SikaBond®-542 IDN
Water Based Adhesive for Full Surface Bonding of PVC, Vinyl, MDF and HPL Film

Product Description
Sikabond®-542 IDN is a one part, water based adhesive

Uses
SikaBond® -542 IDN 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
- One part, easy to use. 1 part adhesive, ready to use
- Very easy to apply
- High strength
- Good moisture Resistance (Not for use in permanent wet conditions)
- 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)

Moisture 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 ºC.

Product Data
Form
Colour
White Brownish

Packaging
10 kg pail can
4 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 ºC.
Technical Data

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

**Viscosity (mpa.s, 30°C)**
25,000 ~ 40,000

**Solid Content**
53 ~ 57

**Machinery Stability**
Good

**Drying Film**
Transparant

**Skinning / Laying Time**
Closed assembly time is within 30 minutes.

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 cementious substrates. Standard construction rules must be observed.
Must be mechanically prepared as necessary to achieve the substrate quality and thoroughly vacuumed.

**Application Temperature**
over 10°C

**Application Instructions**

**Application Method / Tools**
Sikabond®-542 IDN is applied to the prepared substrate directly from the pail and uniformly distributed by roll spreader without diluting.
- 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 IDN 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.
- Not for use in permanent wet conditions.
- 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 IDN.
- 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 IDN has the high performance for plastic sheet lamination, its have fast setting & good spreadibility. 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.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika’s current knowledge and experience of the product 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.