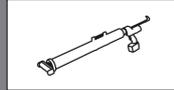


SCHÖNOX® iLINE® 400

easy to apply, universal SMP-wood adhesive for all kind of wood

suitable for bonding all types of parquet on suitable substrates in interior areas as well as in rooms with expected fluctuations in room climate. The application of the adhesive is done ergonomically using SCHÖNOX iLINE APP.



Product characteristics

- approved by the building authorities
- Emission tested building product according to ABG - approval no. Z-155.10-221
- EMICODE EC 1^{PLUS}: very low emission
- solvent-free according to TRGS 610
- fulfills the requirements of DIN EN 17178
- hard elastic glue line
- on many substrates no priming required
- component for SCHÖNOX iLINE APP
- impact sound reducing
- waterfree, no expansion of wood
- adhesive residues easy to remove
- optimum ridging
- low consumption / high coverage
- suitable for application on subfloor heating systems
- low odour
- maximum emptying of residues with SCHÖNOX iLINE APP
- one component
- ready for use
- long storage life
- no waiting time
- long open time

Applications

SCHÖNOX iLINE 400 is suitable for bonding of:

- block parquet, strip parquet (≥ 15 mm thickness)
- oily types of wood
- mosaic parquet, lamparquet (see instructions)
- vertical finger parquet ($l \geq 160$ mm, $w \geq 8$ mm, $t \geq 22$ mm)
- Wood paving RE/WE according to standard (Pay attention to the details given in the product data sheet of SCHÖNOX EB V)
- solid hardwood boards ≥ 15 mm thickness (thickness / width ratio max. 1:10) up to 1200 mm length

- multi-layer parquet elements - double layer up to 1500 mm or triple layer parquet up to 2400 mm length - according to EN 13 489
- smoked oak (free of hurtful residual ammonia)
- SCHÖNOX insulation and uncoupling underlayments on absorbent and non absorbent substrates in interior areas
- For the gluing of solid olive parquet, thermal treated parquet and parquet type of wood Ipé/Lapacho we recommend SCHÖNOX PU 960 PARKETT.
- Not suitable for parquet floors in industrial areas with hand-lift or fork-lift traffic.

Requirements of substrate

- Adequate strength, evenness, dimensional stability and dryness.
- Free of residues which reduce adhesion, e.g. dust, dirt, oil, fat and loose particles.
- Surface treatments or any "friable" areas of the subfloor must be mechanically removed and the subfloor repaired with SCHÖNOX leveling compounds as required.
- Old adhesive residues and levelling layers with no sufficient hardness should be removed completely by suitable mechanical means.
- The requirements of DIN 18 356 "Parquet work" and DIN 18 367 "Wood block work" are applicable.
- For massive parquet floating laid chip-board/OSB-boards should be laid in two layers, bonded and screwed with lateral offset (at least twice as thick as the used parquet)
- For straight edged parquet species and for parquet units > 800 mm length, substrate should have an evenness tolerance according to DIN 18 202 of ≤ 2 mm/m.

Technical data

- Basis: SMP
- Color: beige
- Density: 1,7 kg/l
- Storage temperature: not below $+ 5$ °C
- Application temperature: not below $+ 18$ °C, not above 65 % rel. air humidity
- Material consumption: blast pipe 290/3,5 mm appr. 900 g/m²
blast pipe 380/3,0 mm appr. 1000 g/m²
- Waiting time: none
- Skin formation: after approx. 30 min
- Open time: approx. 30 - 45 min
- Setting time: approx. 24 hours
- Further processing of the wood: after 24 to 48 hours¹

All values are approximate, are subject to local climatic fluctuations and vary according to the absorbency of the substrates and the applicator device.

¹With adjusted relation of humidity of the wood to humidity in the air at the site possible



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- The requirements according to DIN 68 702 apply to wood block flooring.
- Sound, even surfaces with absorbency level appropriate to use are achieved by using SCHÖNOX ZM, SCHÖNOX HS 10, SCHÖNOX HS 50, SCHÖNOX HS 10 F or SCHÖNOX ZM RAPID.
- SCHÖNOX APF and SCHÖNOX AM are also suitable for laying parquet on. Ensure the levelling compound is well dried through.
- on mineral substrates SCHÖNOX KH FIX Mixing ratio 1:4, can be used to bind adherent residual dust before laying parquet (drying time ≥ 60 min.).
- alternativ on mineral substrates SCHÖNOX HP RAPID, can be used to bind adherent residual dust before laying parquet (drying time ≥ 2 hours).
- Mastic asphalt screeds, resistance to indentation class IC 10 and IC 15, should be primed with a single-layer SCHÖNOX HP RAPID (Drying time min. 2 hours).
- Rooms in buildings without a basement, are to be sealed against rising dampness in compliance with the standard.
- Refer to the parquet manufacturer's technical product information for parquet substrate requirements.
- The requirements of the relevant valid standards, guidelines and data sheets apply.

Recommended method of working

- SCHÖNOX iLINE 400 is ready for use.
- Parquet that is bonded with SCHÖNOX iLINE 400 should be conditioned and requires a wood humidity corresponding to the medium seasonal climate of 20 °C and 50 % rh (normally wood humidity at average $9\% \pm 2\%$ for single bars; multi-layer parquet $8\% \pm 2\%$).
- The moisture content of massive parquet should be detected before laying according to EN 13 183-2.
- For laying parquet there is an optimum room climate - room temperature > 18 °C, relative humidity < 65 % - assumed. As a basic rule applies: room climatic laying conditions = room cli-

matic using conditions. With a wood humidity of normally 9 % / 8 % a room temperature of 22 °C and a relative humidity of approx. 50 % is necessary. This equates to the wood-physical laws and the optimal climate for parquet floors.

- Apply the adhesive evenly with SCHÖNOX iLINE APP to the substrate using the blast pipe. If wetting is insufficient adjust the bore diameter of the blast pipe or slow down the spreading speed.
 - Use the nozzle strip 380 / 3.0 mm for small parquet strips (like mosaic parquet, vertical finger parquet). The glue lines are closer.
 - Apply only as much adhesive as can be laid with parquet within 30 - 45 min.
 - Lay the parquet directly into the adhesive with light sliding. Tap it firmly and, if necessary weigh it down. Ensure adequate wetting.
 - The distance between the wall and the parquet to be laid (according to the kind of parquet and the size of the room) should be at least 1 to 2 cm.
 - Sand and seal not before the adhesive is fully cured.
- Adjust the working width:
- If it is necessary to reduce the working width for smaller formats, it is possible to close single bore holes with flat headed screws (4 x 10 mm) or adhesive tape.

Packaging

- 2 x 7,3 kg cubular bag in a covering box

Storage

- Store SCHÖNOX iLINE 400 in cool, dry, frost-free conditions.
- Storage life of 18 months (in closed packaging).
- Opened packages should be closed immediately and used up as soon as possible.

Disposal

- Empty packaging completely and dispose of in accordance with regulations
- For the disposal of product residues, waste water and containers with adher-

ent product residues please follow the local governmental regulations.

EMICODE

- EC 1^{PLUS}: very low emission

GISCODE

- RS 10 - laying materials methoxysilane based

EPD - Self-declaration

- Sika Deutschland GmbH declares that the product fulfills the criteria of one Environmental Product Declaration acc. to ISO 14025 and EN 15804
- Declaration available for download at www.schoenox.com at SCHÖNOX iLINE 400

Instructions

- When laying parquet without tongue and groove, please ensure complete wetting. Primarily at the ends, inadequate wetting can lead to moving of the parquet planks on the elastic adhesive ridge. After laying and a waiting time of appr. 30 minutes roll the parquet with a roller. It might be necessary to level the substrate to achieve adequate evenness.
- A strong increase of wood moisture of massive parquet can lead to irreversible deformation.
- Take care to ensure that no adhesive is squeezed between the parquet elements and comes into contact with oils or wood varnish. Carefully insert each element in to the adhesive bed and press evenly.
- Clean tools immediately after use with SCHÖNOX FIX CLEAN.
- Wipe off impurities on sealed surfaces immediately and remove residual bloom with a suitable cleaning agent (e.g. SCHÖNOX FIX CLEAN).
- Hardened material can only be removed mechanically.
- Follow the parquet manufacturer's laying instructions. If in doubt, we recommend testing a small area.
- The product data sheets of further add-on products should be observed.

SCHÖNOX® iLINE® 400

The applicable recommendations, guidelines, DIN regulations and safety data sheets are to be observed, together with the recognised architectural and engineering regulations. We guarantee that our products leave the factory in perfect condition. While our recommendations for use are based on tests and practical experience, they can only provide general guidance without any assurance as to product characteristics, since we have no influence over the conditions on site, the execution of the work or the method of processing. This product data sheet supersedes all previous editions.



The Sika management system is certified to ISO 9001 and 14001 by SGS

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