

## PRODUCT DATA SHEET

# SikaBond<sup>®</sup>-234 Maxtack

Water-based construction adhesive

## DESCRIPTION

SikaBond<sup>®</sup>-234 Maxtack is a one-component, water-based construction adhesive with good initial grab that forms a strong permanent bond to most construction materials.

## USES

- Indoor and sheltered outdoor use.
- Wall and ceiling
- Porous substrates such as wood, concrete, brick, mortar, stone, tile, fiber-cement, plasterboard etc.
- Non-porous substrates such as steel, aluminum, other metals, Rigid PVC, and polystyrene

\*At least one of the substrates should be porous to allow drying of the adhesive

## FEATURES

- High initial tack
- Fixing without tapes, nails or screws
- Good adhesion on many substrates
- Good workability
- Easy to tool and clean up
- Water-based
- Over-paintable by an emulsion waterborne paint

## PRODUCT INFORMATION

<b>Composition</b>	1-Component water-based dispersion
<b>Packaging</b>	300 ml / cartridge (12 cartridges per box) 75 g / piece (12 pieces per box)
<b>Shelf life</b>	Minimum 18 months from the production date, if storage conditions are met and the packaging is in its original sealed and undamaged state.
<b>Storage conditions</b>	SikaBond <sup>®</sup> -234 Maxtack shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C.
<b>Colour</b>	Off-white
<b>Density</b>	1.34 g/ml approx..
<b>Shore A hardness</b>	75 approx.(after 28 days) <span style="float: right;">ISO 868</span>
<b>Lap shear strength</b>	2.8 N/mm <sup>2</sup>
<b>Service temperature</b>	-30 °C to +60 °C
<b>Consumption</b>	Using a nozzle with a 5 mm diameter, bead yield is approx 14 m in length per 300 ml cartridge (approx. 20 ml per linear meter).

<b>Sagging</b>	Very low	(ISO 7930)
<b>Substrate temperature</b>	+5 °C to +35 °C	
<b>Open Time</b>	5 Min (23 °C / 50% r.h.)	
<b>Curing rate</b>	24 – 72 hrs for final cure (23 °C / 50% r.h.)	(CQP 049-2)

## 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 INFORMATION

- Safety Data Sheet
- Pre-treatment Chart Sealing and Bonding

## IMPORTANT CONSIDERATIONS

- For good workability, the adhesive temperature shall be +20 °C.
- For proper curing of the adhesive, sufficient ambient humidity / moisture is necessary.
- Application during high temperature changes is not recommended (movements during the curing).
- Before bonding, check adhesion and resistance of paints and coatings by carrying out a trail.
- Trials shall be carried out to test for overpaint ability and paint compatibility. When overcoating SikaBond®-234 Maxtack, compatibility of coatings must be tested individually.
- For good bonding, one of the two substrates must be porous.

## 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 Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

For the application of SikaBond®-234 Maxtack all standard construction guidelines apply.

### SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. Paint, cement laitance and other poorly adhering contaminants must be removed. SikaBond®-234 Maxtack adheres without primers and/or activators.

### Non-porous substrates

Aluminium, anodised aluminium, stainless steel, PVC, galvanised steel, powder coated metals or glazed tiles have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. Before sealing, allow a flash-off time of > 15 minutes (< 6 hours). Other metals, such as copper, brass and titanium-zinc, also have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. After the necessary flash-off time, use a brush to apply Sika® Primer-3 N and allow a further flash-off time of > 30 minutes (< 8 hours) before sealing the joints.

### Porous substrates

Wood has to be sanded, concrete and mortar have to be scrubbed and sanded to remove laitance. Clean with an industrial vacuum. For more detailed advice and instructions please contact our Technical Service Department.

## APPLICATION METHOD / TOOLS

After the necessary substrate preparation, apply SikaBond®-234 Maxtack in round shaped cordons with 5 mm in diameters in intervals of a few centimeters each. If necessary, use a notched trowel to distribute SikaBond®-234 Maxtack evenly. Press or tap bonded parts together firmly to ensure good adhesion before a skin occurs. An incorrectly positioned element can easily be unfastened and repositioned during the first few minutes after application. If necessary, use adhesive tapes, wedges, or props to hold the assembled elements together during the initial curing hours. The recommended adhesive layer thickness (depending on surface evenness) is < 3 mm. For immediate fixing, the thickness of the bonding adhesive layer must be ≤ 1 mm.

Fresh, uncured adhesive remaining on the surface must be removed immediately.

Final strength will be obtained after complete curing of SikaBond®-234 Maxtack.

## CLEANING OF EQUIPMENT

Clean all tools and application equipment immediately after use with water. Once cured, residual material can only be removed mechanically.

## 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.

## 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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