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PRODUCT DATA SHEET Casco[®] SuperFix

STRONG MOISTURE CURING ASSEMBLY MASTIC WITH SEALING PROPERTIES AND EXCELLENT ADHESION TO MOST MATERIALS.





DESCRIPTION

The unevenness in the joint can be several millimetres. The elastic properties combine the ability to distribute forces, take up vibrations and hold large forces without tendency for cold flow. Does not affect foamed polystyrene negatively.

USES

Excellent adhesion to most materials as metal, wood, glass, plastics and porous substrates.

CHARACTERISTICS / ADVANTAGES

- High thixotropic and easy to apply
- Tough joint and high strength
- Excellent chemical resistant
- Very high ageing properties and temperature resistance
- No shrinkage and extremely good joint filling properties
- Environmentally favourable with regard to working and indoor environment as well as waste handling and life cycle aspects.

PRODUCT INFORMATION

Composition	SMP (silylated modified polymer)
Packaging	300 ml cartridge and 40ml tube on blistercard (white)
Colour	White, Zinkgrey, Black
Shelf life	12 months for unopened cartridge
Storage conditions	Storage in room temperature.
Density	Approx. 1500 kg/m ³
Solid content by weight	100%
Consistency	Gun-grade thixotropic paste

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TECHNICAL INFORMATION

Shore A Hardness	60-65 Shore A	
Tensile Strength	Tensile strength at break (ASTM D 412): 2.3 N/mm ²	
Secant Tensile Modulus	100 % Modulus: 1,5 N/mm²	
Elongation at Break	Ultimate elongation (ASTM D 412): 250 %	
Shear Strength		
Tear Propagation Resistance	(ASTM D 624): : 9 N/mm	
Chemical Resistance	SuperFix has very good resistance to many chemicals, for example water, rapeseed oil, naphtha, ketones, diesel oil, motor oil, sodium hypochlorite, diluted bases and acids.	
Service Temperature	-40°C to +100°C	
Product Temperature	Application temperature: +5°C - +40°C	
Relative Air Humidity	Minimum 30 % RH	
Curing Time	3 mm the first 24 h. Approx. 10 mm after 7 days.	
Open Time	Approx. 20 minutes (23°C/50%RH)	

APPLICATION INSTRUCTIONS

The joint interface must be clean, dry and free from oils, loose aggregates and other contaminants. A thorough wire brushing, grinding or solvent cleaning may be required to expose clean, sound surfaces. Apply the adhesive in strings or dots. Thicker strings/dots are used if the surfaces are uneven. Never apply continues film if two non-porous materials with large surfaces is glued. String or dot gluing will allow the moisture necessary for curing to pass to the centre of the joint.

Assemble the parts before skin has formed (approx. 20 minutes at room temperature, shorter time at higher temps.)

A fixation may be needed in some cases, until the cure is completed. The joint is possible to handle after 1 to 24 hours, depending on materials glued, temperature and joint thickness.

See below table for recommendation of pre-treatment on different materials.

Metal	SuperFix bonds without primer on metal surfaces such as aluminium, zinc, galvanised steel, stainless steel, brass etc. In general there is also good adhesion to painted and coated metals. It does not bond to lead.
Wood	The adhesion is good to most woods, assuming the surface is freshly sanded. Pre-test on espe- cially "fat" woods are re- commended.
Glass	SuperFix bonds to glass without primer. For out-

	with high UV-exposure on the bond line through the glass, Superfix/Superset is not recommended.
Plastic	SuperFix bonds to un- plasticised PVC, polyester, epoxy, polyurethane, melamine, etc. Pre-testing is recommen- ded on acrylic, ABS, styrene, poly-carbonate and plasticised PVC. There is no adhesion to untreated polyolefin. The adhesion to poly- ethylene, polypropylene and fluorinated plastics is low.
Pourus substrates	With an elastic adhesive it is always harder to get adhesion to porous sub- strates. Always consider a coating if the substrate is to weak, preferable to pre-test. The adhesion to wet concrete might be poor. If in doubt contact technical service. Adhesion to most natural stones is good.

door glass construc-tions

It is recommended to make pre-tests.

SUPER QUICK CURE

The cure speed can be increased by blending moisture in the product. This can be useful in industrial processes.

A solvent miscible with both water and SuperFix is

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chosen. Ethyl alcohol is a possible choice. The joint will have an initial cure after 15 minutes or less, sufficient to handle the assembly. The full cure will be completed as normal, by diffusing moisture. This method can be altered with other solvents and amounts added, to give longer pot life or better initial cure. Contact R&D Sealants for support.

APPLICATION METHOD / TOOLS

Sealant gun

CLEANING OF EQUIPMENT

Remove all excess sealant adjacent to joint and on equipment prior to cure with a rag. White spirit or technical ethanol is used if necessary. Seal Remover 3987 is recommended if the adhesive has cured, otherwise cured adhesive is removed mechanically. On skin, uncured sealant is wiped off with a rag, then wash with soap and water.

IMPORTANT CONSIDERATIONS

LIMITATIONS

SuperFix is moisture curing.

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. If SuperFix is used as a sealant, these cracks can in worst case cause cracking of the joint.

If SuperFix is used together with polyurethane systems, note the following:

SuperFix 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 SuperFix. It is no problem to use SuperFix in combination with polyurethane's, if the product applied first is allowed to cure fully before the second product is applied.

SuperFix doesn't bond Polyethylene, Polypropylene, Teflon and other greasy plastics.

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 regula-

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ECOLOGY, HEALTH AND SAFETY

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and enduse 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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