

Sikaflex®-295UV

Direct glazing adhesive for plastic glass in marine applications

Technical Product Data

Chemical base	1-C polyurethane
Colour (CQP ¹ 001-1)	Black, white
Cure mechanism	Moisture curing
Density (uncured) (CQP 006-4)	1.3 kg/l approx.
Non-sag properties	Good
Application temperature	10°C to 35°C
Tack-free time ² (CQP 019-1)	60 min. approx.
Curing speed (CQP 049-1)	see diagram 1
Shrinkage (CQP 014-1)	1% approx.
Shore A hardness (CQP 023-1 / ISO 868)	35 approx.
Tensile strength (CQP 036-1 / ISO 37)	1.1N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	500% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	5 N/mm approx.
Glass transition temperature (CQP 509-1 / ISO 4663)	-45°C approx.
Movement accommodation factor	12.5% approx.
Service temperature (CQP 513-1)	permanent
Short term	4 hours
	1 hour
Shelf life (storage below 25°C) (CQP 016-1)	cartridge / unipack
	hobbock
	12 months
	6 months

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C (73°F) / 50% r.h.

Industry

Description

Sikaflex®-295UV is a 1C polyurethane adhesive of paste like consistency that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-295 UV meets the requirements set out by the International Maritime Organisation (IMO). Sikaflex®-295 UV is manufactured in accordance with the ISO 9001/14001 quality assurance system and with the responsible care program.

Product Benefits

- 1-C formulation
- Fast cure time
- Short cut-off string
- Approved for the OEM market
- Resistant to ageing and weathering
- Suitable for organic glasses

Areas of Application

Sikaflex®-295 UV has been specially developed for the marine industry, where it is used to bond and seal plastic glazing materials in boats and ships. Because of its excellent UV-resistance this product can also be used to seal joints in areas of severe exposure. Seek advice from our Technical Service before using Sikaflex®-295 UV on thermoformed plastics. Suitable substrates include:

- Aluminum (bright or anodized)
- GRP (polyester resin)
- Stainless steel
- Timber
- 2-C coatings
- Plastic glazing materials (PC, PMMA)



Cure Mechanism

Sikaflex®-295UV cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly.

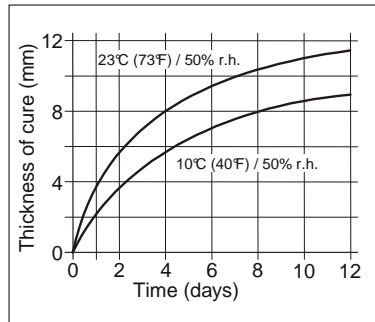


Diagram 1: Curing speed for Sikaflex®-295UV

Chemical Resistance

Sikaflex®-295 UV is resistant to fresh water, seawater, aqueous, chlorine free cleaning solutions and sewage effluent as well as diluted acids and caustic solutions. Temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils. Not resistant to organic acids, alcohol, concentrated mineral acids, caustic solutions or paint thinners. The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

Surfaces must be clean, dry and free from all traces of grease, oil and dust. As a rule the faces must be prepared in accordance with the instructions given in the current Sika® Primer Chart for Marine Applications.

Application

Cartridges: Pierce cartridge membrane. **Unipacs:** Place unipac in the sealant gun and snip off the closure clip. Cut off the tip of the nozzle to suit the joint and apply the adhesive with a suitable hand-operated or compressed air gun. Once opened, packs should be used up within a relatively short space of time. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive is

applied in the form of a triangular bead (see illustration). Correct joint design is essential when bonding plastic glazing materials and must take into account the special properties of these substrates. Do not apply at temperatures below 10°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C. For advice on selecting and setting up a suitable pump system, as well as on the techniques of pump operated application, please contact the System Engineering Department of Sika Industry.

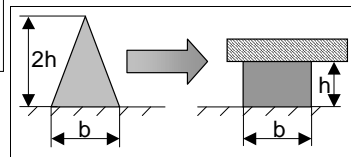


Figure 1: Recommended bead configuration

Tooling and finishing

Tooling and finishing must be carried out within the tack-free time of the adhesive. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for compatibility.

Removal

Uncured Sikaflex®-295UV may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Hand clean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Overpainting

Sikaflex®-295UV can be overpainted with most conventional paint systems. The paint must be tested for compatibility by carrying out preliminary trials and the best results are obtained if the sealant is allowed to cure fully first. Please note that non flexible paint systems may impair the elasticity of the adhesive, impair joint movement and lead to cracking of the paint film. PVC based paints and paints that dry by oxidation are generally not suitable for application over Sikaflex®-295UV and two pack paint systems are preferred.

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Primer Chart
- General Guidelines Bonding and Sealing with Sikaflex® products
- Sika Marine Handbook

Packaging Information

Cartridge	300 ml
Unipac	400 ml
Hobbock	23 l

Value Bases

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.

Health and Safety Information

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

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.

Further information available at:
www.sika.co.uk
www.sika.com

Sika Limited
Industry
Watchmead, Welwyn Garden City
Hertfordshire, AL7 1BQ
United Kingdom
Tel: +44 (0)1707 394444
Fax: +44 (0)1707 329129

