

## PRODUCT DATA SHEET

# SikaTack® Panel

## 1-COMPONENT POLYURETHANE FOR PANEL BONDING IN VENTILATED FACADES

### TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component polyurethane
Color (CQP001-1)	Ivory
Cure mechanism	Moisture-curing
Density (uncured)	1.1 kg/l
Non-sag properties	Good
Application temperature	ambient 5 – 40 °C
Skin time (CQP019-1)	35 minutes <sup>A</sup>
Curing speed (CQP049-1)	(See diagram)
Shore A hardness (CQP023-1 / ISO 48-4)	45
Tensile strength (CQP036-1 / ISO 527)	2.5 MPa
Elongation at break (CQP036-1 / ISO 527)	500 %
Tear propagation resistance (CQP045-1 / ISO 34)	7 N/mm
Service temperature (CQP509-1 / CQP513-1)	-40 – 90 °C
Shelf life	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C / 50 % r. h.<sup>B</sup>) storage below 25 °C

### DESCRIPTION

SikaTack® Panel is a non-sag, 1-component polyurethane of paste-like consistency for structural joints in ventilated facades and interior wall cladding between the vertically installed substructure and the panel that will be subjected to high dynamic and static stresses. It cures on exposure to atmospheric humidity. SikaTack® Panel is part of the SikaTack® Panel system for the economic, concealed fixing of ventilated facades.

### PRODUCT BENEFITS

- Carries DAU 19/114 by ITeC, system for concealed adhesive fixing of opaque external cladding of ventilated façades on aluminium subframes with vertical profiles in new builds and renovations
- Elastic fixing system, vibration and movement absorbing
- Provides creative opportunities for facade design
- Uniform tension over the whole facade panel (no stress points)
- Withstands high dynamic and static stresses
- 1-part product, ready to use
- Bonds well to a wide variety of substrates
- IBU Environmental Product Declaration (EPD) available

### AREAS OF APPLICATION

SikaTack® Panel is suitable for structural joints in ventilated facades and cladded interior walls between the vertically installed substructure and the facade panel that will be subjected to dynamic and static stresses. Suitable substrates are anodized and coated aluminium, metal composite, high pressure laminate and ceramic materials. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

### PRODUCT DATA SHEET

SikaTack® Panel  
Version 05.02 (12 - 2023), en\_DK  
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## CURE MECHANISM

SikaTack® Panel 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).

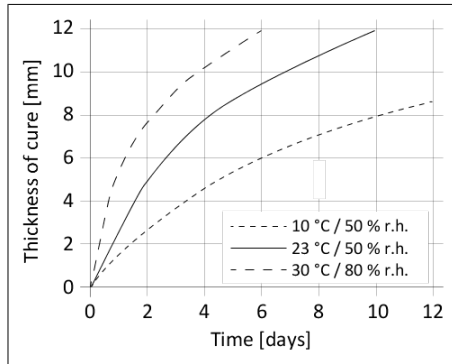


Diagram 1: Curing speed SikaTack® Panel

## 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.

### Application

The standard geometry for bonding façade panels is at least 12 x 3 mm. The supplied nozzle (10 x 8 mm) ensures proper dimension of the compressed bead (see figure below).

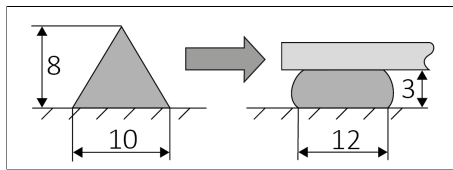


Figure 1: Recommended bead configuration

The optimum temperature for substrate and adhesive is between 15 °C and 25 °C. Do not apply at temperatures below 5 °C or above 40 °C.

To avoid condensation on the surfaces, the temperature of the bonding components (e.g. façade panels, sub-frames) must be at least 3 °C higher than the dew point of the air.

The skin time is significantly shorter in hot and humid climate. The panel must always be installed within 75 % of the skin time determined under local climate conditions (see General Guideline "SikaTack® Panel System"). Never join bonding parts if the adhesive has built a skin. SikaTack® Panel can be processed with hand, pneumatic or electric driven piston guns.

### Removal

Uncured SikaTack® Panel 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.

### Application limits

SikaTack® Panel used for panel bonding is always used in conjunction with SikaTack® Panel Fixing Tape. SikaTack® Panel Fixing Tape ensures the correct joint thickness and keeps the bonded panels initially in place. By curing SikaTack® Panel builds up strength and takes over the long-term load bearing.

SikaTack® Panel Fixing Tape is not a structural component.

### 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 SikaTack® Panel System

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml

## 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

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