

PRODUCT DATA SHEET

Sikaflex[®]-524

Multi purpose isocyanate free STP adhesive sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Silane Terminated Polymer
Color (CQP001-1)	White
Cure mechanism	Moisture-curing
Density (uncured)	1.6 kg/l
Non-sag properties	Very good
Application temperature	5 — 40 °C (41 — 104 °F)
Skin time (CQP019-1)	25 minutes ^A
Curing speed (CQP049-1)	(see diagram 1)
Shore A hardness (CQP023-1 / ISO 48-4)	45
Tensile strength (ASTM D412)	1.7 MPa (250 psi)
Elongation at break (ASTM D412)	250 %
Tear propagation resistance (CQP045-1 / ISO 34)	25 N/mm (140 pli)
Service temperature (CQP509-1 / CQP513-1)	-40 — 77 °C (-40 — 170 °F)
Shelf life (CQP016-1)	12 months ^B

CQP = Corporate Quality Procedure

^A) 23 °C (73 °F) / 50 % r.h.

^B) stored below 25 °C (77 °F)

DESCRIPTION

Sikaflex[®]-524 is a 1-component, Silane Terminated Polymer (STP) adhesive / sealant. Ideal for securing vertical items, such as flat glass mirror products, in place.

PRODUCT BENEFITS

- Bonds to most interior substrates
- Low odor / Low VOC
- Flexible to allow movement between substrates
- Will not discolor or stain mirror

AREAS OF APPLICATION

Designed for adhering mirrors to multiple substrates such as: Drywall, painted drywall, concrete, wood, brick, tile, and painted steel. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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CURE MECHANISM

Sikaflex®-524 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

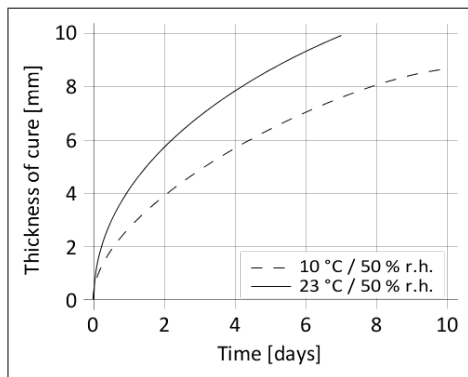


Diagram 1: Curing speed of Sikaflex®-524

CHEMICAL RESISTANCE

Sikaflex®-524 is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-524 can be processed at temperatures (climate and product) between 5 °C and 40 °C (41 °F and 104 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C (59 °F and 77 °F).

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use.

Sikaflex®-524 can be processed with manual, pneumatic or electric driven piston guns.

The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

Tooling and finishing

Tooling and finishing must be carried out within the skin time of the product. Dry tooling is recommended. Do not use soapy water or other liquids when tooling.

Removal

Uncured Sikaflex®-524 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water.

Do not use solvents on skin.

Overpainting

Sikaflex®-524 cannot be overpainted.

Application Limits

For interior use only.

A mechanical support system must be used during and after installation.

Do not use on tar, bituminous or asphaltic based surfaces.

Due to multiple paint types and variances in chemistry, it is recommended to test all paints, safety films, and non-standard mirror products such as painted glass with Sikaflex®-524 prior to application to ensure proper performance.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- General Guideline Bonding and Sealing with 1-component Sikaflex®
- Sika Pre-treatment Chart For Silane Terminated Polymers (STP) – Sikaflex®-500 Series

PACKAGING INFORMATION

Cartridge	295 ml
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BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

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 or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. 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.

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