

PRODUCT DATA SHEET

SikaCeram[®]-740

2 COMPONENT, POLYURETHANE RESIN ADHESIVE FOR TILE AND STONE

DESCRIPTION

SikaCeram[®]-740 is total solids, two-component, polyurethane tile adhesive for laying of ceramic tiles and natural stones on critical substrates such as metal, PVC and plastic-based layered panels. Suitable for use in hot and tropical climatic conditions.

USES

- For indoor and outdoor use
- For walls and floors
- For laying ceramic tiles, porcelain mosaic, brick tiles, clinker bricks, fully vitrified tiles and non-moisture sensitive natural stone tiles
- In swimming pools, pool surroundings, wet rooms and cold storage depots
- On cement screeds, ground anhydrite and/or gypsum based floated screeds, precast concrete elements, aerated concrete, heated screeds, plasterboards, gypsum fiber boards, dry screeds, insulation boards, plaster slabs and plaster
- For renovating old houses, prefabricated houses, for interior finishing and kitchen worktops
- On impermeable, smooth and vibrating substrates, e.g. old ceramic, natural stone, aluminium, steel, PVC covering and polyester substrate
- For bonding thick layers of non-structural, dry building elements
- For bonding non-structural, dry steel elements
- For fast-track tiling work, such as renovation of natural stones and ceramic coverings in residential buildings and commercial buildings, prefabricated houses, with only short interruptions in operation
- For tile-on-tile application (contact Sika representative for further information)

FEATURES

- Deformable and hard-elastic
- Fast and shrinkage-free curing
- Groutable after approx. 4 hours, able to bear weight after approx. 14 hours
- Suitable for laying of porous natural stones
- Especially suitable for fast-track tiling, e. g. for refurbishment work with only short interruptions in operation
- Flexible, adaptable to variations in temperature and expansions in the substrate
- Reliable bond to impermeable, smooth and vibrating substrates
- Impermeable to water and, to a sufficient degree, to water vapor
- Prevents moisture absorbing

CERTIFICATES AND TEST REPORTS

SikaCeram[®]-740 meets the requirements of EN 12004-1 for class **R2T**.

PRODUCT INFORMATION

Composition	Polyurethane resin	
Packaging	Part A (base)	9 kg plastic pail
	Part B (hardener)	1 kg plastic bottle with plastic liner placed within plastic pail (Part A)
	Part A+B (set)	10 kg
Colour	Off-White	
Shelf life	12 months from date of production	
Storage conditions	Store in undamaged, original sealed packaging in dry conditions at temperatures between +5 °C and +23 °C. Protect from direct sunlight, heat and moisture.	
Density	~1.75 kg/l (mixed, at 25 °C)	

TECHNICAL INFORMATION

Service temperature	-30 °C min. / +80 °C max.		
Shear adhesion strength	Initial	≥ 2.0 N/mm ²	(EN 12004-2)
	After thermal shock	≥ 2.0 N/mm ²	
	After water immersion	≥ 2.0 N/mm ²	

APPLICATION INFORMATION

Consumption	Consumption and coverage depends on the surface profile and roughness of the substrate, size and reverse profile of the tiles and the placing technique (simple placing "floating" or back to back "buttering-floating"). As a guide for simple placing technique: <table><tr><th>Required notch size:</th><th>Quantity of mixed material:</th><th>Theoretical coverage per 10 kg set:</th></tr><tr><td>4 mm</td><td>~2.4 kg/m²</td><td>~4.1 m²</td></tr><tr><td>6 mm</td><td>~3.0 kg/m²</td><td>~3.3 m²</td></tr><tr><td>Solid bed application</td><td>~1.8 kg/m²/mm thickness (thk.)</td><td>~5.5 m² at 1 mm thk. ~2.8 m² at 2 mm thk.</td></tr></table> Note: All figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level, wastage or any other variations. Apply product to a test area to calculate the exact consumption for the specific substrate conditions and proposed application equipment.			Required notch size:	Quantity of mixed material:	Theoretical coverage per 10 kg set:	4 mm	~2.4 kg/m ²	~4.1 m ²	6 mm	~3.0 kg/m ²	~3.3 m ²	Solid bed application	~1.8 kg/m ² /mm thickness (thk.)	~5.5 m ² at 1 mm thk. ~2.8 m ² at 2 mm thk.
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4 mm	~2.4 kg/m ²	~4.1 m ²													
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Solid bed application	~1.8 kg/m ² /mm thickness (thk.)	~5.5 m ² at 1 mm thk. ~2.8 m ² at 2 mm thk.													
Layer thickness	1 mm min. / 5 mm max.														
Ambient air temperature	+10 °C min. / +35 °C max.														
Dew point	Beware of condensation. Substrate temperature during application must be at least 3 °C above dew point.														
Substrate temperature	+10 °C min. / +35 °C max.														
Substrate moisture content	< 4 % pbw moisture content Test method: Sika®-Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM D4263 (Polyethylene-sheet).														
Pot Life	~40 min at 23 °C and 50 % relative humidity. Higher temperatures reduce, lower temperatures increase the times given.														
Open Time	~25 min at 30 °C and 50 % relative humidity. Higher temperatures reduce, lower temperatures increase the times given.														

Applied product ready for use

Light foot traffic	~4 hours
Groutable	~4 hours
Able to bear weight	~14 hours

Note: When applied on slightly absorbent substrates. Values determined in laboratory conditions: +23 °C ± 2 °C, R.H. 50 % ± 5 %. Higher temperatures will reduce the indicated waiting times, lower temperatures will increase the indicated waiting time.

BASIS OF PRODUCT DATA

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

FURTHER DOCUMENTATION

General Method Statement (GMS)

IMPORTANT CONSIDERATIONS

- Protect freshly applied material from adverse weather (high/low temperatures, rain, direct sunlight, wind, etc.) for at least 24 hours after application.
- Do not allow contact with water until the material is fully cured.
- Avoid application in direct sunlight.
- For natural stone or absorbent/porous tiles, conduct a cleanability and staining test before installation.
- Do not add water, solvents, or fillers.
- Remove contamination from the tile surface immediately using suitable cleaning agents (e.g. Sika® Cleaning Wipes).
- Underfloor heating systems may be commissioned after a minimum of 7 days at +23 °C, and the temperature should be increased gradually.
- For tile adhesive applications over waterproofing membranes, contact Sika Technical Department.
- Unless otherwise stated, all technical data are based on +23 °C and 50 % RH. Lower temperatures extend, and higher temperatures reduce, the stated values.
- Incorporate movement joints in the tile covering and seal them with an appropriate Sika® sealant. Refer to BS 5385 for standard jointing practice.
- Tile installation shall be carried out in accordance with the applicable international Codes of Practice.
- High ambient temperatures (e.g. 40 °C) will reduce the product's pot life and open time.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

- Substrates must be clean, dry, sound, and free from dust, grease, oil, wax, old coatings, curing compounds, cleaning agents, gypsum-based materials, and other contaminants.
- Substrates shall comply with the relevant standards, including minimum age and residual moisture requirements.
- Degrease steel and other metal substrates (e.g. with xylene, MEK, or acetone), remove rust, and apply a suitable corrosion protection coating (e.g. SikaCor® range).
- Completely remove existing waterproof adhesives by mechanical means.
- Remove wax from existing PVC coverings and clean thoroughly; mechanically abrade if required.
- Mechanically abrade existing polyester and GRP substrates, then clean with a suitable solvent (e.g. xylene, MEK, or acetone).
- Thoroughly clean existing, well-bonded ceramic tiles using a black pad or equivalent mechanical cleaning method.
- Prime absorbent cementitious and calcium sulfate-based substrates with an appropriate Sika® primer before adhesive application. Contact Sika's Technical Service Department for advice.

MIXING

- Remove Part B from the pail and remove it from the plastic liner.
- Add Part B (hardener) to Part A (base) and mix thoroughly using a low-speed mechanical mixer (≈300 rpm) until a homogeneous, streak-free consistency is achieved.
- Avoid overmixing to minimize air entrapment.
- Transfer the mixed material into a clean container and re-mix briefly.
- Mix complete units only. Do not split kits or part-mix components.
- Mix only the quantity that can be applied within the stated pot life.

APPLICATION

- Apply SikaCeram®-740 in small quantities to the substrate to dissipate exothermic heat during curing.
- Apply a thin scratch coat using the flat edge of the trowel to ensure full substrate wetting.
- Comb additional adhesive with an appropriately sized notched trowel, covering only the area that can be tiled within the stated open time.
- Install tiles by firmly pressing with a twist-and-slide motion to achieve full adhesive contact and coverage. Adjust alignment as required.
- Support heavy or large-format vitrified tiles with suitable temporary wedges or spacers until the adhesive has cured.
- For moisture-sensitive substrates, first apply a minimum 1.5 mm thick, pore-free layer of SikaCeram®-740 to form a continuous water-impermeable layer.
- Seal pipe penetrations, internal corners, and floor-to-wall junctions using SikaCeram® WP Tape fully embedded in SikaCeram®-740.
- For large-format vitrified tiles not subjected to mechanical loading, the dot-and-dab or strip application method may be used on the tile reverse. Spread the adhesive to a uniform thickness with a notched trowel.
- Keep tile joints free from adhesive.
- For lath constructions or exceptionally level substrates, apply adhesive in approximately 100 mm wide strips to the lath and/or tile reverse, then comb to a uniform thickness using a notched trowel.

CLEANING OF EQUIPMENT

Clean all tools and application equipment using a suitable thinner (Xylene / MEK / Acetone), immediately after use. Hardened / cured material can only be removed mechanically.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use 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.

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ISO 9001, 14001, 45001 – SGS:
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ISO 9001, 14001 – SGS:
- Sika Saudi Arabia Limited
ISO 9001, 14001 – TÜV:
- Sika UAE LLC (Branch)
ISO 9001 – SGS:
- Sika MB LLC

All products are supplied under a management system certified to conform to the requirements of the quality, environmental and occupational health & safety standards ISO 9001, ISO 14001 and ISO 45001.



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