

SikaBond®-T55

Trowel Grade Polyurethane Elastic Adhesive for Wood Flooring

Description	SikaBond-T55 is a one-component, low-VOC, permanently elastic, super strong polyurethane adhesive for full surface bonding of wood flooring.
Where to Use	SikaBond-T55 may be used for solid and engineered wood floors (strips, longstrips, planks, panels, boards) mosaic parquet, industrial parquet, wood paving (residential) as well as chip boards can be bonded.
Advantages	<ul style="list-style-type: none"> ■ 400% Elongation ■ Formulated to be extremely easy to trowel, preventing arm strain ■ Fast curing - unfinished wood flooring can be sanded after 12 hours of cure time ■ Suitable for most common types of wood floors ■ Especially good for problematic woods such as beech and bamboo ■ Suitable for bonding wood floors directly onto old ceramic tiles ■ Suitable for in-floor radiant heat installation ■ Footfall-sound-dampening adhesive ■ Contains no water ■ Bonds solid wood flooring up to 8 inches wide and engineered planks up to 14 inches wide directly to concrete with no length limitations ■ Eliminate sleepers and plywood over concrete and gypsum substrates ■ Permanently elastic – allows planks to expand and contract without damage to the adhesive or substrate

Green Rating

LEED® EQc 4.1 (100 g/L limit)	SCAQMD, Rule 1168 (100 g/L limit)	BAAQMD, Reg. 8, Rule 51 (120 g/L limit)
passes	passes	passes

Technical Data

Shelf Life	12 months from date of production if stored in undamaged unopened original sealed containers, in dry conditions and protected from direct sunlight at temperatures between 50°F and 77°F (10°C and 25°C).
Color	Tan
Packaging	5 gal. (18.93 L) unit
Chemical Base	1-component Polyurethane, moisture curing
Specific Gravity	11 lbs/gal (1.34 kg/l)
Skinning-/Laying Time	~ 45-60 minutes at 73°F(23°C) and 50% RH
Curing Rate	4.0 mm/24h at 73°F(23°C) and 50% RH. Floor may accept light foot traffic after 4 hrs. and sanded 12 hrs. after installation (depending on climatic conditions and adhesive layer thickness).
Sag Flow	Consistency: Spreads very easily, holds ridges after troweling.
Service Temperature	-40°F to +158°F

Typical Mechanical Properties

Shear Strength	145 psi using 1 mm adhesive thickness at 73°F(23°C) and 50% RH
Tensile Strength	217 psi at 73°F(23°C) and 50% RH
Shore A Hardness	35 (after 28 days)
Elongation at Break	~ 400% cured at 73°F(23°C) and 50% RH
VOC (g/l)	83



Application Details

Consumption

- **P4 Trowel:** approximately 55-60 sq. ft. per gallon. For use with engineered boards less than 7/8" thick and less than 6" wide and less than 6' long.
- **P5 Trowel:** approximately 50 sq. ft. per gallon. Required for all solid wood applications. And when requirements for P4 Trowel do not apply.
- For applications over gypsum-based subflooring, Sika requires the P5 trowel or larger only. In case of uneven substrates, it may be necessary to use a notched trowel with bigger notches (avert hollow sections). Coverage must be monitored to ensure accuracy of application. Trowel angle may prevent proper coverage.

Recommended Trowel Sizes	
P4	P5
<p>1/8" x 1/8" x 3/16"</p>	<p>3/16" x 3/16" x 3/16"</p>

Coverage of approximately:
55-60 sq. ft./gal

Coverage of approximately:
50 sq. ft./gal

Trowel size is recommended to obtain proper coverage. Larger sizes are acceptable. Check coverage during installation. Trowels should be used at the 90° angle to subfloor to get stated coverages.

Substrate Quality

Structurally sound, clean, dry, homogeneous, level, free from grease, dust and loose particles, paint, laitance, and other poorly adhering particles must be removed. Follow standard construction regulations.

Substrate Preparation

SikaBond-T55 can generally be used without priming on properly prepared, structurally sound concrete, cement floors, chipboards, ceramic tiles, plywood and hardwood. For on-grade sub-floors Sika recommends the use of Primer MB for best protection against sub-floor moisture. Moisture testing is required by the wood flooring manufacturer for best results with the wood flooring products. Below grade applications are generally not recommended unless proper precautions are taken to protect the wood flooring from sub-floor and in-room humidity extremes. Sika recommends the use of Primer MB over any dry, gypsum based sub-flooring to enhance surface strength.

Preparation is a critical step in the installation process and will ensure a successful long term tenacious bond. All concrete, cement screed and gypsum based subfloors must be structurally sound, clean, dry, smooth, free of voids, projections, loose materials, oil, grease, sealers and other surface contaminants. Remove laitance or weak areas mechanically. For application over ceramic tiles it is necessary to grind tile surfaces and clean thoroughly with an industrial vacuum. For substrates with old well bonded adhesive or adhesive residue use Primer MB – see Primer MB data sheet for installation instructions and proper details.

If surface contains asphalt (cutback) adhesive follow the Resilient Floor Covering Institute "Recommended Work Practices" for removal. When the asphalt (cutback) adhesive is sufficiently removed use the Sika Primer MB to help promote adhesion to the subfloor – or use an industry approved levelling compound over the cutback residue. SikaBond T55 will adhere to most common patching/levelling compounds. Due to differences in asphalt based adhesive types and performance capabilities; applicator must verify that preparation of the surface is sufficient prior to using Primer MB or patch/level compound. For unknown substrates please contact Sika Technical Services for best practices at 1-800-933-SIKA.

Application Conditions/Limits

Substrate Temperature

During laying and until SikaBond®-T55 has fully cured, substrate temperature should be greater than 60°F (15°C) and in case of floor heating, less than 70°F (20°C). For substrate temperatures, the standard construction rules are relevant

Air Temperature

Room temperature between 60°F (15°C) and 90°F (35°C). For ambient temperatures the standard construction rules are relevant. Follow all wood floor manufacturer's acclimation and room temperature requirements.

Substrate Humidity

Moisture requirements are set forth to protect the wood flooring products that can expand and contract with different moisture levels. SikaBond-T55 is not affected by moisture or vapor transmission. The guidelines below are included to provide the best practices in moisture vapor testing that exists today. Permissible substrate moisture contents are listed on the chart below. For more information on the use of the CM method please contact Troy Corporation at 973-443-4200.

Application	Moisture level requirements using Tramex method (%)	Moisture level requirements using CM method (%)
3/4" solid or engineered over concrete	4%	2.5%
3/4" solid or engineered over concrete with Primer MB layer	6%	4.0%
3/4" solid or engineered over in-floor heating over concrete	3%	1.8%
3/4" solid or engineered over gypsum-based	Tramex should not be used to measure gypsum	0.5%
3/4" solid or engineered over in-floor heating over gypsum-based	Tramex should not be used to measure gypsum	0.3%

The National Wood Flooring Association recommends the use of moisture testing devices that identify actual moisture content in percentages (%). For best results in measuring the moisture levels in cement based subfloor use the Tramex measuring device to find the highest reading in the application area and then run the CM method at that highest point to determine the worst case. As a general guideline for floors with no in-floor heating if the Tramex is below 4% the Primer MB will not be necessary and between 4% and 6% Primer MB will be required - however, the CM method must be used to make final determination of concrete moisture levels – use chart above. For moisture content and quality of substrates the guidelines of wood floor manufacturer must be observed.

Relative Air Humidity Between 40% and 70%

Application Instructions

Application

Read this product data sheet completely prior to starting installation. SikaBond®-T55 is applied to the properly prepared substrate directly from the pail and uniformly distributed by notched trowel. Press the wood floor elements firmly into the adhesive so that the wood floor underside is sufficiently wetted. The elements can then be joined together using a hammer and an impact block and/or rubber mallet. Many types of wood floors have to be tapped from the top. Leave gaps at room perimeters and at any floor wall partition to allow wood flooring to move naturally – follow recommended guidelines from wood floor manufacturer. Spacers should be used to ensure perimeter space is maintained. Fresh, uncured adhesive remaining on the wood floor surface must be removed immediately with a clean cloth and urethane remover. The laying instructions of the wood floor manufacturer as well as standard construction rules must be observed. **Note:** Wood floor manufacturer's requirements for room humidity levels and environmental control along with wood flooring acclimation requirements must be strictly followed.

Note: For Solid and Wide Engineered Hardwood applications: Sika recommends the use of clamps to keep joints tight – for most projects a set of 5 will be adequate. If bowed boards are expected, Sika recommends placing several rows of straight boards across length of room and allow to cure overnight – these will form starter rows that will act as anchor for the clamps. For moderately bowed boards – clamp boards from the starter row. Clamp each individual row or several rows – if clamping several rows this must be done while adhesive is still wet. Clamps can then be loosened until successive rows are place and clamped accordingly. Be careful not to over-tighten. Best practice is to leave clamps in place when work is stopped for the day. For severely bowed boards – cut boards down to shorter pieces so that bow is removed. For situations where wood flooring does not rest flat - Sika recommends as a best practice the use of weights to ensure intimate contact between the wood-adhesive-substrate. Leave clamps and/or weights on critical areas for a minimum of 12 hours.

Clean Up

All tools should be cleaned immediately after use with Sika Equipment Cleaner or Sika Hand Cleaner Towels. Any adhesive that is permitted to cure on the tool will need to be removed by mechanical means. Use a dry towel and Sika Hand Cleaner Towels to removed adhesive from pre-finished wood surface before it cures. Finger prints or small amounts of adhesive residue can be removed from pre-finished wood using the Sika Hand Cleaner Towels. Sika Hand Cleaner Towels use a citrus based cleanser that will not harm the floor finish. Remove any adhesive residue from hands using the Sika Hand Cleaner Towels.



Limitations

- Maximum wood size: Solid wood < 8" wide and Engineered wood < 14" wide.
- P5 trowel or larger must be used with all solid woods and when applying over gypsum-based subfloor.
- Room temperatures should be between 50°F and 90°F during installation unless otherwise specified limitations by wood flooring manufacturer.
- Do not use on wet, contaminated or friable substrates.
- When needed Sika recommends the use of Portland Cement based patching and levelling compounds for best results.
- Gypsum based sub-floors are very susceptible to excess moisture and will be degraded if exposed to excess moisture from below or above.
- Below grade installations are typically more difficult to control moisture and room humidity levels – if this cannot be done sufficiently then below grade applications should use structurally sound Engineered hardwood only.
- Do not use in areas subject to hydrostatic head or in areas subject to secondary source of moisture.
- Do not use over concrete with curing compounds, sealers or other surface treatments that could impact the adhesion.
- This adhesive will not prevent moisture related damage to wood flooring installations.
- Sub-floor should be level – do not use adhesive as a levelling agent.
- Cutback or other asphaltic based residue should be removed.
- Chemically treated woods (ammonia, wood stain, timber preservatives, etc.) and woods with high oil content must be tested for adhesion prior to application.
- Adhesive should be kept above 60°F for best workability.
- Sufficient ambient moisture is necessary for proper curing.
- Solid wood applications are best performed by an experienced installer.
- When bonding solid wood Sika recommends the use of straps to fully connect tongue and groove – especially when wood pieces are not perfectly straight – ensure starter rows are set and properly cured to handle tension from straps.
- Installations over radiant heat require that slab temperature be kept below 70°F during installation and for 48 hours after installation – then raised slowly up to final desired temperature. Follow wood floor manufacturer's temperature guidelines.

Wood floors in non-insulated areas or areas without a damp proof membrane, must only be installed after the application of Sika® Primer MB to control the moisture, if within product limitations. For detailed instructions consult the Product Data Sheets or contact our Technical Service. In case of chemically pre-treated types of wood floors (e.g. ammonia, wood stain, timber preservative or woods that have been pre-sealed on the back side) and woods with high oil content SikaBond should only be used if adhesion tests are run by applicator prior to starting application. Do not use on PE, PP, TEFLON, and certain plasticized synthetic materials. (Carry out pre-trials). Some primers can negatively influence the adhesion of SikaBond (pre-trials suggested). Do not expose SikaBond to alcohol; this will impact the curing of the SikaBond.

Health and Safety Information

Caution	IRRITANT, SENSITIZER. Contains Polyisocyanate Prepolymers (Mixture), Naptha (CAS: 64742-82-1) and Xylene (CAS: 1330-20-7). Causes eye irritation. May cause skin/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged contact. May be harmful if swallowed. Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. Headaches and dizziness may result. Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions.
First Aid	Eyes – Hold eyelids apart and flush thoroughly with water for 15 minutes. Skin – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. Inhalation – Remove to fresh air. Ingestion – Do not induce vomiting. Dilute with water. Contact physician. In all cases contact a physician immediately if symptoms persist.
Handling & Storage	Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and laundry before reuse.
Clean Up	Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and placed in suitable sealed container. Dispose of excess product and container in accordance with applicable local, state, and federal regulations. In case of emergency, call Chemtrec 1-800-424-9300.

KEEP CONTAINER TIGHTLY CLOSED • KEEP OUT OF REACH OF CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s). Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikacorp.com or by calling 800-933-7452.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Technical Data Sheet, product label and Material Safety Data Sheet which are available online at www.sikaconstruction.com or by calling Sika's Technical Service Department at 800-933-7452. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Technical Data Sheet, product label and Material Safety Data Sheet prior to product use.

Sika warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Technical Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKASHALL NOT BELIEABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKASHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Visit our website at www.sikaconstruction.com

1-800-933-SIKA NATIONWIDE

Regional Information and Sales Centers. For the location of your nearest Sika sales office, contact your regional center.

Sika Corporation
201 Polito Avenue
Lyndhurst, NJ 07071
Phone: 800-933-7452
Fax: 201-933-6225

Sika Canada Inc.
601 Delmar Avenue
Pointe Claire
Quebec H9R 4A9
Phone: 514-697-2610
Fax: 514-694-2792

Sika Mexicana S.A. de C.V.
Carretera Libre Celaya Km. 8.5
Fracc. Industrial Balvanera
Corregidora, Queretaro
C.P. 76920
Phone: 52 442 2385800
Fax: 52 442 2250537

Member
 **National Wood Flooring Association**

