

Sikaflex®-291 LOT

Marine Adhesive and Sealant

Technical Product Data

Chemical base	1-C polyurethane
Colour	White, black, mahogany
Cure mechanism	Moisture Cure
Density (uncured)	1.21 kg/L
Application temperature product	5°C – 43°C
Tack free time ¹⁾	3 to 5 hours
Curing speed	(see diagram 1)
Shore A-hardness (ASTM D 2240)	40 to 45
Elongation at break (ASTM D 412)	700%
Peel strength	5.25 N/mm on fibreglass 4.38 N/mm on gelcoat
Tensile lap-shear strength (ASTM D 1002)	0.83 N/mm ²
Service range	-40°C to 82°C

¹⁾ 23°C / 50% r.h.

Description

Sikaflex®-291 LOT is a 1-component, marine grade polyurethane elastomeric adhesive and sealant. It is a moisture cured, non-sag system designed with a long open time for jobs that require more time. Sikaflex®-291 LOT is manufactured in accordance with ISO 9001 / 14001 quality assurance system.

Product Benefits

- Use above and below water line
- Resists salt water
- Long open time capability for humid climates or jobs requiring more time
- Paintable
- Versatile packaging
- Excellent bond
- Permanently elastic
- High strength
- Sandable
- NSF approved for potable water
- USDA approved for incidental food contact

Areas of Application

General all-purpose marine sealant, which may be used for light duty bonding.

This product is suitable for professional experienced users only. Test with actual substrates and conditions must to be performed to ensure adhesion and material compatibility.

Cure Mechanism

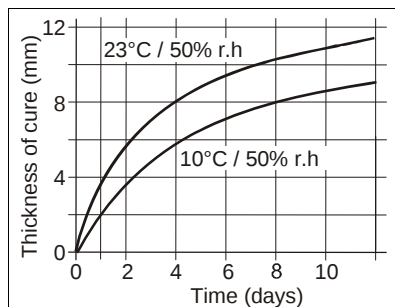


Diagram 1: Curing speed Sikaflex®-291 LOT

Chemical Resistance

Sikaflex®-291 LOT has very good long term resistance to fresh water, sea water, aqueous cleaning agents, weak acids and weak bases and to most teak oils. Brief contact with fuels and lubricants has no significant effect. It is recommended to test on a small area first to ensure compatibility. Sikaflex®-291 LOT has very reduced resistance to solvents, concentrated acids and bases and caustic solutions. Advice on specific applications will be given on request. Consult Sika Technical Service for additional information.

Method of Application

Surface preparation

Clean, dry, free of oil and grease, and of sound quality. Thoroughly remove all loose particles such as residues of color, splashes, etc. Clean surface with a strong jet of compressed air, sandblast, - solvent. Pretest substrates for adhesion. Cleaners and/or primers may be required to achieve optimal adhesion. Please refer to the Surface Preparation Guidelines for specific application information.

Application

Recommended application temperatures: 4°C to 43°C. For cold weather application, store units at approximately 21°C; remove just prior to using. Make sure joint is frost-free. Cut tip to joint size.

Puncture airtight seal. Install with hand or power operated gun.

For best performance, Sikaflex®-291 LOT should be gunned into joint when joint slot is at mid-point of its designed expansion and contraction.

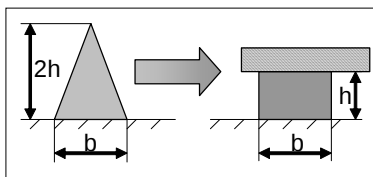


Figure 1: Recommended bead configuration

Tooling and finishing

To facilitate tooling, wet pointing tool or finger with soap solution.

Clean up

Uncured Sikaflex®-291 LOT may be removed from tools and equipment with mineral spirit or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using a suitable industrial hand cleanser and water. Do not use solvents.

Overpainting

Sikaflex®-291 LOT can be overpainted. If overpainting is desired, the paint and paint process compatibility must be tested before use.

Important

When applying sealant, avoid air entrapment. Protect from action of water during curing period.

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Primer Chart

Packaging Information

Cartridge	300 mL
Sausage	600 mL
Pail	17 L
Drums	190 L

Value Basis

All technical data stated in this Product Data Sheet and laboratory test based. Current measured values may vary due to factors beyond our control.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance.

All Product Data Sheets and Material Safety Data Sheets are also available on our web site.

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, within their shelf life. 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 recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet.

Further information available at:
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