

## **TDS – TECHNICAL DATA SHEET**

**HIMACS EXTERIA FACADE 2022 APPENDIX C**

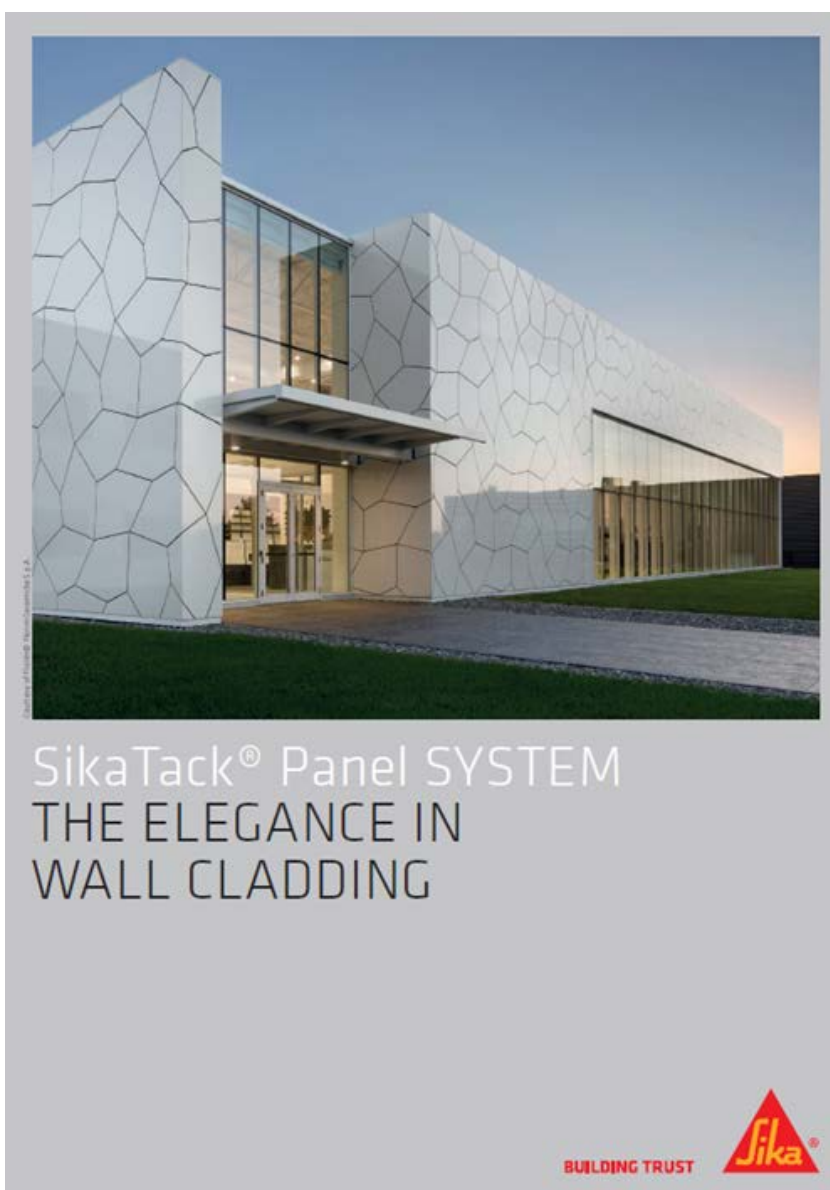
**- Cladding / Fixing System - Bonding II (SIKA)**



## ■ Cladding System Solutions (Cladding / Fixing System / Bonding)

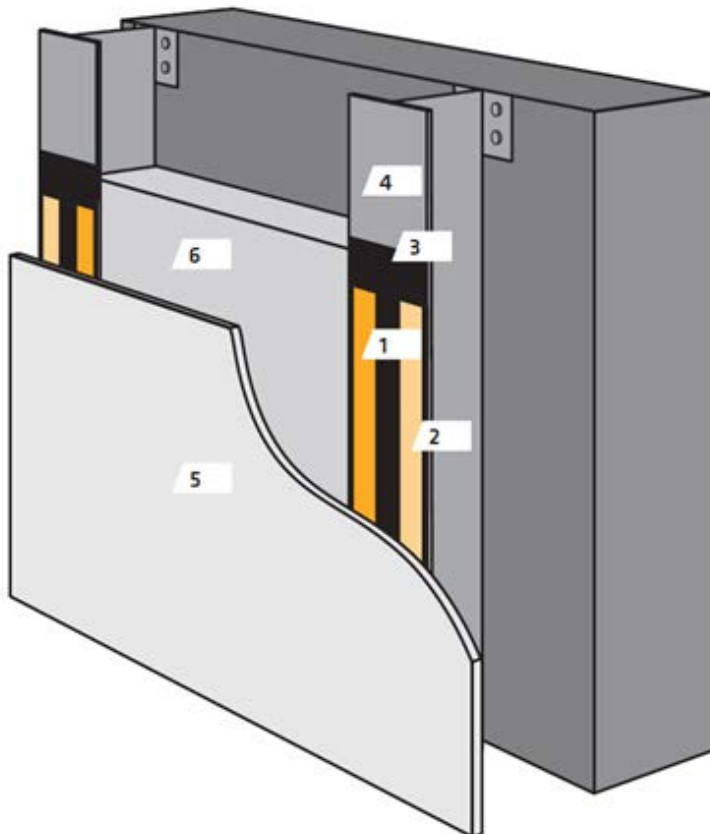
### HIMACS bonding

Please check with your local building authority which approvals are required to use the HI-MACS Exteria® System in conjunction with INNOTEC in a construction project.



► For further details visit [www.sika.de](http://www.sika.de)

### HIMACS bonding with "SIKA Tack Panel System"



- 1 SikaTack® Panel Adhesive – One-part moisture curing and structural adhesive
- 2 SikaTack® Panel Tape – Closed-cell PE foam core with pressure-sensitive adhesive for panel pre-fixation
- 3 SikaTack® Primer – pigmented, solvent-based adhesion promoter
- 4 Aluminium Rail System
- 5 Facade Panel
- 6 Insulation Material (e.g. mineral wool)

In any circumstances we recommend to contact the local SIKA distributor or Sika technical support for best practice and use of SIKA Tack Panel-System

► For further details visit [www.sika.de](http://www.sika.de)

## HIMACS bonding with “SIKA Tack Panel System”

### FOR INTERIOR AND EXTERIOR WALL CLADDING

With the SikaTack® Panel Adhesive System, cladding finishes can be fixed to a carrier frame which allows the designer the freedom to design without any unsightly fixings. The permanent elastic nature of SikaTack® Panel Adhesive System combined with a tenacious adhesion to a variety of panel substrate types accommodates the natural differential movements of varying building materials for the life of most panel types. This ingenious and simple system offers both the designer and installer alike many advantages over comparable mechanical secret fixing systems. SikaTack® Panel Adhesive System is suitable for the fixing of composites, ceramic, high pressure laminate, as well as many metal and powder coated substrates.

### FOR BOTH NEW BUILD AND REFURBISHMENT, THERE ARE MANY BENEFITS RELATED TO THE SikaTack® Panel SYSTEM.

Rain can be forced through the joints and openings of a typical building facade through the action of wind or via external and internal pressure differences. Ventilated rainscreen cladding overcomes these potential problems by utilizing the phenomena of pressure equalization. The principle of pressure equalization offered by a rainscreen cladding system ensures the weather tightness of the building structure by eliminating the methods of which rain may enter the facade. Rainscreen cladding is a tried and tested concept backed up with many years' experience in the development of relatively easily installed lightweight systems that are currently available.

### FOR VENTILATED RAINSCREEN CLADDING

- ☐ Aesthetically pleasing – no screws or rivets are visible
- ☐ Elastic bonding – uniform tension over the whole panel and therefore no deflection of panels
- ☐ Extremely cost effective due to fast and economical installation
- ☐ Adhesive layer prevents galvanic corrosion
- ☐ Increased thermal performance on exterior wall
- ☐ Approval by German Building Authority DIBT and British BBA
- ☐ Over 20 years experience and global references
- ☐ One mounting system for most type of panel

SikaTack Panel System has up to 40% less cost in comparison to hidden mechanical fixation.

## HIMACS bonding with “SIKA Tack Panel System”

THE SikaTack® Panel SYSTEM comprises of SikaTack® Panel Adhesive and SikaTack® Panel Fixing Tape besides appropriate surface pretreatment agents.

The double sided adhesive tape is used for the temporary support of cladding panels for cladding panels while the SikaTack® Panel Adhesive cures. SikaTack® Panel Adhesive is moisture-curing single component polyurethane resin based adhesive, capable of withstanding extreme dynamic and static loads and climatic conditions. Once cured, the adhesive remains permanently elastic to accommodate differing thermal expansion of various building substrates. It eliminates stress fatigue at corners of panels and prevents cold bridging.

For calculations of the glue line, depending on the weight and sizes of panels, maximal wind load and temperature difference, please contact your Sika FFI Competence Center.

### SikaTack® Panel SYSTEM ADHESIVES

	SikaTack® Panel Adhesive	SikaTack® Panel-10	SikaTack® Panel-50
Base	One-part polyurethane moisture curing structural adhesive	One-part polyurethane moisture curing structural adhesive	One-part silicone moisture curing structural adhesive
Typically used	Exterior wall cladding for opaque panels.	Interior and exterior wall cladding for opaque panels	Exterior wall cladding for opaque panels especially porous cement based panel and for printed and enameled coated glass.
	Certified and approved by German Building Authority DIBT and British BBA		EN Approval, Fire Approval
Colour	Ivory	Ivory	Grey S6
Packaging	300 ml cartridge 600 ml unipack	600 ml unipack	600 ml unipack
Skin time	20 min.	45 min.	15 min.
Shelf Life	9 months	12 months	9 months
Service Temperature	-40 – 90°C (-40 – 195°F)	-40 – 90°C (-40 – 195°F)	-40 – 150°C (-40 – 300°F)

### SikaTack® Panel SYSTEM ACCESSORIES

The product	Use	Color	Packaging	Shelf Life
SikaTack® Panel Fixing Tape	Closed-cell PE foam core with pressure-sensitive adhesive for panel pre-fixation	Anthracite	Rolls 33 m Thickness 3 mm, Width 12 mm	24 months
SikaTack® Panel Primer	Pigmented, black primer	Black	1 liter can	9 months
Sika® Aktivator-205	Adhesion promoter	Clear	250 ml, 1 liter can	12 months
Sika® Remover-208	Remover for uncured adhesive	Clear	250 ml, 1 liter, 5 liters can	24 months

## HIMACS bonding with "SIKA Tack Panel System"

### Application Steps

1



A well prepared working place is important for working with adhesives.  
Mark precisely where the first panel must be bonded on the substructure, or use a reference fixed on the substructure.

Make notes for your record with all relevant informations.

Ambient Temperature 5 – 35°C (40 – 95°F).

2



The surface to be bonded must be clean, dry and free from grease. Abrading with an abrasive pad (grain 80) on the panel and the substructure when recommended for the specific system.

Ask Sika representative or the panel supplier for specific advice on pre-treatment steps.

3



Remove dust with a lint-free paper towel or cleaning paper.

4



Activate the bond faces with Sika® Aktivator-205. Use a clean lint-free paper towel or cleaning paper and wipe in one direction only (dirty cloths must be replaced).

Allow a flash off time of 10 minutes.

5



Shake SikaTack® Panel Primer thoroughly (the movement of the steel balls in the container must be clearly audible). Apply one thin coat of SikaTack® Panel Primer uniformly over the whole surface with a felt pad.

Allow a flash off time of at least 30 minutes.

6



Apply SikaTack® Panel Fixing Tape over the whole length of the vertical sections and parallel to the edges.

Do not pull off the protective foil at this time.



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7



Apply SikaTack® Panel Adhesive in a triangular bead by using the triangular nozzle supplied (width 8 mm, height 10 mm) with at least 5 mm gap to the fixing tape and to the side of the batten.

8



Remove the protective foil on the SikaTack® Panel Fixing Tape.

9



Place the cladding panel in the required position first, without the panel touching the fixing tape. After press it firmly until it touches the SikaTack® Panel fixing tape.

FOR FULL APPLICATION INSTRUCTIONS PLEASE REFER TO THE LATEST PRODUCT DATA SHEET AND THE GENERAL GUIDLINE FOR SikaTack® Panel SYSTEM.



Application video  
SikaTack® Panel

Exterior Solid Surface Material

# HI·MACS

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