

## PRODUCT DATA SHEET

# SikaBond®-540

SIKABOND®-540 IS A COLD-WATER RESISTANT WOOD ADHESIVE, BASED ON A MODIFIED PVAC-DISPERSION CLASS D3

### DESCRIPTION

SikaBond®-540 is a 1-component water dilutable, moisture resistant, white PVAc-glue that is used without an additional hardener. Fulfills requirements in EN204 according to class D3.

### USES

SikaBond®-540 is especially produced for gluing of wood, where you need high moisture resistance properties, e.g. for constructions like external doors, windows, facings and garden furniture. The glue is not to be used in load bearing structures such as glulam (laminated timber). After drying it will obtain a invisible and transparent glue joint.

### CHARACTERISTICS / ADVANTAGES

- Fulfills requirements in EN204 according to class D3
- Universal use
- Waterbased
- Fast curing
- Stron adhesion to all sorts of wood

### PRODUCT INFORMATION

<b>Composition</b>	PVAc-dispersion
<b>Packaging</b>	250 ml, 750 ml.
<b>Colour</b>	White
<b>Shelf life</b>	Min. 12 months in sealed original packaging.
<b>Storage conditions</b>	Stored free from frost
<b>Density</b>	Approx. 1 100 kg/m <sup>3</sup>
<b>Solid content by weight</b>	Approx. 46%
<b>Resistance to moisture</b>	Fulfills DIN 68602/68603 class D3
<b>Consumption</b>	Approx. 150 g/m <sup>2</sup> on one side.
<b>Open Time</b>	To be joined directly after application, however max. 5 min. open time at +20°C.

## Pressing Time

Depending on the type of wood and temperature, the time it takes for the glue to harden will vary. Woods of harder and fatter origins or materials with tensions can double the time it takes to harden

## APPLICATION INSTRUCTIONS

### APPLICATION METHOD / TOOLS

1. Make sure that the surfaces to be bonded are clean and dry.
2. Shake the bottle containing the adhesive.
3. SikaBond®-540 is spread evenly on one or both surfaces, spreading on both surfaces will give the best strength. Recommended for bonding hard and oily kinds of wood.
4. After the application, the surfaces are pressed together.
5. Keep the pressure until the joint is strong enough for handling. The press time depends on the porosity and moisture ratio of the wood. Furthermore the press temperature will have influence.

### CLEANING OF EQUIPMENT

Wet glue is removed with water. Dried glue is removed mechanically

## 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.

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

## LEGAL NOTES

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Sika Danmark A/S  
Hirsemarken 5  
3520 Farum  
Tlf. +45 48 18 85 85  
www.sika.dk



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