

## PRODUCT DATA SHEET

# Sika® Adhesive HF

One-part asphalt modified solvent free urethane adhesive

### PRODUCT DESCRIPTION

Sika Adhesive HF is a highly elastomeric, one-part asphalt modified urethane adhesive that is solvent free and does not require mixing. The VOC content of the adhesive is less than 250 g/L.

### USES

Sika Adhesive HF is designed for use as an adhesive for bonding approved base sheets, vapor retarders, and membranes to approved substrates. The adhesive forms a strong bond to most substrates, does not soften or damage the membrane, and provides outstanding wind uplift protection.

Approved Substrates:

- Concrete
- Lightweight Concrete
- Base Sheets (sanded or smooth surfaced)
- Smooth built-up roof surfaces (re-roof applications)
- Modified Bitumen (sanded or granule surfaced only)
- Metal Panels
- High Density ISO Cover Board
- Wood
- Fiber Glass
- Polyisocyanurate Insulation
- Polystyrene (XPS, EPS)
- Perlite Insulation
- Wood Fiber Insulation
- Gypsum Cover Board

Approved Membranes:

- SBS Modified Bitumen Base Sheets
- SBS Modified Bitumen Mineral Surfaced Cap Sheets

Note: for complete list of approved substrates, or for additional information, contact Sika Technical Field Services Technician

### CHARACTERISTICS / ADVANTAGES

- Single component
- Solvent free
- Elastomeric
- VOC content less than 250 g/L
- Cold applied
- Requires no mixing
- No odors
- Remains flexible, absorbs stresses
- Suitable for use in VOC regulated markets
- No flame, no exposure to oxidized asphalt fumes

## PRODUCT INFORMATION

<b>Packaging</b>	5-gal Pail
<b>Color</b>	Black
<b>Shelf Life</b>	12-Months
<b>Storage Conditions</b>	Store material in original unopened packaging at temperatures between 40°F to 100°F (4°C to 38°C). For best results store material at temperatures between 60°F to 80°F (15°C to 27°C) just prior to use.
<b>Density</b>	0.98 g/cm <sup>3</sup>

## APPLICATION INFORMATION

<b>Coverage</b>	Coverage rate is approximately 1.5 to 2 gallons per 100 sq. ft. (9 m <sup>2</sup> ) when applied with a 1/4" notched trowel which results in an approximately 1/8" (0.3 cm) thick layer of adhesive.  Coverage rates may vary when used over irregular surfaces.  Coverage rate using a Better Spreader type adhesive applicator at 6" o.c. is approximately 2 gallons per 100 sq. ft. (9 m <sup>2</sup> ).
-----------------	---

## BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

## USES

- Do not apply to wet or damp surfaces. This includes primers. Allow solvent based primers to completely dry before using the adhesive.
- Do not apply when surface temperatures are below 40°F (4°C).

## ENVIRONMENTAL, HEALTH AND SAFETY

## APPLICATION INSTRUCTIONS

### EQUIPMENT

- 1/4" (0.6 cm) notched or serrated squeegee
- Better Spreader adhesive applicator

### SUBSTRATE PREPARATION

All work surfaces should be clean, dry, and free of dirt, dust, debris, oils, unadhered coatings, deteriorated membrane or other contaminants that may result in a surface that is not sound or is uneven.

For re-cover applications over weathered asphalt BUR or smooth surfaced SBS modified bitumen, apply

appropriate Sika Primer prior to the application of Sika Adhesive HF.

For applications over fresh and/or non-oxidized asphalt or plastic film membranes, apply appropriate surfaces treatment prior to the application of Sika Adhesive HF.

Note: Contact our Technical Field Services Technicians for a substrate/deck evaluation prior to project start.

### MIXING

No Mixing

### APPLICATION

1. Ensure that the substrate is suitable for bonding and is clean, dry, and free of defects. For dusty surfaces prime the substrate using Millennium Universal Primer at a rate of 150-250 sq.ft. (14 m<sup>2</sup> to 23 m<sup>2</sup>) per gallon. Allow primer to dry.

2. Apply Sika Adhesive HF in full coverage with a 1/4" (0.6 cm) notched or serrated squeegee directly to the substrate. Application rate is 1.5 to 2-gallons per 100 sq. ft. (9 m<sup>2</sup>). Coverage rates may vary over irregular surfaces.

3. Follow roof membrane manufacturers recommendations for installing the membrane into the adhesive. For modified bitumen membranes, unroll the sheet and allow to relax prior to setting into the adhesive.

4. Immediately place the roofing membrane into the freshly applied Sika Adhesive HF. Do not allow the adhesive to skin over. Broom or roll the membrane surface to ensure full contact.
5. If using adhesive to seal laps, a continuous bleed-out of adhesive should be present along all membrane side laps and head laps. Alternatively, heat weld side and head laps.
6. For multi-ply applications remove loose sand from the base ply surface and repeat steps 2-5.
7. When applying adhesive with a Better Spreader type of adhesive application, refer to the membrane/substrate manufacturer's application instructions.

## OTHER RESTRICTIONS

See Legal Disclaimer.

## LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole

remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling 1-800-933-7452.

### Sika Corporation

201 Polito Avenue  
Lyndhurst, NJ 07071  
Phone: +1-800-933-7452  
Fax: +1-201-933-6225  
[usa.sika.com](http://usa.sika.com)



### Product Data Sheet

Sika® Adhesive HF  
April 2025, Version 01.01  
02091579200000034

SikaAdhesiveHF-en-US-(04-2025)-1-1.pdf

