

## PRODUCT DATA SHEET

# Sikasil® WT-480

High-modulus, 2-component window bonding adhesive

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

Properties	Sikasil® WT-480 (A)	Sikasil® WT-480 (B)
<b>Chemical base</b>	2-component silicone	
<b>Color (CQP001-1)</b>	White, light grey	Black, dark grey
	mixed Black, grey S6	
<b>Cure mechanism</b>	Polycondensation	
<b>Cure type</b>	Neutral	
<b>Density (uncured)</b>	1.43 kg/l	1.08 kg/l
	mixed 1.40 kg/l	
<b>Mixing ratio</b>	A:B by volume A:B by weight	10:1 13:1
<b>Viscosity (CQP029-6)</b>	1100 Pa·s	250 Pa·s
<b>Consistency</b>	Paste	
<b>Application temperature</b>	ambient 5 – 40 °C	
<b>Snap time (CQP554-1)</b>	35 minutes <sup>A</sup>	
<b>Tack free time (CQP019-3)</b>	180 minutes <sup>A</sup>	
<b>Shore A hardness (CQP023-1 / ISO 48-4)</b>	60	
<b>Tensile strength (CQP036-1 / ISO 527)</b>	2.5 MPa	
<b>100 % modulus (CQP036-1 / ISO 527)</b>	2.0 MPa	
<b>Elongation at break (CQP036-1 / ISO 527)</b>	140 %	
<b>Tear propagation resistance (CQP045-1 / ISO 34)</b>	2.5 N/mm	
<b>Service temperature (CQP513-1)</b>	-40 – 150 °C	
<b>Shelf life (CQP016-1)</b>	15 months <sup>C</sup>	12 months <sup>C</sup>

CQP = Corporate Quality Procedure

<sup>B)</sup> For further values including design values see Calculation Value Sheet<sup>A)</sup> 23 °C / 50 % r. h.<sup>C)</sup> stored below 25 °C
**DESCRIPTION**

Sikasil® WT-480 is a 2-component, neutral-curing structural silicone adhesive with very high modulus, for structural bonding of insulating glass units into window frames and for back-bedding applications.

**PRODUCT BENEFITS**

- Meets requirements of RAL-GZ 716/1
- UV and weathering resistance
- Adheres well to a wide variety of substrates
- Good gap-filling capabilities
- Good mechanical properties with high modulus

**AREAS OF APPLICATION**

Sikasil® WT-480 has a wide adhesion range on many substrates such as glass, (coated) metal, wood, PVC and many other substrates. In combination with its good mechanical properties, especially the high modulus of elasticity, this makes the adhesive most suitable for structural bonding of insulating glass units into window frames and for back-bedding applications. It is further suitable for highly demanding industrial bonding and sealing applications.

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

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Version 07.01 (05 - 2026), en\_DK

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## CURE MECHANISM

Sikasil® WT-480 starts to cure immediately after mixing the two components.

The speed of the reaction depends mainly on the temperature, i.e. the higher the temperature the faster the curing process. Heating above 50 °C could lead to bubble formation and is therefore not allowed.

The mixer open time, i. e. the time the material can remain in the mixer without flushing or extrusion of product, is significantly shorter than the snap time indicated above.

## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond.

### Application

The optimum temperature for substrate and sealant is between 15 °C and 25 °C.

When processing Sikasil® WT-480 both components have to be mixed homogeneously and air-bubble-free in the correct ratio as indicated with an accuracy of  $\pm 10\%$ . Most commercially available metering and mixing equipment are suitable. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Consider that the B-component is moisture-sensitive and must therefore only be exposed briefly to air.

Joints must be properly dimensioned.

Basis for calculation of the necessary joint dimensions are the technical values of the adhesive and the adjacent building materials, the exposure of the building elements, their construction and size as well as external loads.

### Tooling and finishing

Tooling and finishing must be carried out within the snap time of the adhesive.

When tooling freshly applied Sikasil® WT-480, press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents must be used.

## Removal

Uncured Sikasil® WT-480 may be re-moved from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Re-usable, usually metallic, static mixer can be cleaned with Sika® Mixer Cleaner.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water. Do not use solvents on skin.

## Overpainting

Sikasil® WT-480 cannot be overpainted.

## 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 Window Bonding Sikasil® WT Adhesives

## PACKAGING INFORMATION

Sikasil® WT-480 (A)

Pail	26 kg
Drum	260 kg

Sikasil® WT-480 (B)

Pail	20 kg
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Sikasil® WT-480 (A+B)

Cartridge	490 ml
Mixer: MBLTX 14-22G by medmix	

Please contact our customer service, for information of what packaging sizes are sold in Denmark.

## 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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