



A SIKA BRAND

PRODUCT DATA SHEET

Casco[®] XtremFix +

STRONG MOISTURE CURING ASSEMBLY MASTIC WITH HIGH INITIAL TACK AND ADJUSTABLE THE FIRST MINUTE



DESCRIPTION

Casco[®] XtremFix + is a 1-component strong moisture curing assembly mastic with sealing properties and excellent adhesion to most materials. Solvent free.

USES

Casco[®] XtremFix + designed for indoor and outdoor bonding of various objects such as stones, bricks, window and door sills, mirrors, wood beams and heavy moldings.

The unevenness in the joint can be several millimetres.

CHARACTERISTICS / ADVANTAGES

- Extreme high initial grab
- Adjustment possible first minute
- Phthalate free
- High strength, mechanical resistant and E-modulus
- Very good ageing properties and temperature resistance
- No shrinkage and extremely good joint filling properties

PRODUCT INFORMATION

Composition	SMP (silane modified polymer)
Packaging	290ml cartridge, 12x290ml each box
Colour	White
Shelf life	12 months from the date of production, if stored properly in undamaged, original, sealed packaging, and if the storage conditions are met.
Storage conditions	Shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C.
Density	Approx. 1400 kg/m ³ (ISO 1183-1)
Solid content by weight	100 %
Volatile organic compound (VOC) content	None
Consistency	Gun-grade thixotropic paste

TECHNICAL INFORMATION

Shore A Hardness	Approx. 50 (after 28 d) (ISO 868)
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Tensile Strength	Approx. 2,2 N/mm ²	(ISO 37)
Elongation at Break	Approx. 350 %	(ISO 37)
Tear Propagation Resistance	Approx. 10,0 N/mm ²	(ISO 34)
Service Temperature	-40 °C to +80 °C	

APPLICATION INFORMATION

Consumption	1 Cartridge (290 ml) Yield	
	<u>Yield</u>	<u>Dimensions</u>
	~100 spots	Diameter = 30 mm
	~5 m bead (see note)	Thickness = 4 mm
		Nozzle diameter = 5 mm
		(~60 ml per linear meter)
	Note: For heavy objects more or thicker beads (up to ~120 ml per linear metre) maybe required.	
Sag Flow	0 mm (20 mm profile, 23 °C)	(ISO 7390)
Ambient Air Temperature	+5 °C min. to +40 °C max.	
Substrate Temperature	+5 °C min. to +40 °C max.	
Curing Rate	Approx. 3 mm the first 24 h. (23°C / 50% RH)	(CQP 049-2)
	Approx. 7 mm after 7 days (23°C / 50% RH)	
Skinning time	Approx. 15 min (23°C / 50% RH)	(CQP 019-1)

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be 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.

For optimum adhesion and critical, high performance applications outside at porous substrates as concrete, aerated concrete and cement based renders, mortars and bricks, use Casco Primer 21. Before bonding, allow a waiting time of at least 30 min. (< 8 hours).

Note: Primers are adhesion promoters and not an alternative to improve poor preparation or cleaning of the surfaces.

APPLICATION METHOD / TOOLS

Bonding Procedure

Apply in triangular 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. Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be reached after complete curing of Casco® XtremFix +, i.e. after 24 to 48 hours at +23 °C, depending on the environmental conditions and adhesive layer thickness.

CLEANING OF EQUIPMENT

Remove all excess sealant adjacent to joint and on equipment prior to cure with a rag, cured adhesive is removed mechanically.

On skin, uncured sealant is wiped off with a rag, then wash with soap and water.

FURTHER INFORMATION

See the Safety Data Sheet

IMPORTANT CONSIDERATIONS

The access of moisture to the adhesive to be cured is essential. Cold and dry surroundings will slower the cure significantly.

When gluing watertight surfaces, moisture access must be secured. A combination of watertight surfaces and dry conditions can give an unacceptable slow cure.

Adhesion problems can also occur as a result of lack of moisture. If cure time is important, always pre-test the design under the worst conditions anticipated.

Over painting works well with many paint products. Pretesting of drying and adhesion of the paint is always recommended. The adhesive is elastic and can flex a little over the joint. This will lead to cracking of most types of paint.

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If Casco® XtremFix + is used together with polyurethane systems, note the following:
Casco® XtremFix + releases alcohol during cure, which can affect the curing of the polyurethane adversely. The polyurethane probably consumes water during cure. If access to water is limited, this can affect the cure and adhesion of Casco® XtremFix +. It is no problem to use Casco® XtremFix + in combination with polyurethane's, if the product applied first is allowed to cure fully before the second product is applied.

LIMITATIONS

- Not suitable for continuous under water applications.
- Not suitable as joint sealant.
- Do not use for glass bonding if the bond line is exposed to sunlight.
- Do not use for structural bonding.
- Do not expose uncured Casco® XtremFix + to alcohol containing products as this may interfere with the curing reaction.
- Among others not recommended for lead, PE, PP, Teflon, wax, neoprene, natural rubber, bitumen or on any building materials which might leach oils, plasticizers or solvents that could attack the adhesive. Surfaces, always carry out an adhesion test on the substrate before application.

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 Casco 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 or on the website www.casco.eu.

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