



A SIKA BRAND

PRODUCT DATA SHEET

Casco[®] XtremFix +

STRONG MOISTURE CURING ASSEMBLY MASTIC WITH HIGH INITIAL TACK
ADJUSTABLE THE FIRST MINUTE



DESCRIPTION

XtremFix+ is a 1-component strong moisture curing assembly mastic with sealing properties and excellent adhesion to most materials. Solvent free.

USES

XtremFix+ designed for indoor and outdoor bonding of various objects such as stones, bricks, window and door sills, mirrors, wood beams and heavy moldings. The unevenness in the joint can be several millimetres.

CHARACTERISTICS / ADVANTAGES

- Extreme high initial grab
- Adjustment possible first minute
- Phthalate free
- High strength, mechanical resistant and E-modulus
- Very good ageing properties and temperature resistance
- No shrinkage and extremely good joint filling properties
- The product is listed in the database for building products that can be used in Nordic Swan Ecolabelled buildings.

PRODUCT INFORMATION

Composition	SMP (silane modified polymer)
Packaging	290ml cartridge, 12x290ml each box
Colour	White
Shelf life	XtremFix+ has a shelf life of 12 months from the date of production, if stored properly in undamaged, original, sealed packaging, and if the storage conditions are met.
Storage conditions	XtremFix+ shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C.
Density	Approx. 1400 kg/m ³
Solid content by weight	100%
Volatile organic compound (VOC) content	None
Consistency	Gun-grade thixotropic paste
Shore A hardness	~50 (after 28 d)
Tensile strength	2.2 MPa
Tensile strain at break	350%

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Tear propagation resistance	~10,0 N/mm	
Service temperature	-40°C to +80°C	
Consumption	1 Cartridge (290 ml) Yield	
	Yield	Dimensions
	~100 spots	Diameter = 30 mm
	~5 m bead (see note)	Thickness = 4 mm
		Nozzle diameter = 5 mm (~60 ml per linear meter)
	Note: For heavy objects more or thicker beads (up to ~120 ml per linear metre) maybe required.	
Sag flow	0 mm (20 mm profile, 23 °C)	
Ambient air temperature	+5 °C min. / +40 °C max.	
Substrate temperature	+5 °C min. / +40 °C max., min. 3 °C above dew point temperature	
Curing rate	3 mm the first 24 h. (23 °C / 50 % r.h.) Approx. 7 mm after 7 days at 23°C, extended under +5°C and at dense materials.	
Skinning time	Approx. 15 minutes (23°C / 50% RH)	

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be sound, clean, dry and free of all contaminants such as dirt, oil, grease, cement laitance, old sealants and poorly bonded paint coatings which could affect adhesion of the adhesive.

For optimum adhesion and critical, high performance applications the following priming and/or pre-treatment procedures shall be followed:

Non-porous substrates

Aluminium, anodised aluminium, stainless steel, galvanised

steel, powder coated metals or glazed tiles, slightly roughen surface with a fine abrasive pad.

Clean

and pre-treat using Sika® Aktivator-205 applied with a clean cloth.

Before bonding / sealing, allow a waiting time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, clean and pre-treat using Sika® Aktivator-205 applied with a clean cloth.

After a waiting time of > 15 minutes (< 6 hours). Apply Sika® Primer-3 N applied by brush.

Allow a further waiting time of > 30 minutes (< 8 hours) before bonding / sealing.

PVC has to be cleaned and pre-treated using Sika®

Primer-215 applied with a brush. Allow a waiting time of > 15 minutes (< 8 hours) before bonding / sealing.

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks, prime surface using Sika® Primer-3 N applied by brush.

Before bonding / sealing, allow a waiting time of > 30 minutes (< 8 hours).

For more detailed advice and instructions contact Sika Technical Services.

Note: Primers are adhesion promoters and not an alternative to improve poor preparation / cleaning of joint surfaces. Primers also improve the long term adhesion performance of a sealed joint.

APPLICATION METHOD / TOOLS

Bonding Procedure

After the necessary substrate preparation, prepare the end of the cartridge before or after inserting into the sealant gun then fit the nozzle.

Apply in triangular beads, strips or spots at intervals of a few centimetres each. Use hand pressure only to fix the components to be bonded into position before skinning of the adhesive occurs. Incorrectly positioned components can easily be unbonded and repositioned during the first few minutes after application. If necessary,

use temporary adhesive tapes, wedges, or supports to hold the assembled components together during the initial curing time.

Fresh, uncured adhesive remaining on the surface must be removed immediately. Final strength will be reached after complete curing of Sikaflex®-118 Extreme

Grab, i.e. after 24 to 48 hours at +23 °C, depending on the environmental conditions and adhesive layer thickness.

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CLEANING OF EQUIPMENT

Remove all excess sealant adjacent to joint and on equipment prior to cure with a rag. White spirit or technical ethanol is used if necessary. Seal Remover is recommended if the adhesive has cured, otherwise cured adhesive is removed mechanically.

On skin, uncured sealant is wiped off with a rag, then wash with soap and water.

Keep out of reach of children.

Do not empty into drains.

FURTHER INFORMATION

Safety Data Sheet

IMPORTANT CONSIDERATIONS

LIMITATIONS

The access of moisture to the adhesive to be cured is essential. Cold and dry surroundings will slow the cure significantly.

When gluing watertight surfaces, moisture access must be secured. A combination of watertight surfaces and dry conditions can give an unacceptable slow cure.

Adhesion problems can also occur as a result of lack of moisture. If cure time is important, always pre-test the design under the worst conditions anticipated.

Over painting works well with many paint products.

Pretesting of drying and adhesion of the paint is always recommended. The adhesive is elastic and can flex a little over the joint. This will lead to cracking of most types of paint.

If XtremFix+ is used together with polyurethane systems, note the following:

XtremFix+ releases alcohol during cure, which can affect the curing of the polyurethane adversely. The polyurethane probably consumes water during cure. If access to water is limited, this can affect the cure and adhesion of XtremFix+. It is no problem to use XtremFix in combination with polyurethane's, if the product applied first is allowed to cure fully before the second product is applied.

Not suitable for continuous under water applications. Not suitable as joint sealant.

Among others not recommended for lead, PE, PP, Teflon, wax, neoprene and bitumen surfaces, always carry out an adhesion test on the substrate before application.

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.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

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 Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTES

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

Sika Danmark A/S

Hirsemarken 5
3520 Farum
Tlf. +45 48 18 85 85
www.sika.dk



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