

**Technical Data Sheet**  
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**SikaBond®-542 IDN**

## SikaBond®-542 IDN

Water Based Adhesive for Full Surface Bonding of PVC, Vinyl, MDF and HPL Film

<b>Product Description</b>	Sikabond®-542 IDN is a one part, water based adhesive
<b>Uses</b>	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.
<b>Characteristics / Advantages</b>	<ul style="list-style-type: none"> <li>■ One part, easy to use. 1 part adhesive , ready to use</li> <li>■ Very easy to apply</li> <li>■ High strength</li> <li>■ Good moisture Resistance (Not for use in permanent wet conditions)</li> <li>■ Suitable for many types of vinyl and laminate floor</li> </ul>
<b>Test</b>	
<b>Test Method</b>	5 days after application completed.
<b>Test Condition</b>	
<b>Dry Strength</b>	After aging at the room temperature , measure peel strength at $20 \pm 2^{\circ}\text{C}$ and $60 \pm 5\% \text{ RH}$ (Unit :kgf/25mm)
<b>Moisture Resistance</b>	Immerse the sample in water (room temperature) for 24 hours and then measure peel strength immediately (Unit : kgf/25mm)
<b>Heat creep resistance</b>	Measure a creep length after being left 0.5 , 1.0 , 3 hours with 500 g static loading per 25mm width at $60^{\circ}\text{C}$ .
<b>Product Data</b>	
<b>Form</b>	
<b>Colour</b>	White Brownish
<b>Packaging</b>	10 kg pail can 4 kg pail can
<b>Storage</b>	
<b>Storage Conditions / Shelf Life</b>	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 $+10^{\circ}\text{C}$ and $+25^{\circ}\text{C}$ .

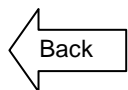


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## Technical Data

**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

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

## System Information

### Application Details

**Consumption / Yield** 110 to 130 g/ m<sup>2</sup> 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 cementitious 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<sup>®</sup>-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/m<sup>2</sup> 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<sup>®</sup> 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<sup>®</sup>-542 IDN.
- The adhesive is not to be diluted.
- Do not expose the adhesive directly 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<sup>®</sup>-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.



<b>Value Base</b>	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.
<b>Local Restrictions</b>	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.
<b>Health and Safety Information</b>	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.
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