

Laboratory Report Adhesion

Date: 27.10.2008

Project #: WN30733/08

Test costs: CHF 750.-

Project name: Adhesion test

Location: -

Customer: Pilkington Plyglass, England

Date samples received: 23.09.2008

Description of samples received and adhesion testing:

(according to CQP 033-1, CQP 034-1 and CQP 555-1; CQP = Sika Corporate Quality Procedure)

No	Sample:	1 st Pretreatment Step:	2 nd Pretreatment Step:	3 rd Pretreatment Step:	Sealant / Adhesive:	Results:
1.	Glass coated Graphite BS 18B25	Sika® Cleaner P	-	-	Sikasil® SG-500	1 -
2.		Sika® Cleaner-205	-	-	Sikasil® SG-500	1 -
3.		Sika® Cleaner P	-	-	Sikasil® IG-25	1 -
4.		Sika® Cleaner-205	-	-	Sikasil® IG-25	1 -
5.		Sika® Cleaner P	-	-	Sikasil® IG-25 HM	1 -
6.		Sika® Cleaner-205	-	-	Sikasil® IG-25 HM	1 -

Additional Remarks:

The adhesion of Sikasil® SG-500, IG-25 and IG-25 HM to the submitted samples was excellent under aforementioned conditions.

1	>95% cohesive failure
2	>75% cohesive failure
3	>25% cohesive failure
4	<25% cohesive failure
5	0% cohesive failure
L	Paint/substrate rupture
P	Primer failure
BK	Bubbles in adhesive
B	Bubbles on substrate surface
T	Tunneling
K	Uncured adhesive on surface
FH	Film adhesion
S	Foam structure on surface
RA	Separation on the edges

Approved by:



(Ulli Müller, Product Engineer)
Market Field Façade, Fenestration & Insulating Glass



(Felix Fischer)
Market Field Façade, Fenestration & Insulating Glass

Important note:

The information contained herein and any other advice 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. The information only applies to the application(s) and product(s) expressly referred to herein. In case of changes in the parameters of the application, such as changes in substrates etc., or in case of a different application, consult Sika's Technical Service prior to using Sika products. The information contained herein is only provided with the purpose of providing the user with additional information as to Sika's products. It does not relieve the user of the products from testing them for the intended application and purpose. All orders are accepted subject to our current terms of sale and delivery. Users should 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.



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1.	Glass coated Harmony Bronze BS 08B27	Sika® Cleaner P	-	-	Sikasil® SG-500	1 -
2.		Sika® Cleaner-205	-	-	Sikasil® SG-500	1 -
3.		Sika® Cleaner P	-	-	Sikasil® IG-25	1 -
4.		Sika® Cleaner-205	-	-	Sikasil® IG-25	1 -
5.		Sika® Cleaner P	-	-	Sikasil® IG-25 HM	1 -
6.		Sika® Cleaner-205	-	-	Sikasil® IG-25 HM	1 -

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No	Sample:	1 st Pretreatment Step:	2 nd Pretreatment Step:	3 rd Pretreatment Step:	Sealant / Adhesive:	Results:
1.	Glass coated, red	Sika® Cleaner P	-	-	Sikasil® SG-500	1 -
2.		Sika® Cleaner-205	-	-	Sikasil® SG-500	1 -
3.		Sika® Cleaner P	-	-	Sikasil® IG-25	1 -
4.		Sika® Cleaner-205	-	-	Sikasil® IG-25	1 -
5.		Sika® Cleaner P	-	-	Sikasil® IG-25 HM	1 -
6.		Sika® Cleaner-205	-	-	Sikasil® IG-25 HM	1 -

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