

SILIKAL® R 90 Adhesive is a solvent free, fast curing 2-component adhesive compound based on a medium flexible Methacrylic resin for layer thicknesses of 1.5 – 3 mm, preferable 2 mm. The quick curing time of less than 1 hour and the excellent chemical resistance enables a fast working procedure.

### Application

The application is being recommended directly onto the asphalt or concrete surface without primer. It can be used for fixing metal or PVC profiles to walls or floors, as well as tiles, concrete blocks like curb stones, road marking cat eyes, polymer concrete parts or prefabricated braille tiles. Surface must be dense, dry, dust and oil free. On top of cementitious substrates an appropriate curing and adhesion test has to be performed. Since the application is very simple, ordinary comb trowels can be used.

Calculate the area per m<sup>2</sup> and thickness of 2 mm in average. A thickness can vary depending on the evenness of the surface and item. A 2 mm thickness in average means a consumption of appr. 4 kg/m<sup>2</sup>. Mix the calculated amount of the SILIKAL® R 90 Adhesive with the right amount of BPO Hardener Powder (see table). Stir for 1 minute and avoid lumps in the mixture. Masking tape can be used to collect the surplus adhesive beside the fixed item for protection.

Potlife is appr. 10 – 15 minutes. Curing time about 1 hour.

### Technical datas

Property	Measuring method	Approx. value
Viscosity	Visual	Pasty, thixotrope
Specific Gravity	EN ISO 2811-2	1.75 g/cm <sup>3</sup>
Flash point	DIN 51 755	+10 °C
Pot Life at +20 °C	10 – 15 min.	
Application Temperature	+5 °C to +40 °C	
Hardening Time +20 °C	1 hour	
Colour	Visual	Not pigmented
Recommended Thickness	Wet film comb	2 mm (1.5 – 3 mm)
Consumption	Weight	2 kg/m <sup>2</sup> per 1 mm thickness
Packing Unit	5 kg pail	
Labelling	Flam. Liq. 2, Skin Irrit. 2, Skin Sens. 1	
Storage	min. 6 months < +30 °C	

### Amount of BPO Hardener Powder depending on surface and item temperature

Temperature	Hardening powder % pbw. *
+5 °C	2.0
+10 °C	1.5
+15 °C	1.0
+20 °C	1.0
+25 °C	1.0
+30 °C	1.0
+35 °C	0.5
+40 °C	0.5

### Tool cleaning

Use Ethylacetate, Acetone or MEK.