HOW-TO GUIDE

SikaBond® Mammoth® Crystal

TRANSPARENT, DOUBLE-SIDED CONSTRUCTION TAPE FOR GENERAL-PURPOSE BONDING

MATERIALS:

- 1.5 m (4.92 ft.) roll of SikaBond® Mammoth® Crystal tape
- Scissors or utility knife (optional)
- Mild cleaning agent (for surface preparation)

SITE PREP & PROCEDURE

1. 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.
2. 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.
3. Remove the red release liner and place object or second substrate.
4. 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.