

## PRODUCT DATA SHEET

Sikaflex<sup>®</sup>-112 Crystal Clear

TRANSPARENT ADHESIVE AND SEALANT

**DESCRIPTION**

Sikaflex<sup>®</sup>-112 Crystal Clear is a 1-part, multipurpose transparent adhesive and sealant with good initial grab which bonds and seals most construction material substrates. Internal and external use.

**USES**

An adhesive to bond most construction components and materials such as:

- Concrete
- Masonry
- Most stones
- Ceramic
- Wood
- Metals
- Glass
- PVC

A sealant to seal around bonded components.

**CHARACTERISTICS / ADVANTAGES**

- 100 % transparent
- Good initial grab
- Very low emissions
- Adhesive-sealant with CE marking

**ENVIRONMENTAL INFORMATION**

- Conformity with LEED v4 EQc 2: Low-Emitting Materials
- VOC emission classification GEV-EMICODE EC 1<sup>PLUS</sup>
- Class A+ according to French Regulation on VOC emissions

**APPROVALS / STANDARDS**

- CE Marking and Declaration of Performance to EN 15651-1 - Sealants for non-structural use in joints in buildings - Facade elements: Class F EXT-INT 20HM

**PRODUCT INFORMATION**

<b>Chemical base</b>	Silane terminated polymer	
<b>Packaging</b>	290 ml cartridge, 12 cartridges per box	
<b>Colour</b>	Transparent	
<b>Shelf life</b>	12 months from the date of production	
<b>Storage conditions</b>	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +25 °C. Always refer to packaging.	
<b>Density</b>	~1,05 kg/l	(ISO 1183-1)

**TECHNICAL INFORMATION**

<b>Shore A Hardness</b>	~48 (after 28 days)	(ISO 868)
<b>Tensile Strength</b>	~2.5 N/mm <sup>2</sup>	(ISO 37)

<b>Elongation at Break</b>	~400 %	(ISO 37)
<b>Tear Propagation Resistance</b>	~4.0 N/mm	(ISO 34)
<b>Service temperature</b>	-40 °C min. / +70 °C max.	
<b>Joint Design</b>	<p>The joint width must be designed to suit the movement capability of the sealant. The joint width must be <math>\geq 6</math> mm and <math>\leq 20</math> mm. A width to depth ratio of 2:1 must be maintained.</p> <p>Joints <math>\leq 10</math> mm in width are generally for crack control and therefore non-movement joints.</p> <p>For larger joints contact Sika Technical Services for additional information.</p>	

## APPLICATION INFORMATION

<b>Yield</b>	1 Cartridge (290 ml)	
	<b>Yield</b>	<b>Dimension</b>
	~100 spots	Diameter = 30 mm
	~15 m bead	Thickness = 4 mm
		Nozzle diameter = 5 mm
		(~20 ml per linear meter)
<b>Backing Material</b>	Use closed cell polyethylene foam backing rods.	
<b>Sag Flow</b>	0 mm (20 mm profile, 23 °C)	(ISO 7390)
<b>Ambient Air Temperature</b>	+5 °C min. / +40 °C max.	
<b>Substrate Temperature</b>	+5 °C min. / +40 °C max., min. 3 °C above dew point temperature	
<b>Curing Rate</b>	~3 mm/24 h (23 °C / 50 % r.h.)	Sika Corporate Quality Procedure(CQP 049-2)
<b>Skin time</b>	~10 min (23 °C / 50 % r.h.)	(CQP 019-1)

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

The substrate must be sound, clean, dry and free of all contaminants such as dirt, oil, grease, cement laitance, old sealants and poorly bonded paint coatings which could affect adhesion of the adhesive / sealant. The substrate must be of sufficient strength to manage with the stresses induced by the sealant during movement.

Removal techniques such as wire brushing, grinding, sanding or other suitable mechanical tools can be used.

All dust, loose and friable material must be completely removed from all surfaces before application of any activators, primers or adhesive / sealant.

For optimum adhesion, joint durability and critical, high performance applications the following priming and/or pre-treatment procedures must be followed:

#### Non-porous substrates

Aluminium, anodised aluminium, stainless steel, galvanised steel, powder coated metals or glazed tiles, slightly roughen surface with a fine abrasive pad. Clean and pre-treat using Sika® Aktivator-205 applied with a clean cloth.

Before bonding / sealing, allow a waiting time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, clean and pre-treat using Sika® Aktivator-205 applied with a clean cloth. After a waiting time of > 15 minutes

(< 6 hours). Apply Sika® Primer-3 N applied by brush. Allow a further waiting time of > 30 minutes (< 8 hours) before bonding / sealing.

PVC has to be cleaned and pre-treated using Sika® Primer-215 applied with a brush. Allow a waiting time of > 15 minutes (< 8 hours) before bonding / sealing.

#### Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks, prime surface using Sika® Primer-3 N applied by brush.

Before bonding / sealing, allow a waiting time of > 30 minutes (< 8 hours).

For more detailed advice and instructions contact Sika Technical Services.

Note: Primers are adhesion promoters and not an alternative to improve poor preparation / cleaning of joint surfaces. Primers also improve the long term adhesion performance of a sealed joint.

### APPLICATION METHOD / TOOLS

#### Bonding Procedure

After the necessary substrate preparation, prepare the end of the cartridge before or after inserting into the sealant gun then fit the nozzle.

Apply in beads, strips or spots at intervals of a few centimetres each. Use hand pressure only to fix the components to be bonded into position before skinning of the adhesive occurs. Incorrectly positioned components can easily be unbonded and repositioned during

the first few minutes after application. If necessary, use temporary adhesive tapes, wedges, or supports to hold the assembled components together during the initial curing time.

Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be reached after complete curing of Sikaflex®-112 Crystal Clear, i.e. after 24 to 48 hours at +23 °C, depending on the environmental conditions and adhesive layer thickness.

## Sealing Procedure

### Masking

It is recommended to use masking tape where neat or exact joint lines are required. Remove the tape within the skin time after finishing.

### Joint Backing

After the required substrate preparation, insert a suitable backing rod to the required depth.

### Priming

Prime the joint surfaces as recommended in substrate preparation. Avoid excessive application of primer to avoid causing puddles at the base of the joint.

### Application

Prepare the end of the cartridge before or after inserting into the sealant gun then fit the nozzle. Extrude Sikaflex®-112 Crystal Clear into the joint ensuring that it comes into full contact with the sides of the joint and avoiding any air entrapment.

### Finishing

As soon as possible after application, sealant must be firmly tooled against the joint sides to ensure adequate adhesion and a smooth finish. Use a compatible tooling agent (e.g. Sika® Tooling Agent N) to smooth the joint surface. Do not use tooling products containing solvents.

## CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208. Once cured, hardened material can only be removed mechanically. For cleaning skin use Sika® Cleaning Wipes-100.

## FURTHER DOCUMENTS

Pre-treatment Sealing and Bonding Chart

## LIMITATIONS

- For good workability, the adhesive temperature must be +20 °C.
- Application during high temperature changes is not recommended (movement during curing).
- Before bonding, check adhesion and compatibility of paints and coatings by carrying out preliminary trials.
- Sikaflex®-112 Crystal Clear can be overpainted with most conventional water-based coating and paint systems. However, paints must first be tested to ensure compatibility by carrying out preliminary trials.

The best over-painting results are obtained when the adhesive is allowed to fully cure first. Note: non-flexible paint systems may impair the elasticity of the adhesive and lead to cracking of the paint film.

- Colour variations may occur due to the exposure in service to chemicals, high temperatures and/or UV-radiation (especially with white colour shade). This effect is aesthetic and does not adversely influence the technical performance or durability of the product
- Always use Sikaflex®-112 Crystal Clear in conjunction with mechanical fixings for overhead applications or heavy components.
- For very heavy components, provide temporary support until Sikaflex®-112 Crystal Clear has fully cured.
- Full surface applications / fixings are not recommended since the inner part of the adhesive layer may never cure.
- Before using on natural stone, contact Sika Technical Services.
- Do not use on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might leach oils, plasticisers or solvents that could degrade the adhesive.
- Do not use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE / Teflon) and certain plasticised synthetic materials. Preliminary trials must be carried out or contact Sika Technical Services.
- Do not use to seal joints in and around swimming pools.
- Do not use for joints under water pressure or for permanent water immersion.
- Do not use to seal glass or in floor or sanitary joints.
- Do not use for bonding glass if the bond line is exposed to sunlight.
- Do not use for structural bonding.
- Do not expose uncured Sikaflex®-112 Crystal Clear to alcohol containing products as this may interfere with the curing reaction.

## BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

## 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.

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