

# SikaTack<sup>®</sup> Plus + SikaBooster<sup>®</sup>-20W

## Fast-curing high-strength adhesive system

### Typical Product Data

Properties	With Booster	Without Booster
Chemical base	Accelerated PUR	1-C polyurethane
Appropriate accelerating paste (Booster)	SikaBooster <sup>®</sup> -20W	
Colour (CQP <sup>1</sup> 001-1)	Black	
Cure mechanism	Moisture-curing <sup>2</sup>	Moisture-curing
Density (uncured) (CQP 006-4)	1.2 kg/l	
Booster content	by volume 2 % (100 : 2) by weight 1.9 % (100 : 1.9)	n. a.
(Tolerance ± 10 %, e.g. 2 % = 1.8 – 2.2 %)		
Non-sag properties	Good	
Application temperature	adhesive 15 – 40 °C	15 – 60 °C
Skin time <sup>3</sup> (CQP 019-1)	n. a.	30 minutes
Open time <sup>3</sup> (CQP 526-1)	5 minutes	n. a.
Curing speed (CQP 049-1)	n. a.	3.5 mm / 24 h
Volume shrinkage (CQP 014-1)	1 %	
Shore A hardness (CQP 023-1 / ISO 868)	50	
Tensile strength (CQP 036-1 / ISO 37)	7 MPa	
Elongation at break (CQP 036-1 / ISO 37)	400 %	
Tear propagation resistance (CQP 045-1 / ISO 34)	12 N/mm	
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	4.5 MPa	
Glass transition temperature (CQP 509-1 / ISO 4663)	-50 °C	
Electrical resistivity (CQP 079-2 / ASTM D 257-99)	10 <sup>8</sup> Ωcm	
Service temperature (CQP 513-1)	-40 – 90 °C	
Shelf life (CQP 016-1) (storage below 25 °C) drum / pail	6 months	
Mixer	Statomix MS 13/18 G mixer from Sulzer	

<sup>1)</sup> CQP = Corporate Quality Procedure    <sup>2)</sup> Moisture provided by SikaBooster<sup>®</sup>-20W    <sup>3)</sup> 23 °C / 50 % r.h.

### Description

SikaTack<sup>®</sup> Plus + SikaBooster<sup>®</sup>-20W is an accelerated 1-component polyurethane adhesive suitable for a variety of industrial bonding applications.

### Product Benefits

- Accelerated adhesive system for fast curing and strength build-up
- Curing speed almost independent of climatic conditions if used with SikaBooster<sup>®</sup>-20W
- Good gap-filling capabilities

### Areas of Application

SikaTack<sup>®</sup> Plus + SikaBooster<sup>®</sup>-20W is an elastic adhesive designed for applications where significant strength build-up within a short period of time is required. It is well suited for direct glazing and bonding of other vehicle parts.

This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



## Cure Mechanism

SikaTack® Plus cures by reaction with atmospheric moisture. When used in conjunction with SikaBooster®-20W, curing proceeds more rapidly and largely independent of atmospheric moisture.

Time [h]	Strength [MPa]
1	0.3
2	1.8
4	> 4

Table 1: Typical lap-shear strength build-up of SikaTack® Plus + SikaBooster®-20W at 23 °C on Sika® Primer-207

## Chemical Resistance

SikaTack® Plus is resistant to fresh water, seawater, and proprietary aqueous cleaning agents; temporary resistant to fuels, mineral oils, vegetable and animal fats; not resistant to organic acids, concentrated mineral acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

## Method of Application

### Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Due to the wide variety of substrate compositions preliminary tests are mandatory.

Advice on specific applications is available from the Technical Department of Sika Industry.

## Application

SikaTack® Plus + SikaBooster®-20W can be processed between 10 °C and 35 °C but changes in reactivity as well as application properties need to be considered. The optimum process temperature (substrates, climate and product) is between 15 °C and 25 °C.

To ensure a uniform thickness of adhesive when compressed, we recommend applying the adhesive in the form of a triangular bead (see figure 1).

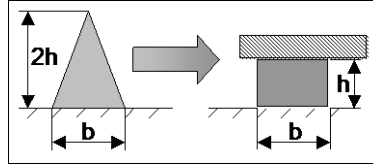


Figure 1: Recommended bead configuration

For advice on selecting and setting up suitable pump systems contact the System Engineering Department of Sika Industry.

## Removal

Uncured SikaTack® Plus 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 should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleaner and water. Do not use solvents on skin!

## Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet. Copies of the following publications are available on request:

- Safety Data Sheets
- General Guidelines - Bonding and Sealing with Sikaflex®

## Packaging Information

### SikaTack® Plus

Pail	23 l
Drum	195 l

### SikaBooster®-20W

Unipack	600 ml
Pail	23 l

## Basis of Product Data

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

## Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## Disclaimer

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:

[www.sika.ch](http://www.sika.ch)  
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