

## PRODUCT DATA SHEET

# SikaTherm®-155 MA

Water-based adhesive for flocking applications

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaTherm®-155	Component B SikaTherm®-011
Chemical base	Acrylate dispersion	Polyisocyanate
Color (CQP001-1)	White, black	Colorless (UV), dark blue, dark black
Cure mechanism	Polyaddition	
Density (uncured)	1.00 kg/l	1.20 kg/l
pH value (CQP004-1)	8	
Solid content	35 %	
Mixing ratio	by weight 100 : 2.5 by volume 100 : 2.1	
Viscosity (by Brookfield)	RVT, Sp. 4/20 rpm RVT, Sp. 2/10 rpm	4 600 mPa·s <sup>A</sup> 650 mPa·s <sup>A</sup>
Coat weight	wet	150 – 400 g/m <sup>2</sup>
Application temperature	15 – 25 °C	
Pot-life	8 hours <sup>B</sup>	
Drying time (CQP565-1)	90 minutes <sup>B</sup> in drying tunnel at 50 °C 40 minutes in drying tunnel at 70 °C 20 minutes	
Shelf life	6 months	12 months

CQP = Corporate Quality Procedure

A) at 20 °C

B) 23 °C / 50 % r.h.

## DESCRIPTION

SikaTherm®-155 MA is a water-based adhesive, which can be used as a 1-component product. With the use of the hardener, the adhesion performance and water and abrasion resistance of SikaTherm®-155 MA can be improved.

It is designed for flocking applications and can be applied by spray, roller or brush.

## PRODUCT BENEFITS

- Good leveling behavior
- Broad adhesion range
- Can be used as 1-component product
- High abrasion resistance in wet and dry state
- Good heat and weathering resistance

## AREAS OF APPLICATION

SikaTherm®-155 MA is suitable for permanent bonding of polar plastics as well as for wood, foam, textiles, painted and primed steel. Non polar plastics like PP and PE can be bonded after proper pre-treatment.

SikaTherm®-155 MA is specially designed for flocking applications of flat and 3D shapes. This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

The curing of SikaTherm®-155 MA starts after the evaporation of water. When used in combination with the hardener, after the evaporation process, the chemical crosslinking with the hardener takes place. At room temperature the full curing is completed after 72 hours. Higher temperatures speed up and lower temperatures slow down the curing and drying process.

CHEMICAL RESISTANCE

SikaTherm®-155 MA is temporarily resistant to aqueous surfactant, weak alkaline/ acids solutions, fuels, solvents and mineral oils. The chemical resistance is influenced by several factors such as chemical composition, concentration, period of exposure and temperature. Therefore a project related testing in case of chemical or thermal exposure is required.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Based on the substrates a physical or chemical pre-treatment might be required. All pre-treatment steps must be confirmed by preliminary tests on original substrates.

Mixing process

Both components must be mixed homogeneously in the right mixing ratio. Consider, SikaTherm®-155 MA is not suitable for automated mixing devices. Care must be taken to avoid air inclusion.

Application

SikaTherm®-155 MA is typically applied by spray, roller or brush. The application parameters and the subsequent processing vary depending on the application and the process used (vacuum or press lamination, two- or one-sided application, flocking, etc.). Consider, if processing SikaTherm®-155 MA by spray application, inhalation of substances must be prevented by suitable air extraction or other means

The Product can be dried at ambient condition as well as in a drying tunnel. The drying time at 50 °C shall not exceed 40 minutes, and at 70 °C it shall not exceed 20 minutes. In case of automated dosing applications a suitable filter system must be installed. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured SikaTherm®-155 MA may be removed from tools and equipment with warm water. Once cured, the material can only be removed mechanically. Hands and exposed skin shall be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin.

STORAGE CONDITIONS

SikaTherm®-155 is frost sensitive and has to be stored at temperatures between 5 °C and 25 °C in a dry place. SikaTherm®-011 has to be stored at temperature below 30 °C in a dry place.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry. Copies of the following publications are available on request:

- Safety Data Sheet
- Application Manual
- SikaTherm®

PACKAGING INFORMATION

SikaTherm®-155 (A)

Pail	25 kg
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SikaTherm®-011 (B)

Can	1.25 kg
Drum	155 kg

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

PRODUCT DATA SHEET

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