

Industry

Technical Service Report

Project number:
00083-CZ-00002-JiR

Date:
2.7..2014

Adhesion test on facade panels ORGANOID

Customer:
Fassadenklebetechnik Klug GmbH

Costs:
790 EUR

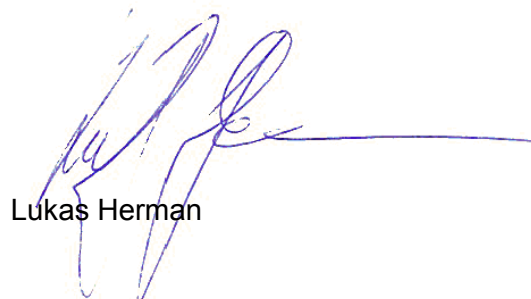
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Držitel certifikátu jakosti podle ČSN EN ISO 9001 a systému EMS podle ČSN EN ISO 14001



Task

For the company Fassadenklebetechnik Klug GmbH adhesion test according CQP was done. We received various facade panels ORGANOID for interior wall cladding with the purpose of identifying the best suitable bonding process with Sikaflex® - 552

Test Methods

CQP 033-1 - Bead Adhesion

CQP 034-1 - Test Condition for Bead Adhesion

Utilities

-

Cleaner/Activators

-

Batch Nr

Primer

Sika® Primer-215

Batch Nr

3000962241

Adhesive

Sikaflex® -552 white

Batch Nr

3000790613

Substrate

Various

Detail

facade panel ORGANOID HONF,
not defined

Various

facade panel ORGANOID ROSCHT,
not defined

Various

facade panel ORGANOID RINDÄ,
not defined

Notes

Testmethod: CQP 033-1 - Bead Adhesion
Substrate: Various: facade panel ORGANOID HONF, not defined

Pre-Treatment 1	Pre-Treatment 2	t [min]	Pre-Treatment 3	t [min]	Adhesive	Results				
						B	C	G	J	L
					Sikaflex® -552 white	1	n	n	1	1
			Sika® Primer-215	30	Sikaflex® -552 white	1	n	n	1	2

Testmethod: CQP 033-1 - Bead Adhesion
Substrate: Various: facade panel ORGANOID ROSCHT, not defined

Pre-Treatment 1	Pre-Treatment 2	t [min]	Pre-Treatment 3	t [min]	Adhesive	Results				
						B	C	G	J	L
					Sikaflex® -552 white	1	n	n	1	2
			Sika® Primer-215	30	Sikaflex® -552 white	1	n	n	1	4

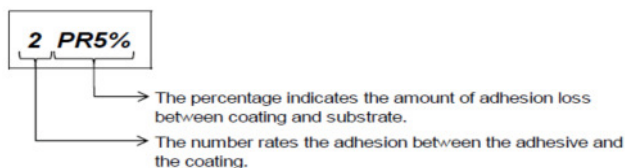
Testmethod: CQP 033-1 - Bead Adhesion
Substrate: Various: facade panel ORGANOID RINDÄ, not defined

Pre-Treatment 1	Pre-Treatment 2	t [min]	Pre-Treatment 3	t [min]	Adhesive	Results				
						B	C	G	J	L
					Sikaflex® -552 white	1	n	n	1	3
			Sika® Primer-215	30	Sikaflex® -552 white	1	n	n	1	4

Notation for the Results

Notation	Exposure
A	1d KLR
B	7d KLR
C	7d WL + 2h KLR
D	7d 40°C/95%rh. + 2h KLR
E	7d 70°C + 1d KLR
F	1d 80°C
G	1d 80°C + 2h KLR
H	3d -30°C + 2h KLR
I	7d 80°C + 2h KLR
J	3d 80°C
K	2h KLR
L	7d CP + 2h KLR
M	7d CP + 1d -30°C + 1d KLR
N	10 cycles VDA
O	20 cycles VDA
P	3x 7d WL 55°C
Q	7d 35°C/90%rh
R	7d WL 40°C
S	7d 70°C

KLR	Exposure at 23°C/50%rh acc. to DIN 50 014
WL	Exposure to 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
1	Bond satisfactory	> 95% cohesion failure
2	Bond basically satisfactory	> 75% cohesion failure
3	Bond not satisfactory	>25% cohesion failure
4	Bond not satisfactory	< 25% cohesion failure
CR	Chipping of the coating (paints etc.). Describe the failure	
PR	Rupture in the primer	
BA	Bubbles in adhesive	
BS	Bubbles/voids on the bond surface	
TU	Tunnel effect/edge bonding	
UC	Adhesive is not fully cured. Describe details	
SF	Substrate failure (failure in fibers on layers of non-coated substrates)	
FS	Foam structure on the bond surface (fine bubbles)	
ES	Edge separation	
SCF	Substrate close adhesive failure (substrate visible)	
Cor	Corroded substrate	
PT	Partial adhesion loss of primer to substrate	
NT	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.

Legal Note:

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