

Industry

Technical Service Report

Report-No.:

00024-UK-00001-GR

Date:

06/11/2009

Adhesion of Sikatack Panel to Chromatics Laminate Panel

Customer:

Glass Wall Company

Test-costs:

240 GBP

Requestor:

David Fraser

Distributor Customer:

Distributor Sika:

David Fraser

Sika Limited
Technical Service

Nigel Harris

Gareth Ross

Important Note

This report has been carefully prepared based on the information received in writing. It does however not relieve the user of the product from testing the product's suitability for the intended application and purpose. Our warranty in regard to our products is governed exclusively by our sales condition of which we gladly send you a copy.



Sika Limited

Watchmead / Welwyn Garden City / Herts. AL7 1BQ
Phone: +44 (0)1707 363894/ Fax: +44 (0)1707 329129
e-Mail: harris.nigel@uk.sika.com
Internet: www.sika.co.uk

Tests

Standard adhesion test CQP 033-1

Conclusion

Excellent adhesion was achieved to the aluminium coating on Chromatics Laminate panel with the Sikatack Panel system.

Adhesion of Sikatack Panel to Chromatics Laminate Panel 00024-UK-00001-GR

Tests conducted

CQP 033-1 - Bead adhesion

Cleaner

Sika® Cleaner-205

Charge

0012206960/0419

Primer

SikaTack®- Panel Primer

Charge

0012360685/2299

Adhesive

SikaTack® -Panel

Charge

0012277537

Substrate [Attribute]

Glass Wall Company

[Chromatics Laminate Panel]

Remarks

The Chromatics Laminate panel is a panel of coated annealed glass with an aluminium layer to the rear face. It is to this aluminium rear face that the Sikatack Panel adhesive was applied.

Chromatics Laminate Panel 00024-UK-00001-GR

Panel Table

Tests: CQP 033-1 - Bead adhesion

Substrates:

Chromatics Laminate Panel
Glass Wall Company

PreTreatment	Cleaner	t [min]	Primer	t [min]	Adhesive	Results					
						B	C	H	J	K	L
	Sika® Cleaner-205	10	SikaTack®- Panel Primer	30	SikaTack® -Panel	1	1	1	1	1	1

Notation for the Results

Notation	Exposure
A	1d KLR
B	7d KLR
C	7d WL + 2h KLR
D	7d 40°C/95%rh. + 2h KLR
E	7d 70°C + 1d KLR
F	1d 80°C
G	1d 80°C + 2h KLR
H	3d -30°C + 2h KLR
I	7d 80°C + 2h KLR
J	3d 80°C
K	2h KLR
L	7d CP + 2h KLR
M	7d CP + 1d -30°C + 1d KLR
N	10 cycles VDA
O	20 cycles VDA

KLR = Exposure at 23°C/50%rh acc. to DIN 50'014

WL = Exposure in deionised water at 23°C

CP = Cataplasma at 70°C/100%rh.

VDA = Cycletest acc. to VDA 621-415

xh = x hour(s)

xd = x day(s)

The test results are analyzed as shown in the Table below:

Note	Assessment	Bond
1	Bond satisfactory	> 95% cohesion failure
2	Bond basically satisfactory	> 75% cohesion failure
3	Bond not satisfactory	> 25% cohesion failure
4	Bond not satisfactory	< 25% cohesion failure
L	Failure of paint structure (define failure point)	
P	Primer separates from substrate	
BK	Bubbles in adhesive	
B	Bubbles/voids on the bond surface	
T	Tunnel effect/edge bonding	
K	Adhesive is not cured on the bond surface	
FH	Film bonding	
S	Foam structure on the bond surface (fine bubbles)	
RA	Edge separation	
n	Not tested	

Note:

If no additional designation is given, the failure area (if adhesive) is between the adhesive and the layer applied last. Different failure modes should be described.