

## PRODUCT DATA SHEET

# SikaBond® 5 minute PU Wood Adhesive

One part moisture curing wood adhesive in gel and liquid form.

### PRODUCT DESCRIPTION

SikaBond® 5 minute PU Wood Adhesive is a one part moisture curing, gap filling wood adhesive which sets hard in just 5 minutes. For professional users. Particularly suitable for equipment manufacture and production line applications where rapid handling is required.

Conforms to EN 204 Class D4 waterproofing, ensuring it can be used internally and externally and provides a high strength, impact and temperature resistant bond that is usually stronger than the wood itself. As well as bonding all common wood types, SikaBond® 5 minute PU Wood Adhesive will also bond to many other substrates stated in the uses below.

### USES

- Bonds to; wood (hard, soft, painted), Formica, polystyrene foam, PU foam, metal and glass wool, stone, concrete, brick, masonry, and various plastics including PVC to porous substrates.
- Woodworking, joinery and construction uses.
- Window and door frame manufacture.
- Furniture assembly.
- Door assembly.
- General assembly line work.
- Construction of staircases and ladders.
- Interior and exterior use.
- As a high quality insulation adhesive for foam / glass.
- Wool / fibre boarding.

### PRODUCT INFORMATION

Chemical Base

Polyurethane

### CHARACTERISTICS / ADVANTAGES

- Fast setting – 5-minute set (vs typical PVA based wood glues of 8 - 12 hours)
- Fast bond strength development.
- Exceptional bond strength to wood and most common building surfaces.
- Excellent weathering and aging properties for internal and external use.
- Suitable for constant water immersion – D4 classification water resistance.
- Products foam slightly on application to fill small gaps and increase overall bond strength.
- Excellent chemical resistance.

### APPROVALS / STANDARDS

Conforms to EN 204 class D4.

<b>Packaging</b>	Liquid: 1 L Plastic Bottle Gel: 310 mL Cartridge
<b>Colour</b>	Liquid: Brown Gel: Transparent
<b>Shelf Life</b>	12 months from date of manufacture when stored according to manufacturer's instructions.
<b>Storage Conditions</b>	Store in cool, dry conditions between +5 °C to +25 °C. Reseal containers immediately once used or disposal will be necessary.
<b>Density</b>	Liquid: 1.12 g/cm <sup>3</sup> Gel: 1.10 g/cm <sup>3</sup>
<b>Solid Content</b>	100 % (solvent free)
<b>Viscosity</b>	Gel: 200,000 cP Liquid: 2,000 cP

## APPLICATION INFORMATION

<b>Yield</b>	Liquid: Approx. 400 g/m <sup>2</sup> Gel: Approx. 225 – 355 mL/m <sup>2</sup>
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## 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.

## LIMITATIONS

- At least one of the surfaces to be bonded must be porous.
- Not suitable for polyethylene, polypropylene, Teflon or Nylon.
- Surfaces may be damp, but moisture content of wood must not exceed 30 % w/w.
- As product expands slightly on curing, do not use on sheet laminate. Use Stick2 Contact Adhesive.
- Only apply between + 5 and + 30 °C.
- Ensure surfaces are always clamped during use.
- Setting times will be increased at low temperatures and low humidity.

It is the user's responsibility to determine suitability of use. If in doubt, please contact Technical Services department for advice.

## 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

- All surfaces must be clean, dry and free from dust, grease and other contaminants.
- At least one of the materials must be porous.
- Roughen nonporous surfaces to give a key for the adhesive.
- To assist cure and achieve maximum bond strength, slightly moisten one surface with a damp cloth.
- Do not over wet.

### APPLICATION

- Wearing of gloves is recommended.
- Apply adhesive evenly to one surface.
- If necessary, cover large areas with a fine-toothed spreader.
- Assemble parts IMMEDIATELY and clamp for duration of cure (5 - 30 minutes at +20 °C; longer at lower temperatures). After this time, the joint may be easily handled.
- Full and final bond strength will be achieved after 30 minutes.
- These products foam slightly on application to fill small gaps.

### APPLICATION METHOD / TOOLS

#### Cartridge Products:

- Cut tip of cartridge taking care not to damage the thread.
- Fix nozzle, cut to required aperture and apply using standard sealant gun.

### Liquid Products:

- Remove cap, cut spout and apply. Replace cap after use.

### **CLEANING OF TOOLS**

Before curing: SikaBoom® Foam Cleaner or acetone, alternatively Sika® Wonder Wipes.

Post cure: Use mechanical abrasion or a sharp chisel.

### **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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