

# SikaTack<sup>®</sup> Panel

## Panel adhesive for ventilated façades

### Technical Product Data

Chemical base		1-C polyurethane
Colour (CQP <sup>1</sup> 001-1)		Ivory
Cure mechanism		Humidity-curing
Density (uncured) (CQP 006-4)		1.1 kg/l approx.
Non-sag properties		Very good
Application temperature	ambient	5 - 35 °C
Tack-free time <sup>2</sup> (CQP 019-1)		35 min. approx.
Curing speed (CQP 049-1)		see diagram 1
Shrinkage (CQP 014-1)		6 % approx.
Shore A hardness (CQP 023-1 / ISO 868)		45 approx.
Tensile strength (CQP 036-1 / ISO 37)		2.5 N/mm <sup>2</sup> approx.
Elongation at break (CQP 036-1 / ISO 37)		500 % approx.
Tear propagation resistance (CQP 045-1 / ISO 34)		7 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)		2.0 N/mm <sup>2</sup> approx.
Glass transition temperature (CQP 509-1 / ISO 4663)		-40 °C approx.
Service temperature (CQP 513-1)		-40 - 90 °C
	4 hours	130 °C
	1 hour	150 °C
Shelf life (storage ≤ 25 °C) (CQP 016-1)		9 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23 °C / 50 % r.h.

### Description

SikaTack<sup>®</sup> Panel adhesive is a non-sag 1-part polyurethane adhesive of stiff, paste-like consistency that cures on exposure to atmospheric humidity to form a durable elastomer. It is part of a system for the economic, concealed fixing of ventilated façades. With the SikaTack<sup>®</sup> Panel system, façade panels are invisible attached to their normal substructure.

SikaTack<sup>®</sup> Panel adhesive is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

### Product Benefits

- Elastic
- 1-part product, ready to use
- Capable of withstands high dynamic and static stresses
- Vibration and movement absorbing fixing system
- Provides creative opportunities for façade design
- Uniform tension over the whole façade panel (no stress points)
- Weathering resistant
- Bonds well to a wide variety of substrates
- The SikaTack<sup>®</sup> Panel system is approved from "Deutsches Institut für Bautechnik"

### Areas of Application

SikaTack<sup>®</sup> Panel adhesive is suitable for structural joints in ventilated facades between the vertically installed substructure and the façade panel that will be subjected to dynamic and static stresses. Suitable substrates are aluminum (incl. anodized components), wood, fiber cement, ceramic materials and plastics. Seek manufacturer's advice before using on plastics that are prone to stress cracking.

This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



## Cure Mechanism

SikaTack® Panel adhesive cures by reaction with atmospheric moisture. At low temperature the water content of the air is generally lower and the curing reaction proceeds slower (see diagram 1).

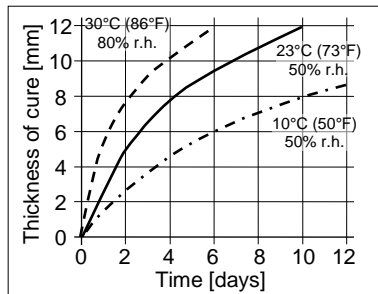


Diagram 1: Curing speed for SikaTack® Panel

## Chemical Resistance

SikaTack® Panel adhesive is resistant to fresh water, seawater, aqueous cleaning solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids, caustic solutions and solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

## Method of Application

### Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. The substructure and the panels must be prepared in accordance with the instructions given for the specific substrates.

Advice on specific applications is available from the Technical Department of Sika Industry.

## Application

Cut off the tip of the nozzle. To ensure uniform thickness of adhesive when compressed, we recommend applying the adhesive in the form of a triangular bead. In order to guarantee a minimum bead dimension of 10 x 3 mm it is to cut the nozzle approx. 10 x 8 mm (see figure 1).

Do not apply at temperatures below 5 °C (40 °F) or above 35 °C (95 °F). The optimum temperature for substrate and adhesive is between 15 °C (60 °F) and 25 °C (77 °F). For cartridge application we recommend the use of a compressed air piston type cartridge gun.

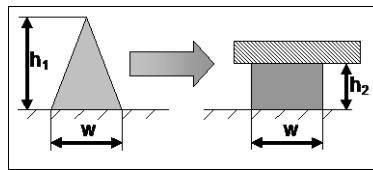


Figure 1: Recommended bead configuration

## Removal

Uncured SikaTack® Panel adhesive may be removed from tools with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towel or a suitable industrial hand cleaner and water. Do not use solvents!

## Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet. Copies of the following publications are available on request:

- Safety Data Sheet
- General Guidelines - Bonding and Sealing with Sikaflex®

## Packaging Information

Cartridge	300 ml
Unipack	600 ml

## Value Bases

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.

## Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets 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.

Further information available at:  
[www.sika.co.uk](http://www.sika.co.uk)

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