

# Industry

## Technical Service Report

**Report-No.:**

00024-UK-00001-GR

**Date:**

06/11/2009

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## Adhesion of Sikatack Panel to Chromatics Laminate Panel

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**Customer:**

Glass Wall Company

**Test-costs:**

240 GBP

**Requestor:**

David Fraser

**Distributor Customer:**

**Distributor Sika:**

David Fraser

**Sika Limited**  
Technical Service

Nigel Harris

Gareth Ross

**Important Note**

This report has been carefully prepared based on the information received in writing. It does however not relieve the user of the product from testing the product's suitability for the intended application and purpose. Our warranty in regard to our products is governed exclusively by our sales condition of which we gladly send you a copy.



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## **Tests**

Standard adhesion test CQP 033-1

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## **Conclusion**

Excellent adhesion was achieved to the aluminium coating on Chromatics Laminate panel with the Sikatack Panel system.

# Adhesion of Sikatack Panel to Chromatics Laminate Panel 00024-UK-00001-GR

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## Tests conducted

CQP 033-1 - Bead adhesion

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### Cleaner

Sika® Cleaner-205

### Charge

0012206960/0419

### Primer

SikaTack®- Panel Primer

### Charge

0012360685/2299

### Adhesive

SikaTack® -Panel

### Charge

0012277537

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### Substrate [Attribute]

Glass Wall Company

[Chromatics Laminate Panel]

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## Remarks

The Chromatics Laminate panel is a panel of coated annealed glass with an aluminium layer to the rear face. It is to this aluminium rear face that the Sikatack Panel adhesive was applied.

**Chromatics Laminate Panel** 00024-UK-00001-GR

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**Panel Table**

**Tests:** CQP 033-1 - Bead adhesion

**Substrates:**

Chromatics Laminate Panel  
Glass Wall Company

| PreTreatment | Cleaner           | t<br>[min] | Primer                  | t<br>[min] | Adhesive         | Results |   |   |   |   |   |
|--------------|-------------------|------------|-------------------------|------------|------------------|---------|---|---|---|---|---|
|              |                   |            |                         |            |                  | B       | C | H | J | K | L |
|              | Sika® Cleaner-205 | 10         | SikaTack®- Panel Primer | 30         | SikaTack® -Panel | 1       | 1 | 1 | 1 | 1 | 1 |

**Notation for the Results**

| Notation | Exposure                  |
|----------|---------------------------|
| <b>A</b> | 1d KLR                    |
| <b>B</b> | 7d KLR                    |
| <b>C</b> | 7d WL + 2h KLR            |
| <b>D</b> | 7d 40°C/95%rh. + 2h KLR   |
| <b>E</b> | 7d 70°C + 1d KLR          |
| <b>F</b> | 1d 80°C                   |
| <b>G</b> | 1d 80°C + 2h KLR          |
| <b>H</b> | 3d -30°C + 2h KLR         |
| <b>I</b> | 7d 80°C + 2h KLR          |
| <b>J</b> | 3d 80°C                   |
| <b>K</b> | 2h KLR                    |
| <b>L</b> | 7d CP + 2h KLR            |
| <b>M</b> | 7d CP + 1d -30°C + 1d KLR |
| <b>N</b> | 10 cycles VDA             |
| <b>O</b> | 20 cycles VDA             |

KLR = Exposure at 23°C/50%rh acc. to DIN 50'014

WL = Exposure in deionised water at 23°C

CP = Cataplasma at 70°C/100%rh.

VDA = Cycletest acc. to VDA 621-415

xh = x hour(s)

xd = x day(s)

**The test results are analyzed as shown in the Table below:**

| Note      | Assessment  | Bond                   |
|-----------|---|------------------------|
| <b>1</b>  | Bond satisfactory                                 | > 95% cohesion failure |
| <b>2</b>  | Bond basically satisfactory                       | > 75% cohesion failure |
| <b>3</b>  | Bond not satisfactory                             | > 25% cohesion failure |
| <b>4</b>  | Bond not satisfactory                             | < 25% cohesion failure |
| <b>L</b>  | Failure of paint structure (define failure point) |                        |
| <b>P</b>  | Primer separates from substrate                   |                        |
| <b>BK</b> | Bubbles in adhesive                               |                        |
| <b>B</b>  | Bubbles/voids on the bond surface                 |                        |
| <b>T</b>  | Tunnel effect/edge bonding                        |                        |
| <b>K</b>  | Adhesive is not cured on the bond surface         |                        |
| <b>FH</b> | Film bonding                                      |                        |
| <b>S</b>  | Foam structure on the bond surface (fine bubbles) |                        |
| <b>RA</b> | Edge separation                                   |                        |
| <b>n</b>  | Not tested  |                        |

Note:

If no additional designation is given, the failure area (if adhesive) is between the adhesive and the layer applied last. Different failure modes should be described.