

PRODUCT DATA SHEET

SikaTack® OEM

High modulus, fast curing 1-component adhesive for automotive industry

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

| | |
|--|---------------------------------|
| Chemical base | Polyurethane |
| Color (CQP001-1) | Black |
| Cure mechanism | Moisture-curing |
| Density (uncured) | 1.22 kg/l |
| Non-sag properties | Very good |
| Application temperature | adhesive, ambient 10 – 35 °C |
| Skin time (CQP019-1) | 15 minutes ^A |
| Curing speed (CQP049-1) | (see diagram 1) |
| Shore A hardness (CQP023-1 / ISO 48-4) | 70 |
| Tensile strength (CQP036-1 / ISO 527) | 8 MPa |
| Elongation at break (CQP036-1 / ISO 527) | 250 % |
| Tear propagation resistance (CQP045-1 / ISO 34) | 10 N/mm |
| Tensile lap-shear strength (CQP046-1 / ISO 4587) | 5 MPa |
| Shear modulus (CQP081-1) | at 10 % 2 MPa |
| Shelf life | cartridge 9 months ^B |
| | pail 6 months ^B |

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r.h.^{B)} stored below 25 °C in an unopened container
DESCRIPTION

SikaTack® OEM is an elastic 1-component polyurethane adhesive for high modulus assembly bonding applications.

PRODUCT BENEFITS

- 1-component application
- High modulus
- Fast curing
- Very good non-sag properties
- High mechanical strength
- Suitable for automated application

AREAS OF APPLICATION

SikaTack® OEM is typically used for assembly bonding applications. SikaTack® OEM bonds well to a variety of substrates as glass, metals and plastics. SikaTack® OEM is suitable for basic assembly operations without high early strength requirements.

Seek manufacturer's advice and perform tests on original substrates before using SikaTack® OEM on materials prone to stress cracking.

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

CURE MECHANISM

SikaTack® OEM cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

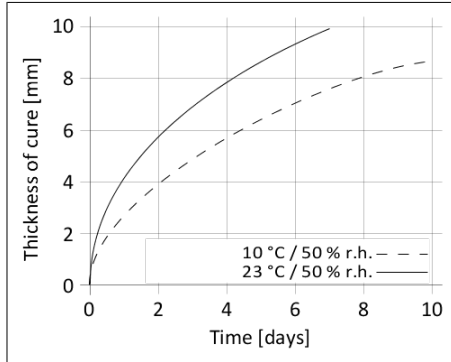


Diagram 1: Curing speed for SikaTack® OEM

CHEMICAL RESISTANCE

SikaTack® OEM is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond.

All pretreatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application

SikaTack® OEM can be processed between 10 °C and 35 °C (adhesive and ambient) but changes in reactivity and application properties have to be considered. The temperature for substrate need to be at least 3 °C above the dew point.

To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

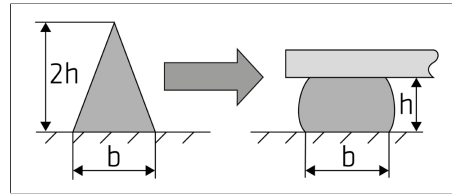


Figure 1: Recommended bead configuration

The skin time is significantly shorter in hot and humid climate. The parts must always be installed within the skin time. Never join bonding parts if the adhesive has built a skin. SikaTack® OEM can be processed with hand, 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 SikaTack® OEM can 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 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
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

| | |
|-----------|--------|
| Cartridge | 300 ml |
| Pail | 23 l |

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

SikaTack® OEM
Version 03.01 (04 - 2024), en_IN
012002210020001100

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