

## PRODUCT DATA SHEET

# SikaForce®-110 CT55

1-component adhesive for panel bonding

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

Chemical base	Polyurethane
Color (CQP001-1)	Yellowish
Cure mechanism	Moisture curing
Density (uncured)	1.38 g/cm <sup>3</sup>
Consistency	Liquid
Solid content	100 %
Viscosity (CQP029-4)	Rheometer, PP25, shear rate 10 s <sup>-1</sup> , d=1 mm 13 500 mPa·s <sup>A</sup>
Application temperature	15 – 30 °C
Open time (CQP097-1)	50 minutes <sup>A</sup>
Press time (CQP097-1)	110 minutes <sup>A</sup>
Gross calorific potential (EN ISO 1716)	20.5 MJ/kg
Shelf life	IBC 3 months smaller packaging 6 months

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r. h.

**DESCRIPTION**

SikaForce®-110 CT55 is a foaming, moisture curing 1-component polyurethane adhesive for bonding sandwich panels and similar constructions of various materials.

SikaForce®-110 CT55 is tested according to FTP Code system and approved according to the IMO Marine Equipment Directives.

**PRODUCT BENEFITS**

- Long open time
- Low content of isocyanate
- IMO approved

**AREAS OF APPLICATION**

SikaForce®-110 CT55 is used primarily for bonding sandwich panels with skin materials of pre-treated or primed aluminum, steel, glass fiber reinforced plastic and core materials of plywood, wood, extruded / expanded polystyrene and mineral wool.

SikaForce®-110 CT55 is well suited for automatic 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.

## CURE MECHANISM

The curing of SikaForce®-110 CT55 takes place by chemical reaction between the adhesive and moisture. Higher temperatures speed up the curing process and lower slow it down.

## CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. After the cleaning process, a physical or chemical pretreatment might be required, depending on surface and type of material. The type of pretreatment must be determined by tests.

During the curing process, carbon dioxide is released from the adhesive. If none of the substrates are porous, measures need to be taken to allow the carbon dioxide to escape.

### Application

Typically a coat weight between 100 and 300 g/m<sup>2</sup> is applied, depending on the substrates to be bonded. The specific coat weight for a given substrate combination must be determined by tests.

SikaForce®-110 CT55 is a moisture curing adhesive. A water mist of approx. 10 % of the adhesive coat weight, sprayed either on the adhesive or the bond face, is required.

To prevent curing of the product in the short term, the dosage nozzles for 1-component polyurethane adhesive are typically submerged in a tray filled with SikaForce®-097 Nozzle Oil, when not in use.

For manual application, apply with trowel, spray water mist on the surface and press parts together before the end of the open time.

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

## Pressing

An adequate bonding pressure is necessary to obtain a voidless contact between the substrates and the adhesive. The specific pressure is, however, dependent on the core material and must be determined by tests. The pressure must always be below the maximum compressive strength of the core. After starting the press process, do not release the pressure until the press time has elapsed.

## Removal

Uncured SikaForce®-110 CT55 may be removed from tools and equipment with SikaForce®-096 Cleaner. 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.

## STORAGE CONDITIONS

SikaForce®-110 CT55 has to be kept between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has to be protected against humidity.

## 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

## 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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