

SikaBond® 542 ID

Water Based Adhesive for Full Surface Bonding of PVC, Vinyl, MDF and HPL Film

Product Description	Sikabond® 542 ID is a one part, water based adhesive
Uses	SikaBond® 542 ID is an adhesive for PVC sheet or film of which main components are Copolymerized Emulsion of Ethylene Vinyl acetate and exhibits the excellent capacity mainly on the production of PVC Overlay Plywood, MDF , HPL film.
Characteristics / Advantages	<ul style="list-style-type: none"> ■ One part, easy to use. 1 part adhesive , ready to use ■ Very easy to apply ■ High strength ■ Good Water Resistance ■ Suitable for many types of vinyl and laminate floor
Test	
Test Method	5 days after application completed.
Test Condition	
Dry Strength	After aging at the room temperature , measure peel strength at 20 ± 2°C and 60 ± 5% RH (Unit :kgf/25mm)
Water Resistance	Immerse the sample in water (room temperature) for 24 hours and then measure peel strength immediately (Unit : kgf/25mm)
Heat creep resistance	Measure a creep length after being left 0.5 , 1.0 , 3 hours with 500 g static loading per 25mm width at 60 °C.
Product Data	
Form	
Colour	White Brownish
Packaging	10 kg pail can
Storage	
Storage Conditions / Shelf Life	6 months from the date of production if stored in undamaged and unopened original sealed containers, in dry conditions and protected from frost and direct sunlight at temperature between +10°C and +25 °C.



Technical Data

Chemical Base 1 part adhesive , eva modified, water based (pH-value 4.0 ~ 6.0)

Viscosity (mpa.s, 30°C) 40,000 ~ 55,000

Solid Content 53 ~ 57

Machinery Stability Stable

Drying Film Opaque

Skimming / Laying Time Closed assembly time is within 30 minutes.

Service Temperature over 10°C

System Information

Application Details

Consumption / Yield 110 to 130 g/ m² of adhesive (on MDF , HPL)
Consumption will vary dependent on the type of substrate and the type of timber floor.

Substrate Quality

Concrete / cementitious screed

Clean and dry, homogenous, even , free from oils and grease, dust and loose or friable particles

Paint, laitance and any other poorly adhering materials must be removed. Only for cementitious substrates. Standard construction rules must be observed.

Must be mechanically prepared as necessary to achieve the substrate quality and thoroughly vacuumed.

Application Instructions

Application Method /

Sikabond® 542 ID is applied to the prepared substrate directly from the pail and uniformly distributed by roll spreader without diluting.

Tools

- Apply 100 to 130 g/m² of adhesive (MDF, HPL).
- Cover with plastic sheet after application immediately.
- After plastic sheet is covered, press plastic sheet and plywood (MDF, HPL) with rubber roller. (Rubber hardness is 50 to 60 is desirable)
- Curing time is within 20 minutes.
- Working temperature is +10 °C.

Cleaning of Tools

Clean all tools and application equipment with water immediately after use. Cured material can only be mechanically removed.

Notes of Application / Limitations

- Sikabond® 542 id is only suitable for use by experienced applicators
- For optimum workability the adhesive temperature must be at least + 10 °C.
- Not suitable for laminated floor / vinyl in non insulated areas such as basements, or other areas without a damp proof membrane.
- Uneven substrates must be properly prepared and leveled out in order to avoid an accumulation of dispersion adhesive.
- Some primers can negatively influence the adhesion of Sikabond® 542 ID.
- The adhesive is not to be diluted.
- Do not expose the adhesive directory to the sunshine and keep it at above 0 °C to prevent from freezing in winter.
- After use, be sure to close the adhesive container tightly.
- Sikabond 542 id has the high performance for plastic sheet lamination, its have fast setting & good spreadability. However, the performance is due to bonding conditions and materials such as PVC sheets, Olefin sheets MDF (type, shape, etc).
- A spreader is generally used to apply the adhesive. Do not allow the equipment to operate in a no-load condition for an extended period of time. If the equipment is operated for the adhesive left on the spreader for a prolonged period (such as during lunch break), the adhesive can be thicken , and this can reduce the bonding performance for gluing a vinyl chloride sheet.
- Avoid strong vibration during curing of the adhesive (i.e too early walking on, or tapping the floor before the adhesive is fully cured)
- After the pressing process is completed, it is recommended to allow at least three days for curing before cutting or performing other processing.



Value Base	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 performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.
Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.
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