

PRODUCT DATA SHEET

SikaBond® Mammoth® Crystal

Transparent double-sided construction tape for general-purpose

PRODUCT DESCRIPTION

SikaBond® Mammoth® Crystal is a double-sided, transparent construction tape. It is easy to apply and bonds a broad range of substrates and materials in interior and exterior applications. It is used for bonding various objects such as hooks, hangers, holders for home improvement applications as well as glass partitions, windows and doors frames, signs, cladding panels and many more. It is especially suitable for bonding transparent and translucent materials when an invisible bond line is required.

USES

SikaBond® Mammoth® Crystal is used for bonding the following substrates:

- Glass
- Metals
- Concrete
- Wood
- Many plastics

CHARACTERISTICS / ADVANTAGES

- Crystal clear acrylic foam tape
- Double-sided
- Easy to apply
- Multi-purpose use
- Broad application range
- Replaces mechanical fasteners or liquid adhesives
- Excellent for bonding transparent and translucent materials
- High bonding strength and permanent bonding
- Pressure sensitive, allowing immediate handling strength
- High UV and chemical resistance
- Good anti-vibration and shock absorption properties

PRODUCT INFORMATION

Chemical Base	Adhesive	acrylic
	Carrier	clear acrylic foam
	Release liner	red LDPE
Packaging	plastic cup on paper blister, 34 rolls per box	
Color	Transparent	
Shelf Life	2 years from date of production	
Storage Conditions	The Product must be stored in its original packaging in dry conditions at temperatures between 41 °F (5 °C) and 95 °F (35 °C) and it should be	

protected against direct sunlight. Once removed from its packaging, it should be protected against dust and other impurities. Always refer to the packaging.

Density	62.4 lb/ft ³	
Dimensions	Thickness	0.04 in (1.0 mm)
	Width	0.75 in (19 mm)
	Length	4.92 ft (1.5 m)

TECHNICAL INFORMATION

Lap Shear Strength	24 in/min (22 mm/min)	≈ 35 PSI (150 N/25*25 mm)	(ASTM D1002)
Service Temperature	Maximum	302 °F (+150 °C)	
	Minimum	-40 °F (-40 °C)	
Slant Shear Strength	2.28 psi (1 kg, 25*25 mm)	>2000 h	
Adhesion in peel	180°, 12 in/min	5 lbf/in	(ASTM D3163)

APPLICATION INFORMATION

Ambient Air Temperature	Maximum	95 °F (+35 °C)	
	Minimum	59 °F (+15 °C)	
Cure Time	73 °F (+23 °C)	24 - 72 h	

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.

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.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be sound, clean, dry and free of contaminants such as dirt, oil, grease or tape residues. The substrates to be bonded, should have full contact, using light pressure. To achieve high bond strengths, the adhesive must flow onto the surfaces of the substrates. Depending on the

properties of the surfaces, further preparation methods such as abrasion (e.g. to remove oxidation), priming (e.g. for plastics) or sealing (e.g. for wood or concrete) may be required.

APPLICATION

Test if the substrates to be bonded has full contact, using little to no pressure. Apply the tape in stripes at desired length. For vertical bonding applications apply the tape in vertical orientation. Press or rub the applied tape to ensure full contact with the substrate. Remove the red release liner and place object or second substrate. The strength of the bond strength increases gradually as the adhesive flows onto the bonded surfaces. The increase of the bond strength depends on the tape, the substrates and the temperature. At room temperature, about 50% of the final bond strength will be reached after 30 minutes. The indicated final level of performance will be reached after a bonding period of 24 - 72 h at 73 °F. The higher the temperature, the faster the flow of the adhesive tape.

OTHER RESTRICTIONS

See Legal Disclaimer.

LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION

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 calling SIKA's Technical Service Department at 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.

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Product Data Sheet

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