

## PRODUCT DATA SHEET

# Sikaflex®-134 Bond & Seal

Multipurpose elastic adhesive and joint sealant

### DESCRIPTION

Sikaflex®-134 is a 1-part, multipurpose elastic polyurethane adhesive and sealant. It bonds and seals to most common building and industrial materials, is permanently elastic and has good adhesive and crack filling properties.

### USES

An all in one adhesive and sealant, suitable for a wide range of building and maintenance uses including:

- Bonding & Fixing of tiles, floor boards, skirtings, cabinets, shower trays, mirrors, wall decorations and more.
- Bonding & Sealing of metal awnings, roof flashings, gutters, service penetrations.
- Crack repair on roofs, driveways, walls.
- Forming gaskets in ducting and sealing between metal components and window frames.
- Fabrications and shop fitting.
- Joint sealing of floor and wall joints.
- Internal and external use.

### CHARACTERISTICS / ADVANTAGES

- Good adhesion to concrete, brick, mortar, wood, metals, glass and resins (FRP, GRP..).
- Bonds to damp concrete.
- Non-sag & non-slip.
- Fast curing.
- Paintable.
- Non-corrosive.
- Permanent elastic.
- Good mechanical and weathering resistance.

## PRODUCT INFORMATION

Chemical base	<i>i</i> -Cure technology polyurethane	
Packaging	300 ml cartridge	12 cartridges per box
	600 ml cylindrical foil pack	20 foil packs per box
Colour	Black, Concrete Grey and White	
Shelf life	15 months from the date of production	
Storage conditions	The product must be stored in original, unopened and undamaged packaging in dry conditions at temperatures between +5 °C and +25 °C. Always refer to packaging.	
Density	~1,34 kg/l	(ISO 1138-1)

## TECHNICAL INFORMATION

Shore A Hardness	~30 (after 28 days)	(ISO 868)
Tensile Strength	>1,2 N/mm <sup>2</sup>	(ISO 37)
Secant Tensile Modulus	~0,60 N/mm <sup>2</sup> at 100 % elongation (+23 °C) ~1,10 N/mm <sup>2</sup> at 100 % elongation (-20 °C)	(ISO 8339)
Elongation at Break	~700 %	(ISO 37)
Tear Propagation Resistance	~6,0 N/mm	(ISO 34)
Service temperature	-40 °C min. / +80 °C max.	

### Joint Design

Joint width of between 10 mm and 35 mm. Minimum Joint depth of 10mm. Width-to-depth ratio of 2:1 for wall joints and 2:1,6 for floor joints.

#### Typical joint dimensions for joints between concrete elements:

Joint distance	Joint width	Min. joint depth	
		Wall	Floor
2,0 m	10 mm	10 mm	10 mm
4,0 m	15 mm	10 mm	12 mm
6,0 m	20 mm	10 mm	16 mm
8,0 m	30 mm	15 mm	24 mm
10,0 m	35 mm	17 mm	28 mm

All joints must be correctly designed and dimensioned in accordance with the relevant standards and codes of practice before their construction. The basis for calculation of the necessary joint widths are the type of structure, dimensions, technical values of the adjacent building materials, joint sealing material and the specific exposure of the building and the joints.

## APPLICATION INFORMATION

### Consumption

#### Sealing WALL

Joint width	Joint depth	Metre run per cartridge (300ml)	Metre run per foil pack (600ml)
10 mm	10 mm	3,0 m	6,0 m
15 mm	10 mm	2,0 m	4,0 m
20 mm	10 mm	1,5 m	3,0 m

FLOOR			
Joint width	Joint depth	Metre run per cartridge (300ml)	Metre run per foil pack (600ml)
15 mm	12 mm	1,6 m	3,2 m
20 mm	16 mm	0,9 m	1,8 m
30 mm	24 mm	0,4 m	0,8 m

#### Bonding

Yield	Dimension
<b>1 Cartridge (300 ml)</b>	
~100 spots	Diameter = 30 mm Thickness = 4 mm
~15 m bead	Nozzle diameter = 5 mm (~20 ml per linear meter)

#### Calculation:

Metre run = Packaging Volume / Joint width (mm) x Joint depth (mm)  
Consumption depends on the roughness and absorbency of the substrate. These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level or wastage etc.

<b>Backing Material</b>	Use closed cell, polyethylene foam backing rods
<b>Ambient Air Temperature</b>	+5 °C min. / +40 °C max.
<b>Relative Air Humidity</b>	30 % to 90 %
<b>Substrate Temperature</b>	+5 °C min. / +40 °C max. Minimum +3 °C above dew point temperature
<b>Skin time</b>	~70 min (+23 °C / 50 % r.h.) (CQP 019-1)

## 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.

## FURTHER DOCUMENTS

- Pre-treatment Sealing and Bonding Chart
- Method Statement: Joint Sealing
- Method Statement: Joint Maintenance, Cleaning and Renovation
- Technical Manual: Facade Sealing

## IMPORTANT CONSIDERATION

- For good workability, the adhesive temperature must be +20 °C.
- Application during high temperature changes is not recommended (movement during curing).
- Before bonding or sealing, check adhesion and compatibility of paints and coatings by carrying out preliminary trials.
- Sikaflex®-134 Bond & Seal can be overpainted with most conventional water-based coating and paint systems. However, paints must first be tested to ensure compatibility by carrying out preliminary trials. The best over-painting results are obtained when the adhesive is allowed to fully cure first. Note: non-flexible paint systems may impair the elasticity of the adhesive and lead to cracking of the paint film.
- Colour variations may occur due to the exposure in service to chemicals, high temperatures and/or UV-radiation (especially with white colour shade). This

effect is aesthetic and does not adversely influence the technical performance or durability of the product.

- Always use Sikaflex®-134 Bond & Seal in conjunction with mechanical fixings for overhead applications or heavy components.
- For very heavy components provide temporary support until Sikaflex®-134 Bond & Seal has fully cured.
- Full surface applications / fixings are not recommended since the inner part of the adhesive layer may never cure.
- Before using on reconstituted, cast or natural stone, contact Sika Technical Services.
- Do not use on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might leach oils, plasticisers or solvents that could degrade the adhesive.
- Do not use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE / Teflon), and certain plasticised synthetic materials. Preliminary trials are recommended or contact Sika® Technical Services.
- Do not use to seal joints in and around swimming pools.
- Do not use for joints under water pressure or for permanent water immersion.
- Do not use to seal glass or sanitary joints.
- Do not use for trafficked floor joints. Contact Sika® Technical Services for advice on alternative products.
- Do not use for bonding glass if the bond line is exposed to sunlight.
- Do not use for structural bonding.
- Do not expose uncured Sikaflex®-134 Bond & Seal to alcohol containing products as this may interfere with the curing reaction.

## 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.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

The substrate must be sound, 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 / sealant. The substrate must be of sufficient strength to resist with the stresses induced by the sealant during movement. Removal techniques such as wire brushing, grinding, sanding or other similar mechanical tools can be used. All dust, loose and friable material must be completely removed from all surfaces before application of any activators, primers or adhesive / sealant.

Sikaflex®-134 Bond & Seal adheres without primers and/or activators.

However, for optimum adhesion, joint durability and critical, high performance applications the following priming and/or pre-treatment procedures must be followed:

#### Non-porous substrates

Aluminium, anodised aluminium, stainless steel, PVC, galvanised steel, powder coated metals or glazed tiles, slightly roughen surface with a fine abrasive pad.

Clean and pre-treat using Sika® Cleaner P or Sika® Aktivator-205 applied with a clean cloth.

Before bonding / sealing, allow a waiting time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, clean and pre-treat using Sika® Cleaner P or Sika® Aktivator-205 applied with a clean cloth. After a waiting time of > 15 minutes (< 6 hours). Apply Sika® Primer-3 N by brush.

Allow a further waiting time of > 30 minutes (< 8 hours) before bonding / sealing, PVC must be cleaned and pre-treated using Sika® Primer-215 applied with a brush.

Before bonding / sealing, allow a waiting time of > 15 minutes (< 8 hours).

#### Porous substrates

Concrete, aerated concrete and cement-based renders, mortars and bricks, prime surface using Sika® Primer-3 N applied by brush.

Before bonding / sealing, allow a waiting time of > 30 minutes (< 8 hours).

Note: Primers and activators are adhesion promoters and not an alternative to improve poor preparation / cleaning of the joint surface. Primers also improve the long term adhesion performance of the sealed joint. Contact Sika Technical Services for additional information.

### APPLICATION METHOD / TOOLS

Strictly follow installation procedures as defined in method statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

#### Bonding Procedure

##### Application

After the necessary substrate preparation, prepare the end of the cartridge / foil pack before or after inserting into the sealant gun then fit the nozzle.

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. Incorrectly positioned components can easily be unbonded and repositioned during the first few minutes after application. If necessary, use temporary adhesive tapes, wedges, or supports to hold the assembled components together during the initial curing time.

Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be reached after complete curing of Sikaflex®-134 Bond & Seal, i.e. after 24 to 48 hours at +23 °C, depending on the environmental conditions and adhesive layer thickness.

#### Sealing Procedure

##### Masking

It is recommended to use masking tape where neat or exact joint lines are required. Remove the tape within the skin time after finishing.

##### Joint Backing

After the required substrate preparation, insert a suitable backing rod to the required depth.

##### Priming

Prime the joint surfaces as recommended in substrate preparation. Avoid excessive application of primer to avoid causing puddles at the base of the joint.

##### Application

Prepare the end of the cartridge / foil pack before or after inserting into the sealant gun then fit the nozzle. Extrude Sikaflex®-134 Bond & Seal into the joint ensuring that it comes into full contact with the sides of the joint and avoiding any air entrapment.

##### Finishing

As soon as possible after application, sealant must be firmly tooled against the joint sides to ensure adequate adhesion and a smooth finish.

Use a compatible tooling agent (e.g. Sika® Tooling Agent N) to smooth the joint surface. Do not use tooling products containing solvents.

### CLEANING OF TOOLS

Clean all tools and application equipment with Sika® Remover-208 immediately after use. Once cured, hardened material can only be removed mechanically. For cleaning skin use Sika® Cleaning Wipes-100.

### 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.

### 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 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.

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#### Product Data Sheet

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