

PRODUCT DATA SHEET

SikaCeram[®]-428 Super Bond T

Multipurpose high performance elastic polyurethane tile adhesive with no vertical slip on deformable surfaces (Type-5 'T'S2, R2T Tile Adhesive)

DESCRIPTION

SikaCeram[®]-428 Super Bond T is a two component, high performance, universal, elastomeric polyurethane resin adhesive used for high adhesion fixing on deformable surfaces with no vertical slip. It is particularly suitable for natural stone and marble sensitive to dampness and on absorbent and non-absorbent substrates. Interior and exterior use.

USES

SikaCeram[®]-428 Super Bond T may only be used by experienced professionals.

- Fixing ceramic tiles of all types and sizes on difficult substrates or ones liable to warp considerably
- Fixing natural stone and marble affected by humidity
- Fixing vitreous mosaic
- Fixing ceramic tiles to kitchen surfaces or work tops, to wood or iron surfaces
- Fixing on heating screeds
- Fixing thin and / or large tiles

CHARACTERISTICS / ADVANTAGES

- Multipurpose
- Good workability
- No creep
- High performance
- Extremely flexible
- Highly thixotropic
- Excellent durability
- Resistant to ageing
- Adhesion to most construction materials
- Suitable for dry wall substrates
- High deformability
- Hardening without shrinkage

APPROVALS / STANDARDS

Conforms to IS 15477-2019 , Type-5 'T'S2 Adhesive
Conforms to EN12004-2 :2017, R2T Class Adhesive

PRODUCT INFORMATION

Chemical base	Polyurethane resin and selected quartz	
Packaging	Part A+B pre-batched	5 kg set
	Part A	4.6 kg container
	Part B	0.4 kg container
Appearance / Colour	Part A+B mixed	White paste
	Part A	White viscous paste
	Part B	Transparent liquid
Shelf life	12 months from date of production	
Storage conditions	The product must be stored properly in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +10 °C	

and +40 °C. Protect from direct sunshine.

Density	Part A+B mixed	~1.60 kg/L	(EN ISO 2811-1)
	Part A	~1.75 kg/L	
	Part B	~1.00 kg/L	
All density values at +30 °C.			

TECHNICAL INFORMATION

Tensile adhesion strength	Test Condition	Requirement as per Standard	Values Observed	(IS 15477-2019)
	Dry condition	≥ 2 N/mm ²	≥ 2.3 N/mm ²	
	Wet condition	No specific requirement mentioned in standard	≥ 1.9 N/mm ²	

* No Tensile Adhesion Strength requirement mandated by EN 12004-2:2017

Chemical resistance	Resistant to many chemicals. Contact Sika Technical Services for additional information.		
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Permeability to liquid water	No penetration and weight gain ≤ 20g (Pass)	(BS EN 14891, A.7 : 2017)
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Slip resistance	Requirement as per Standard	Value Observed	(EN12004-2:2017/IS15477-2019)
	≤ 0.5 mm	≤ 0.35 mm	

Service temperature	-20 °C min. / +80 °C max.
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Transverse deformation	Requirement as per Standard	Value Observed	(IS 15477-2019)
	≥ 5 mm	Highly deformable, > 5 mm (Machine limit reached)	

* No limit specified as per EN12004-2 :2017

Shear Adhesion	Test Condition	Requirement as per Standard	Values Observed	(EN 12004-2: 2017)
	Initial shear adhesion strength	≥ 2 N/mm ²	≥ 3.8 N/mm ²	
	Shear adhesion strength after water immersion	≥ 2 N/mm ²	≥ 3 N/mm ²	
	Shear adhesion strength after thermal shock	≥ 2 N/mm ²	≥ 3.5 N/mm ²	
	After > 20 minutes, open time	≥ 0.5 N/mm ²	≥ 2 N/mm ²	

	Test Condition	Requirement as per Standard	Values Observed	(IS 15477-2019)
	Dry condition	≥ 6 N/mm ²	≥ 6 N/mm ²	
	Wet condition	No specific requirement mentioned in standard	≥ 4 N/mm ²	
	Heat Ageing	≥ 3 N/mm ²	≥ 3 N/mm ²	

APPLICATION INFORMATION

Mixing ratio	Part A : Part B = 92 : 8 (by weight)										
Consumption	Consumption is dependent on the substrate, surface profile, roughness, size of the tiles, the joints between them and application technique (i.e. single spreading / floating method or double spreading / buttering method). Apply product to a test area to calculate the exact consumption for the specific substrate conditions and proposed application. As a guide for a single adhesive layer: <table border="1"><thead><tr><th>Size of tiles</th><th>Notched trowel size</th><th>Consumption</th></tr></thead><tbody><tr><td>Small</td><td>3 mm</td><td>~2.5 kg/m²</td></tr><tr><td>Medium / Large</td><td>6 mm</td><td>~4.5 kg/m²</td></tr></tbody></table> These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level or wastage etc.		Size of tiles	Notched trowel size	Consumption	Small	3 mm	~2.5 kg/m ²	Medium / Large	6 mm	~4.5 kg/m ²
Size of tiles	Notched trowel size	Consumption									
Small	3 mm	~2.5 kg/m ²									
Medium / Large	6 mm	~4.5 kg/m ²									
Layer thickness	Maximum	4.0 mm									
	Minimum	1.5 mm									
	For higher thickness application, please contact Sika Technical Services.										
Ambient air temperature	+10 °C min. / +35 °C max.										
Relative air humidity	65 % max.										
Dew point	Beware of condensation. The substrate and uncured applied product must be at least +3 °C above dew point to reduce the risk of condensation or blooming on the surface of the applied product. Low temperatures and high humidity conditions increase the probability of blooming.										
Substrate temperature	+10 °C min. / +35 °C max.										
Substrate moisture content	≤ 4 % parts by weight The following test methods can be used: Sika®-Tramex meter, CM-measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).										
Pot life	~60 minutes (100 g mass, +30 °C)										
Open time	60 - 80 minutes (In lab conditions)										
Applied product ready for use	Grouting floors / Foot traffic	~24 hours									
	Grouting walls	~12 hours									
	Normal use	~3 days									
	Note: Values are obtained in laboratory condition at +25 °C. Higher temperatures will reduce the indicated waiting time, lower temperatures increase waiting time.										
Adjustability time	60 - 80 minutes (In lab conditions)										

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.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other

safety-related data.

APPLICATION INSTRUCTIONS

EQUIPMENT

MIXING

- Electric single paddle mixer (< 400 rpm) with spiral paddle

APPLICATION

- Notched trowel
- Rubber mallet

SUBSTRATE QUALITY / PRE-TREATMENT

- The substrate can be one of the following materials: Cementitious screed, concrete, plaster, ceramic tiles, cement lime mortars, calcium sulphate screed, gypsum fibre boards, anhydrite screeds, sanded surfaces, metal, rubber, plasterboard, wood, asbestos cement, old ceramic tiles, polystyrene, PVC, linoleum, glass.
- Cementitious substrates must be sufficiently cured and dried (2–6 weeks).
- All substrates must be structurally sound, able to support the weight of the new tiling and provide a firm and securely fixed background.
- Substrates must be clean, dry, free of any loose or friable particles, contaminants such as dust, dirt, oil, wax polish, grease, cement laitance or efflorescence.
- Use adequate mechanical preparation techniques to remove from the substrate, all traces of any materials that could reduce the product's adhesion to the substrate.
- Smooth surfaces must be roughened lightly to improve adhesion.
- To confirm adequate surface preparation and adhesion, carry out a small trial before full application.
- Any small surface defects and variations in level, profile, or around exposed aggregates, prefill and level with Sika MonoTop® to a maximum thickness of 5 mm, applied at least 24 hours before full adhesive application.
- For larger and thicker areas of substrate re-profiling and making good, use suitable mortars from the Sika MonoTop® or SikaCeram® Floor Leveler range.
- Identify cracks in the substrate and seal appropriately with Sikadur® epoxy resins.
- When laying tiles on non-absorbent or substrates with limited absorbency, such as existing ceramic tiles, painted surfaces etc., check these surfaces are all sound, firm and securely bonded. Use suitable degreasing / descaling products to thoroughly and completely clean the substrate.
- For applications in hot climates / environments, or on absorbent substrates, thoroughly pre-dampen the substrate immediately before product application. Avoid any ponding / standing water on the substrate. Surface must not be damp to touch.
- If a waterproofing layer is required under the tiles, cement-based and acrylic-based Sika® waterproofing product / systems must be applied to the substrate before tiling.

MIXING

Important: Mix full units only

Important: Avoid over-mixing to minimise air entrainment.

1. Add Part B (hardener) to Part A (resin).
2. Mix continuously for 3 minutes, until a uniform mix is achieved.
3. During the final mixing stage, scrape down the sides and bottom of the mixing container with a flat or straight edge trowel at least once to ensure complete mixing.

APPLICATION

Important: Apply sufficient adhesive to ensure adequate 'wetting' of the backs of the tiles.

Important: Coverage on the back of the tiles must be > 60 %.

Important: Tiling must be carried out on freshly applied adhesive. Exert adequate pressure to ensure 100 % complete and uniform contact with the adhesive to achieve optimum adhesion.

Important: If a skin forms on the surface of the adhesive, immediately remove the adhesive layer with a trowel, discard material and apply a fresh layer of SikaCeram®-428 Super Bond T adhesive.

Important: Protect freshly applied material from extremely high or low (freezing) temperatures, rain, direct exposure to sun, for at least 12–24 hours from application.

Important: Avoid application in direct sunlight and/or strong wind / draughts.

Note: For tiles > 900 cm² (30 × 30 cm), the double-spreading (buttering) technique is always recommended.

1. Apply sufficient adhesive to the prepared fixing surfaces with the flat side of trowel.
2. Comb additional adhesive with appropriate square notched trowel to the required bed thickness.
3. Wherever needed (for large tiles), back butter the tiles for full bedding.
4. Place tiles into wet, sticky adhesive and use rubber mallet to fully embed the tiles.
5. Adjust tiles if required. Provide support wherever needed.
6. Clean off surplus adhesive from tile face and between tile joints before the adhesive has dried.

CLEANING OF TOOLS

Clean all tools and application equipment with Sika® Thinner C immediately after use. Hardened material can only be mechanically removed.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

LEGAL NOTES

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.

Sika India Pvt. Ltd.

620, Diamond Harbour Road
Commercial Complex II
Kolkata - 700 034
West Bengal, India

Contact:

Phone: +91 33 2447 2448
Fax: +91 33 2397 8688
info.india@in.sika.com
www.sika.in



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