

PRODUCT DATA SHEET

SikaForce®-100 CT35

1-component adhesive for panel bonding

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Polyurethane
Color (CQP001-1)	Brown
Cure mechanism	Moisture curing
Density (uncured)	1.11 g/cm ³ (9.3 lb/gal)
Consistency	Liquid
Solid content	100 %
Viscosity (CQP029-4)	Rheometer, PP25, shear rate 10 s ⁻¹ , d=1 mm 6200 mPa·s ^A
Application temperature	15 – 30 °C (59 – 86 °F)
Open time (CQP591-1)	15 minutes ^A
Curing time (CQP591-1)	30 minutes ^A
Gross calorific potential (EN ISO 1716)	29.8 MJ/kg
Shelf life	12 months

CQP = Corporate Quality Procedure

^A) 23 °C (73 °F)/ 50 % r.h.

DESCRIPTION

SikaForce®-100 CT35 is a foaming, moisture curing 1-component polyurethane adhesive for bonding sandwich panels and similar constructions of various materials.

PRODUCT BENEFITS

- Good strength at low coat weights
- Highly foaming, expands to fill gaps and to re-inforce
- Better utilization, low waste remaining in packaging
- Easily processed, can be pumped easily
- Solvent free

AREAS OF APPLICATION

SikaForce®-100 CT35 is used primarily for bonding sandwich panels with skin materials of pre-treated or primed aluminum, steel, glass fiber reinforced plastic and core materials of plywood, wood, extruded / expanded polystyrene and mineral wool.

SikaForce®-100 CT35 is well suited for automatic applications.

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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Version 03.01 (03 - 2025), en_US

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CURE MECHANISM

The curing of SikaForce®-100 CT35 takes place by chemical reaction between the adhesive and moisture. Higher temperatures speed up the curing process and lower slow it down.

CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. After the cleaning process, a physical or chemical pretreatment might be required, depending on surface and type of material. The type of pretreatment must be determined by tests. During the curing process, carbon dioxide is released from the adhesive. If none of the substrates are porous, measures need to be taken to allow the carbon dioxide to escape.

Application

Typically a coat weight between 100 g/m² and 300 g/m² (10 g/ft² and 28 g/ft²) is applied, depending on the substrates to be bonded. The specific coat weight for a given substrate combination must be determined by tests.

SikaForce®-100 CT35 is a moisture curing adhesive. A water mist of approx. 10 % of the adhesive coat weight, sprayed either on the adhesive or the bond face, is required.

To prevent curing of the product in the short term, the dosage nozzles for 1-component polyurethane adhesive are typically submerged in a tray filled with SikaForce®-097 Nozzle Oil, when not in use.

For manual application, apply with trowel, spray water mist on the surface and press parts together before the end of the open time.

For support on selecting and setting up a suitable pump system, contact System Engineering Department of Sika Industry.

Pressing

An adequate bonding pressure is necessary to obtain a voidless contact between the substrates and the adhesive. The specific pressure is, however, dependent on the core material and must be determined by tests. The pressure must always be below the maximum compressive strength of the core. After starting the press process, do not release the pressure until the press time has elapsed.

Removal

Uncured SikaForce®-100 CT35 may be removed from tools and equipment with SikaForce®-096 Cleaner. 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.

STORAGE CONDITIONS

SikaForce®-100 CT35 has to be kept between 10 °C and 30 °C (50 °F and 86 °F) in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has to be protected against humidity.

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

PACKAGING INFORMATION

Drum	220 kg
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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.

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.

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