15 °C	
Substrate Temperature	Maximum	+30 °C	
	Minimum	+15 °C	
Open Time	At +23 °C and 50 % r.h.	~7 minutes	(ISO 4587)

## Curing Time

## Conditions

## Curing Time for 90 % of Final Strength

## Full Cure

(ISO 4587)

At +23 °C and 50 % r.h.	~60 minutes	-
At +15 °C and 50 % r.h.	~80 minutes	-
At +10 °C and 50 % r.h.	~90 minutes	-
At +5 °C and 50 % r.h.	~120 minutes	-
At +23 °C and 50 % r.h.	-	1 day

**NOTE:** Trafficability is reached when 90 % of final strength (Shore A hardness) is reached.

## 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.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

Substrate must be sound, clean, dry and free of all contaminants such as dirt, oil, grease, coatings and loose friable materials.

Additional surface treatment depends on the specific nature of the substrates and is crucial for long lasting bond. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process. For information on substrate preparation and priming, contact Sika® Technical Services.

### APPLICATION

- Extrude part A and part B without the mixer to equalise the filling levels. Use suitable manual, pneumatic or electric piston dispensers.
- Attach the static mixer to the cartridge.
- Extrude part A and part B with the mixer until both parts come out uniformly.

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- Dispose of the first few centimeters of the bead before application.
- Apply the adhesive onto the surface within the open time.

### CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208 or Sika® PowerClean. Once cured, hardened material can only be removed mechanically.

## 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.

## 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.

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