

The Henkel logo is enclosed in an oval within a white banner that has a red top edge and a blue bottom edge. The banner is set against a background of red and blue geometric shapes.

Macroplast® SIA-117

TYPE OF ADHESIVE: Macroplast® SIA-117 is a single component, solvent free, moisture curable, liquid polyurethane adhesive. It cures with water to form a tough, strong, and thermoset polymer.

FIELD OF APPLICATION: Macroplast® SIA-117 can be used for lamination of sandwich panel elements of wood, lauan, fiberboard, particleboard, plywood, FRP, EPS foam, PU foam, and primed metals. Users should fully qualify the product before commercial production.

BENEFITS: Macroplast® SIA-117 is 100% solid. It does not require heat for application. It provides excellent bonding strength to many substrates along with excellent resistance to chemicals, water, weather, and environmental changes.

TYPICAL TECHNICAL DATA:

Color	Light Tan to Brown
Viscosity @ 77F	5,500 cps
Density @ 77F	9.0lbs/gallon
Solids	100%
Odor	Odorless
Curing mechanism	Curing with Water
Open Time @ 75F	~6-7 min

APPLICATION:

Substrate Surface must be free of oil, grease, lubricants, dust, dirt, and any other surface contaminants. Aluminum or other metals must be conversion coated or primed for best adhesion.

Macroplast® SIA-117 can be applied with a bead extruder or manually. Deposition rate can vary from 10 to 20 g/sft, depending on substrate porosity. Typical water fog rate is 10-15% of the coating weight or 1-2 grams per square foot. Water should be evenly distributed without droplets. Press is needed during the moisture curing of the adhesive. Intimate contact pressure between sandwich panel elements is necessary during the setting time period. Contact pressure with a vacuum press of 6" of mercury or greater is recommended.

PRECAUTIONS:

Please refer to the Material Safety Data Sheet for further safety information.

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CLEANING:

Propylene carbonate or some organic solvents can be used to clean uncured material. Cured material can only be removed mechanically.

STORAGE CONDITIONS:

Store in a dry area at 60-85F. Use the product first in first out.

Shelf Life: The shelf life of original, unopened packages is 90 days from date of shipment. Once opened, the material has to be used immediately.

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