

PRODUCT DATA SHEET

SikaFast®-3123 L20

Low odour structural assembly adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaFast®-3123 L20 (A)	SikaFast®-3123 L20 (B)
Chemical base	2-component acrylate	
Color (CQP001-1)	Pale yellow	Dark green
mixed	Yellow green	
Cure mechanism	Polymerisation	
Density (uncured)	1.10 kg/l	1.10 kg/l
mixed (calculated)	1.10 kg/l	
Mixing ratio	by volume	1 : 1
	by weight	1 : 1
Viscosity	(at 23 °C)	85 000 mPa·s
		85 000 mPa·s
Application temperature	10 – 35 °C	
Open time (CQP526-2)	20 minutes	
Fixing time	(at 23 °C, bead thickness 0.1 mm, lap-shear strength reach 0.1 MPa)	
	30 minutes	
Shore D hardness (CQP023-1 / ISO 868)	56	
Tensile strength (CQP036-1 / ISO 527)	14 MPa ^A	
Elongation at break (CQP036-1 / ISO 527)	100 % ^A	
Tensile lap-shear strength (CQP046-6 / ISO 4587)	18 MPa ^A	
Shelf life	6 months ^B	

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) stored below 25 °C, avoid exposure of direct sunlight

DESCRIPTION

SikaFast®-3123 L20 is low odour, 2-component adhesive system based on acrylate polymer technology.

PRODUCT BENEFITS

- Low odour
- High strength
- Room temperature curing
- Good adhesion to a wide variety of substrates without or limited surface preparation

AREAS OF APPLICATION

SikaFast®-3123 L20 is a flexible structural fast curing adhesive designed to substitute welding, riveting and other mechanical fastening.

SikaFast®-3123 L20 is suitable for high strength fastening of joints on different types of substrates including cold-rolled steel, stainless steel, and aluminium, etc., without or limited surface preparation.

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

CURE MECHANISM

SikaFast®-3123 L20 cures according to radical chain polymerization.

For an ideal curing process, it is required to homogeneously mix both components with the defined ratio. Open and cure time are influenced by mixing ratio deviations as well as temperature. The higher the temperature the shorter the open and cure time and vice versa.

Despite the quick strength build-up, exposure to premature stresses must be avoided since this may result in a reduction of mechanical properties and loss of adhesion.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct project related testing.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly. Due to the diversity of materials, preliminary tests with original substrates are necessary.

Application

SikaFast®-3123 L20 is applied with a mixing ratio of 1:1 by volume from cartridges or bulk packaging. If applied in large masses, heat is generated by the exothermic reaction.

Optimum temperature for the bonding process is between 15 °C and 25 °C. The approved temperature range for substrates and adhesive is between 10 °C and 35 °C. The influence of the reactivity by temperature changes must be respected.

The parts must always be joined within the open time.

SikaFast®-3123 L20 shall be processed with pneumatic or electric driven piston guns as well as pump equipment.

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

Removal

Uncured excess of SikaFast®-3123 L20 can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

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

SikaFast®-3123 L20 (A+B)

Dual cartridge	400 ml
Mixer: OC-MGQ 10-19D	

SikaFast®-3123 L20 (A)

Pail	18 kg
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SikaFast®-3123 L20 (B)

Pail	18 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.

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 enduse 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.

PRODUCT DATA SHEET

SikaFast®-3123 L20
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