

Sealing and bonding for HVAC applications

Versatile solutions with certified performance



LEARN. WATCH. APPLY.



ELASTIC BONDING COMPENDIUM

Dive deeper into the key principles and guidelines of elastic adhesive technology.

- **Key principles & technology**
for elastic adhesive solutions.
- **Design & application guidelines**
for industrial use.
- **Practical reference for engineers**
and production teams.



BETTER BONDED VIDEO HUB

Watch, learn and apply – step-by-step. Practical videos for your daily work.

- **Step-by-step application videos**
from surface preparation to final assembly.
- **Expert tips & tricks**
from bonding specialists.
- **Stronger bonds**
through easy learning and guidance.



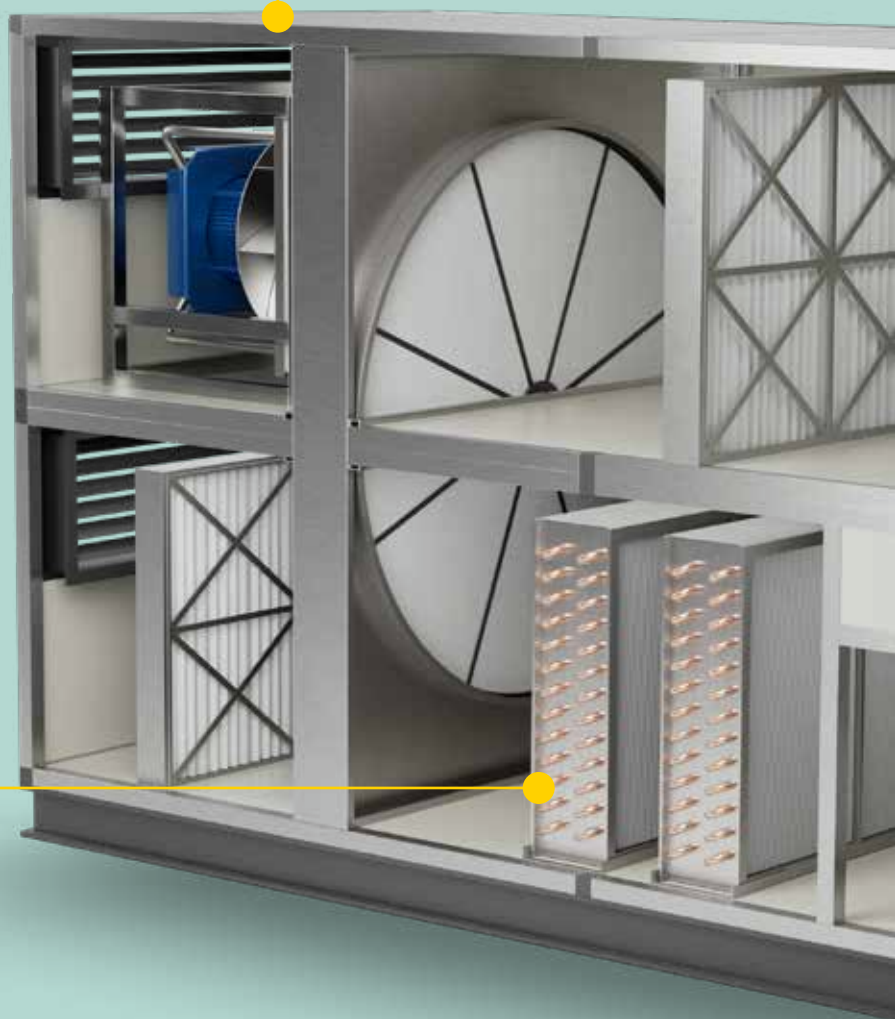
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APPLICATION OVERVIEW

General & Hygiene
Sealing

Condensate
Drain Pan



Cladding Panels
Bonding



Inspection Window
Bonding



EASY. VERSATILE. CERTIFIED.

VERSATILE SOLUTIONS WITH CERTIFIED PERFORMANCE

YOUR BENEFITS



CERTIFIED & INDUSTRY-APPROVED

- Compliant with HVAC and hygiene standards
- Supports DIN EN 1886 leakage and airtightness targets
- Selected technologies with ISEGA and IPA certifications



EASY & EFFICIENT APPLICATION

- Broad adhesion on multiple substrates, often primerless
- User-friendly : reduced process steps and simplified handling
- Fewer products covering multiple applications and production needs



SCALES WITH YOUR NEEDS

- Scalable from manual assembly to fully automated production
- Flexible packaging and processing concepts



IMPROVED OCCUPATIONAL SAFETY

- Low odor and pleasant to work with
- No REACH training required

GENERAL ELASTIC SEALING



Sikaflex®-522

- Versatile solution for HVAC applications
- Certified hygiene performance (VDI 6022)
- Excellent resistance against weathering & ageing
- Broad adhesion on many substrates without primer

CLADDING PANEL

MINERAL WOOL



SikaForce®-110 CT55

- Long open time
- Foaming adhesive for mineral wool core
- Low isocyanate content

PU CORE



SikaForce®-710 L35

- Room temperature curing
- Free from solvents
- Self leveling

CONDENSATE DRAIN PAN BONDING



SikaFast®-555 L05

- Instant handling strength
- Minimal surface preparation
- High mechanical strength

HYGIENE & GENERAL SEALING



INSPECTION WINDOW BONDING



Sikaflex®-522

- **Certified (Hygiene) Performance**
VDI 6022, DIN EN ISO 846, IPA, ISEGA, and much more
- **Outstanding Resistance To Weathering & Ageing**
Ensures long-term performance, even in demanding environments
- **Primerless Adhesion On A Wide Range Of Substrates**
Simplifies application and reduces processing time and cost



	Product	Art. No.	Size	Colour	Box Content
Pretreatment	 Sika® Remover-208	135750	400 ml	transparent	12 pc
		117569	1 L	transparent	4 pc
	 Sika® Aktivator-205	3209	30 ml	transparent	24 pc
		423806	250 ml	transparent	6 pc
		117498	1 L	transparent	4 pc
Adhesives	 Sikaflex®-522	688219	300 ml	black	12 pc
		634863	300 ml	white	12 pc
		688360	300 ml	steel grey	12 pc
		724935	400 ml	steel grey	12 pc
		538816	600 ml	white	20 pc
		573590	600 ml	steel grey	20 pc
Tools	 Airpressure Dispenser for 1K cartridges	598490	–	–	1 pc
	 Airpressure Dispenser for 600 ml unipack	65017	–	–	1 pc

CLADDING PANELS



Mineral Wool Core

SikaForce®-110 CT55

- **Extended Open Time**
Enables reliable bonding of large panels and complex assemblies with sufficient processing
- **Foaming Behavior For Durable Bonding**
Expands, ensuring effective bonding with mineral wool
- **Low Isocyanate Content**
Enhance occupational safety during handling and processing



PU Core

SikaForce®-710 L35

- **Room Temperature Curing**
Enables efficient and easy processing without additional heat input
- **Safe**
Solvent-free formulation supports occupational safety
- **Versatile Material Compatibility**
Suitable for bonding metals, composites and typical core materials e.g. PU foam, polystyrene



	Product	Art. No.	Size	Colour	Box Content
Pretreatment	 Sika® Remover-208	135750	400 ml	transparent	12 pc
		117569	1 L	transparent	4 pc
Adhesives	 Sikaforce®-110 CT55	91236	25 kg	yellowish	1 pc
		490877	265 kg	yellowish	1 pc
	SikaForce®-710 L35 (Kit A+B)	183330	1,2 kg	beige	6 pc
	SikaForce®-710 L35 (A)	136247	25 kg	beige	1 pc
		91287	300 kg	beige	1 pc
	SikaForce®-710 L35	691444	1,5 kg	beige	1 pc
		91237	5 kg	beige	1 pc
	SikaForce®-010 (B)	91238	20 kg	beige	1 pc

CONDENSATE DRAIN PAN (STAINLESS STEEL)



SikaFast®-555 L05

- **Instant Fixation – Fast Assembly**
Handling strength in minutes for quick positioning and reduced cycle time
- **Easy Application – No Complex Preparation**
Bonds a wide range of substrates with little or no surface preparation
- **High Mechanical Strength – Reliable Performance**
High strength and impact resistance you can rely on



SikaFast® Application Tools

2-COMPONENT DISPENSER



CARTRIDGE



STATIC MIXER



	Product	Art. No.	Size	Colour	Box Content
Pretreatment	 Sika® Remover-208	135750	400 ml	transparent	12 pc
		117569	1 L	transparent	4 pc
Adhesives	 SikaFast®-555 L05	571661	50 ml	grey	12 pc
		135750	250 ml	grey	12 pc
Tools	 Application Gun for SikaFast®-555 L05 – 50 ml	74866	–	–	1 pc
	 Static Mixer SikaFast®-555 L05 – 50 ml	74867	–	–	12 pc
	 Application Gun for SikaFast®-555 L05 – 250 ml	452901	–	–	1 pc
	 Static Mixer SikaFast®-555 L05 – 250 ml	411774	–	–	12 pc

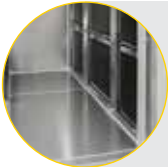
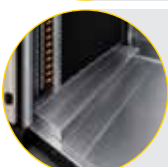
APPLICATION GUIDE





STEP-BY-STEP APPLICATION

THE RIGHT SOLUTION FOR EVERY APPLICATION

	CLEANING	PRETREATMENT	ADHESIVE
 GENERAL & HYGIENE SEALING	 Sika® Remover-208	 Sika® Aktivator-205	 Sikaflex®-522
 INSPECTION WINDOW BONDING			 Sikaflex®-522
 CLADDING PANELS MINERAL CORE		No pretreatment	 SikaForce®-110 CT55
 CLADDING PANELS PU CORE			 SikaForce®-710 L35
 CONDENSATE DRAIN PAN BONDING			 SikaFast®-555 L05

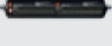
EASY PRETREATMENT AND APPLICATION

For further information on surface pretreatment, please check our pretreatment chart.



SCALES WITH YOUR NEEDS

FLEXIBLE SOLUTION FOR EVERY PRODUCTION STAGE

		MANUAL APPLICATION			FULL AUTOMATION	
		 OTHER PACKAGES	 CARTRIDGE	 UNIPACK	 PAILS	 DRUMS
	Sikaflex®-522	✓	✓	✓	✓	✓
	SikaFast®-555 L05	✓	✓			
	SikaForce®-110 CT55				✓	✓
	SikaForce®-710 L35 A	✓			✓	✓
	B					✓

Sikaflex®-522 available in multiple colors



WHITE



LIGHT GREY

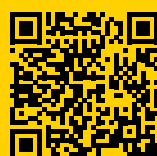


STEEL GREY



BLACK

Adapts to your design and material requirements.



Ready to get started?
Check out our website
with more information.
www.sika.com/aftermarket

RELIABLE SOLUTIONS. CERTIFIED PERFORMANCE.

CERTIFIED SOLUTIONS

Our products are tested and certified to meet the highest standards for hygiene, emissions and durability in HVAC applications

Sikaflex®-522

Universal sealant



Hygiene in
ventilation
systems



DIN EN ISO 846
Microbial
metabolisation tested



Cleanroom
suitable



Indirect Food
Contact
Compliance



Solvent Free



Very low
emission

SikaForce®-110 CT55

Sandwichpanel – Mineral Wool



Low isocyanate
content

SikaForce®-710 L35

Sandwichpanel – PU Core



Solvent Free

SikaFast®-555 L05

Fast structural Adhesive



Low Odour
than products
containing MMA



Solvent- and
Acid-Free

7 CARBON TRANSPARENCY



Product Carbon Footprints (PCFs) available for selected products to support ESG reporting, LCA calculations and sustainability targets.

STRONGER CONNECTIONS. SMARTER CONSTRUCTIONS.

SikaPower®-880

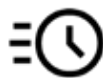
2-component epoxy adhesive for stronger assemblies.



HIGH STRENGTH & TOUGHNESS
23 MPa lap shear strength



MATERIAL VERSATILITY
Suitable for metals, CFRP & GFRP



GOOD PROCESSABILITY
Long open time, easy application,
optional heat acceleration



DEFINED BOND LINE
0.3 mm glass beads ensure
consistent thickness

MORE ABOUT METAL BONDING



BONDING OF CORNER JOINTS

Structural bonding of HVAC frame corner connections for stronger constructions.



BONDING OF STIFFENING PROFILES

Bonding of reinforcement and stiffening profiles to panels for increased rigidity and performance.



YOUR BENEFITS



FASTEN LESS. ACHIEVE MORE.

Replaces or reduces mechanical fastening in frame corner constructions



SAFE STRUCTURES MEETING STANDARDS

Meet relevant safety requirements/ tests such as ROPS, FOPS

YOUR BENEFITS



INCREASED RIGIDITY & PERFORMANCE

Reduces stress peaks without thermal impact, improving panel stability and minimizing vibration.



LEANER PRODUCTION & FASTER ASSEMBLY

No drilling or welding marks, no rework—clean surfaces and simple bonding steps enable faster, more efficient assembly.

A Global Company But Local Partner

We are Sika

Sika is a specialty chemicals company with a leading position in the development and production of systems and products for bonding, sealing, damping, reinforcing and protecting in the building sector and the motor vehicle industry. Sika's product lines feature concrete admixtures, mortars, sealants and adhesives, structural strengthening systems, industrial flooring as well as roofing and waterproofing systems.

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.

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