BUILDING TRUST

PRODUCT DATA SHEET

SikaTile®-625 Type 1 Adhesive

PREMIUM TILE ADHESIVE

PRODUCT DESCRIPTION

SikaTile®-625 Type 1 Adhesive is a premium-grade, ready to use, acrylic Type 1 adhesive formulated for reliable interior wall and floor tile installations. Manufactured with high quality organic resins and acrylic polymers, it delivers excellent initial grab and bond strength for setting a wide range of glazed and unglazed ceramic, mosaic, porcelain tile and most gauged stone tile.

USES

SikaTile®-625 Type 1 Adhesive is suitable for bonding the following types of tile and stone:

- Cement-based precast terrazzo
- Impervious porcelain and glass tile
- Natural stone tile
- Vitreous, semi-vitreous or non-vitreous tile: Ceramic, mosaic, quarry, cement body tile

CHARACTERISTICS / ADVANTAGES

- For standard interior wall, floor and countertop installations
- Ideal for setting glazed and unglazed ceramic and porcelain tiles up to 12” x 12” (30 x 30 cm)
- Smooth; easy to trowel
- Quick grab, no slip
- Extended open time
- Zero VOC and Low odor
- Ready to use; no mixing
- Exceeds ANSI A136.1 Type I and II requirements for intermittent water exposure

ENVIRONMENTAL INFORMATION

Sika® is committed to environmental responsibility in both products produced and in manufacturing practices. Complete the LEED Product Data Request Form at SikaTile.com for detailed information based on project location. Use of this product can contribute toward LEED® v4.1 certification:

- Up to 2 points toward MR Credit 5, Regional Materials
- Up to 1 point towards IEQ Credit 4.1, Low-Emitting Materials – Adhesives & Sealants

APPROVALS / STANDARDS

American National Standards Institute (ANSI) — ANSI A108.5, A136.1 type 1 and type 2 of the American National Standards for the Installation of Ceramic Tile
ASTM International (ASTM)

- Tile Council of North America (TCNA) - TCNA Handbook for Ceramic Tile Installation, TCNA EJ171 Movement Joint Guidelines
- ISO 13007: D1TE

PRODUCT INFORMATION

Chemical Base	Synthetic type 1, acrylic based adhesive
Packaging	1 Gallon (3.8 L) and 3.5 Gallon (13.3 L) Pail
Color	Creamy White

Shelf Life	12 months from date of production when stored in original, sealed package
Storage Conditions	Store in undamaged, original, sealed package, in dry conditions at 73° F (23° C)

TECHNICAL INFORMATION

Slant Shear Strength	Shear Strength 7 Day Dry	A136.1	> 50 psi	Pass
	Shear Strength 7 Day Wet Immersion	A136.1	> 50 psi	Pass
	Shear Strength 28 Day	A136.1	> 50 psi	Pass

APPLICATION INFORMATION

Open Time	Open Time	45 Minutes*
	Adjustment Time	45 Minutes*

*Depending on trowel size, temperature, humidity and substrate porosity.

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.

LIMITATIONS

- Do not use SikaTile®-625 Type 1 Adhesive below 40°F (4°C) or above 95°F (35°C).
- Protect from freezing.
- Do not bond directly to hardwood, Luan plywood, particle board, parquet, cushion or sponge-back vinyl flooring, metal, fiberglass, plastic or OSB panels.
- Not recommended for interior and exterior pools and water features.
- When setting moisture-sensitive natural stone, cement or agglomerate tile use SikaTile®-825 Epoxy Grout & Mortar.
- Do not use to install resin-backed stone; use SikaTile®-825 Epoxy Grout & Mortar.
- Recommended floor tile size: 12" x 12” (30 x 30 cm) or less on all sides.
- If dry time is a concern due to tile size or other noted limitations, use a traditional polymer-modified tile mortar instead.
- When installing ceramic plank tile greater than 15"(38.1 cm) long, use a cement mortar designed for large and heavy tile.
- Not recommended for installing tile larger than 6" x 6" (15.2 cm x 15.2 cm) over waterproofing membranes and vinyl flooring.
- Interior use only.
- Do not use for steam rooms, shower floors or submerged applications. For those installations, use Sika’s Polymer-Modified Mortar Systems.
- Not for use over radiant heat systems.
- Installation dry time varies depending on tile size and density, substrate porosity and ambient conditions.
- Do not use to install fixtures, un-gauged natural stone, gauged stone thicker than 3⁄8" (9.5 mm), transparent glass tile, translucent stone, Saltillo pavers or lug back tile on floors.

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

SURFACE PREPARATION

All surfaces must be between 40°F (4°C) to 95°F (35°C) and structurally sound (deflection not to exceed L⁄360 for ceramic and porcelain tiles and L/720 for natural stone), dry, clean, and free from oil, grease, wax, paint, old adhesives, sealers, and curing compounds. Any contaminants that inhibit proper bond must be removed. Substrate preparation should be completed following ANSI A108 AN-2 “General Requirements for Sub-surfaces.” All substrates should be plumb and true; surface deviation should not exceed 1⁄4" in 10’ or 1/8” in 10’ for large format tiles. Patching, leveling or areas requiring a mortar bed should be prepared using Sika® underlayments. Movement (expansion) joints should be provided to comply with TCNA method EJ171. Concrete

must be free of any negative hydrostatic pressure and/or excessive moisture.

SUBSTRATES:

Concrete Substrates: All concrete substrates should be cured a minimum of 28 days and accept water penetration per ASTM F-3191. Test by sprinkling water on various areas of the substrate. If water penetrates, then a good bond can be achieved; if water beads, surface contaminants are present, and loss of adhesion may occur. Contaminants should be mechanically removed before installation. Concrete must be free of efflorescence and not subject to hydrostatic pressure. Smooth steel troweled floors should be roughed up using mechanical chipping, scraping, or shot blasting. Porous dry concrete, and porous backer board must be "SSD" (Surface Saturated with water but, dry to the touch) prior to the application of SikaTile®-625 Type 1 Adhesive.

Gypsum Board Substrates: Gypsum board substrates shall be installed in accordance with manufacturer recommendations and applicable building codes.

Plywood Substrates: Plywood substrates shall be structurally sound, rigid, and meet a maximum allowable deflection of L/360 under combined live and dead loads. The substrate surface receiving tile adhesive shall be exterior-grade plywood only, securely fastened using screw-type fasteners and bonded with construction adhesive where applicable. A perimeter gap of 3/16 in (5 mm) shall be maintained between individual plywood panels and where plywood abuts vertical surfaces to allow for expansion. Plywood substrates shall be limited to interior floor or countertop applications and must be protected from exposure to worksite or in-service moisture prior to installation.

Cementitious Substrates: Concrete, masonry, and plaster substrates shall be fully cured, dimensionally stable, and free of hydrostatic pressure or active water seepage prior to installation. Substrates shall be clean and sound, free of contaminants that may inhibit bond. Uneven or irregular surfaces shall be plumbed or leveled using an appropriate cementitious leveling or patching compound and allowed to cure for a minimum of 48 hours before application of tile adhesive.

Tile Over Tile

Existing ceramic tile surfaces shall be sound, well bonded, and securely adhered to the substrate. All surfaces shall be thoroughly cleaned to remove waxes, sealers, coatings, grease, or other contaminants that may affect adhesion. The existing tile surface shall be mechanically abraded or scarified to create an open, textured profile suitable for bonding prior to application of tile adhesive. Prime with SikaLevel®-02 EZ Primer as directed in the Product Data Sheet found at www.sika.secure.com.

MIXING

Ready to use; no mixing is required.

APPLICATION

Read all installation instructions before installation. Prior to installation, it is recommended that the adhesive be conditioned to a temperature range between 40°F and 80°F (4°C to 27°C). Tile type, size, and substrate conditions will determine the appropriate trowel notch size required to achieve minimum 95% adhesive contact with the tile and an effective adhesive thickness of approximately 1/32 in (1 mm) after embedment.
Apply adhesive using the flat side of the trowel to key the material into the substrate, then immediately comb additional adhesive using the notched side of the trowel in a single direction. In areas subject to moisture exposure, apply a skim coat of SikaTile®-625 Type 1 Adhesive, allow it to dry, and then proceed with adhesive application. Spread only as much adhesive as can be covered with tile before skinning occurs. Remove any skinned adhesive and apply fresh material as necessary. Firmly press tiles into the wet adhesive while moving perpendicular to the trowel ridges to ensure full collapse of ridges, maximum contact, and proper alignment. Periodically lift installed tile to verify complete adhesive transfer and coverage.

MOVEMENT JOINTS:

All expansion, control, construction, cold, saw-cut, isolation, contraction, and seismic joints in the structure should continue through the tilework, including such joints at vertical surfaces, as specified per TCNA Method EJ171 or TTMAC Specification Guide 09 30 00, Detail 301MJ. Do not cover movement joints with adhesive.

CURING:

Product Curing time is affected by ambient and surface temperatures and humidity. Use the following as a guideline.
Under normal conditions of 75 °F (24 °C), tile installations may be grouted after a minimum of 48 hours. Under cooler or high humidity conditions, or when installing vitreous tile larger than 4 in × 4 in (100 mm × 100 mm), extended curing time of up to 72 hours may be required to allow for complete evaporation of excess moisture.
Failure to allow sufficient curing time may result in residual moisture being trapped within the installation, which can adversely affect grout appearance and may cause discoloration or yellowing.

CLEANING OF TOOLS

Clean tools and tile with water before the material dries. Dry adhesive can be removed by scraping or scrubbing pad.

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 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.**

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Sika Corporation
201 Polito Avenue
Lyndhurst, NJ 07071
Phone: +1-800-933-7452
Fax: +1-201-933-6225
usa.sika.com