



AUTHORIZED SIKA DISTRIBUTOR PRODUCT SELECTOR GUIDE FOR PLASTICS

BUILDING TRUST



PLASTIC BONDING AND SEALING

Sika offers a wide range of technologies and products for bonding both polar and non-polar plastics. These could be found in construction and furniture elements, housewares, generic industrial components and machinery. This guide provides general selector guidance. Always consult the most actual Product Data Sheets prior to product usage or consult your Sika contact.

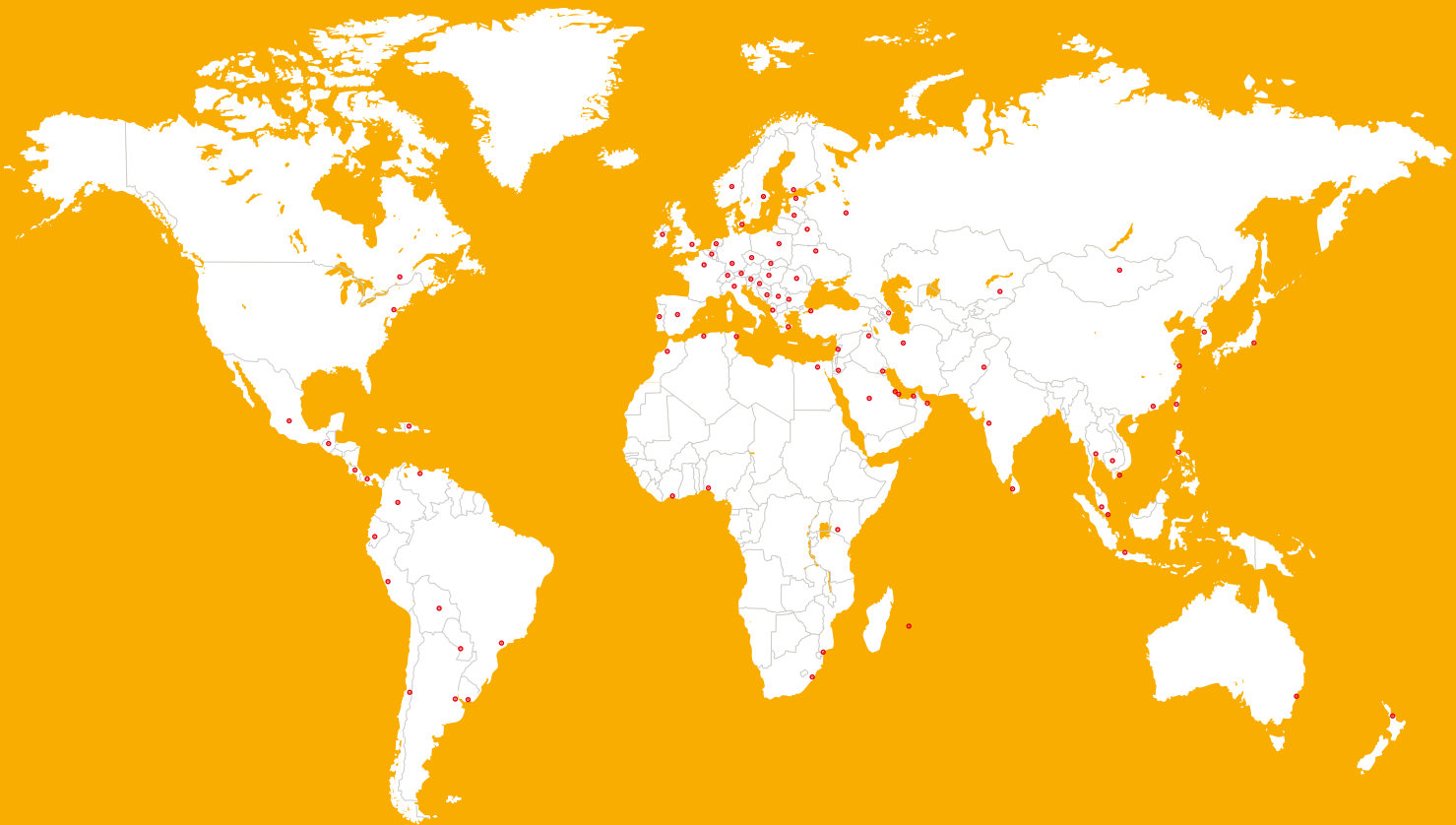
YOUR APPLICATION	Polar plastics (PA, PC, PMMA, ABS, PVC, etc.)				Polyolefin plastics (PE, PP, etc.)			
	Sealing applications	Cold applied adhesive			Hot applied adhesive		Hot applied adhesive	
	UV-resistant joint	Flexible bonding	Multipurpose, fast curing	Gap filling and vertical surfaces	High green strength	Large surface bonding	In combination with moisture permeable substrates	High mechanical strength and flexibility
SIKA SOLUTION	Sikasil® W-605 S	Sikasil® AS-70	SikaFast®-555 L03	SikaForce®-755 L15	SikaMelt®-670	SikaMelt®-677	SikaMelt®-885 IA	SikaMelt®-171
Chemistry	1-component silicone	1-component silicone	2-component acrylic	2-component polyurethane	Polyurethane reactive hot melt	Polyurethane reactive hot melt	Polyolefin reactive hot melt	Polyolefin hot melt
Color	Black, grey, white	Black, grey, white	Grey	Black	White - beige, opaque	Yellow, opaque	Yellow	Honey yellow
Shore hardness	20 A	39 A	50 D	70 A	45 D	-	-	-
Mix ratio	-	-	10:1	2:1	-	-	-	-
Open time / pot life (min) ¹	25	15	3	15	1	5	40 sec.	25 sec.
Tack free time (min)	120	180	9	-	-	-	-	-
Tensile strength (MPa)	1	2.2	11	5	25	9	2.2	3.5
Elongation at break (%)	800	450	200	350	700	500	450	2600
Service temperature (°C)	-40 to +150	-40 to +150	-40 to +80	-40 to +110	-40 to +110	-40 to +110	-40 to +160	-40 to +110

PRODUCT DESCRIPTION	Sikasil® W-605 S	Sikasil® AS-70	SikaFast®-555 L03	SikaForce®-755 L15	SikaMelt®-670	SikaMelt®-677	SikaMelt®-885 IA	SikaMelt®-171
	Sikasil® W-605 S can be used for weather-proofing and sealing applications where durability under severe conditions is required. It is particularly suited as a weather seal for structural glazing, curtain walling and windows.	Sikasil® AS-70 can be used for structural sealant glazing in facades, windows or other building elements. It is perfectly suitable for bonding of photovoltaic and solar thermal modules and other high-demanding industrial applications.	SikaFast®-555 L03 is an acrylic based, fast curing, flexibilized structural, 2-component adhesive. It has a pasty-like consistency allowing for vertical and horizontal, easy and precise application. It is suitable to replace mechanical fixation and provides very good adhesion on various substrates such as metals, plastics, glass and wood. Available also with an open time of 5 min (L05) and 10 min (L10).	SikaForce®-755 L15 is suitable for structural joints that will be subjected to dynamic stresses, where rapid strength development and fast cure is an essential requirement. Seek manufacturers advice before using on transparent plastics that are prone to stress cracking. Available also with an open time of 5 min (L05) and 8 min (L08).	SikaMelt®-670 is a versatile, reactive hot melt assembly adhesive with short open time based on polyurethane. It cures with moisture of the air and forms an elastomer, which is not remeltable. It is suitable for permanent strong bonding of polar polymers like ABS, PC, SMC and PVC, wood, foams, textiles, painted and primed steel.	SikaMelt®-677 is a versatile reactive hot melt adhesive used for lamination as well as for assembly bonding. It cures on exposure to atmospheric humidity and forms a durable elastomer. SikaMelt®-677 is manufactured in accordance with ISO / TS 16949 / ISO 14001 quality assurance system and the responsible care program.	SikaMelt®-885 IA is a versatile, reactive hot melt assembly adhesive with high green strength based on polyolefin. It cures with moisture of the air and forms an elastomer, which cannot be melted anymore. SikaMelt®-9185 IA has excellent adhesion properties on non-polar polymers substrates like polypropylene, polyethylene, wood, textiles, non-woven materials and foams. SikaMelt®-9185 shows good adhesion results on the polar polymeric substrates ABS, PVC, PC and PA. Area applications on substrate combinations like polymer and steel plates, which do not provide moisture permeability to the adhesive layer, are not possible with SikaMelt®-9185 IA.	SikaMelt®-171 is a multipurpose, thermoplastic hot melt assembly adhesive with high green strength. SikaMelt®-171 has excellent adhesion properties on non-polar olefin based substrates like poly-propylene. Therefore it is suitable for permanent bonding on non-polar polymers and wood, textiles, non-woven materials and foams. SikaMelt®-171 shows good adhesion on the polar polymeric substrates ABS, PVC, ABS/PC and PA.

¹Equal to skin time for 1-component and snap time for 2-component technology

*For Sikaflex® grades 2xx and 5xx, please refer to Sika Pretreatment Chart.

GLOBAL BUT LOCAL PARTNERSHIP



LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use 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.

Our most current General Sales Conditions shall apply.
Please consult the Data Sheet prior to any use and processing.



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