



PRODUCT DATA SHEET

Sikaflex®-227 US

1-component fast skinning sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component polyurethane
Colour (CQP001-1)	White
Cure mechanism	Moisture-curing
Density (uncured)	depending on color 1.3 kg/L
Non-sag properties	Good
Application temperature	5 – 35 °C
Skin time (CQP019-1)	40 minutes ^A
Curing speed (CQP049-1)	(see diagram 1)
Shrinkage (CQP014-1)	5 %
Shore A hardness (CQP023-1 / ISO 48-4)	40
Tensile strength (ASTM D412)	1.6 MPa
Elongation at break (ASTM D412)	600 %
Service temperature (CQP513-1)	-50 – 90 °C
Shelf life	Cartridges / unipacks 9 months ^B Drums / pails 6 months ^B

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r. h

B) storage below 25 °C

DESCRIPTION

Sikaflex®-227 US is a 1-component polyurethane sealant curing on exposure to atmospheric moisture. It adheres well to a wide variety of substrates like metals, metal primers and paint coatings (2-component systems), ceramic materials and plastics.

PRODUCT BENEFITS

- Very good application properties, overhead work possible
- Fast skinning time
- Can be painted, sanded
- Bonds well to a wide variety of substrates
- Resistant to aging
- Low odour

AREAS OF APPLICATION

Sikaflex®-227 US is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound damping measures in trailers, recreational vehicles, metal buildings, and HVAC units. Suitable substrates are metal primers and paint coatings (2-c systems), metals, painted plastics and plastics. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-227 US on materials prone to stress cracking. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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CURE MECHANISM

Sikaflex®-227 US cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

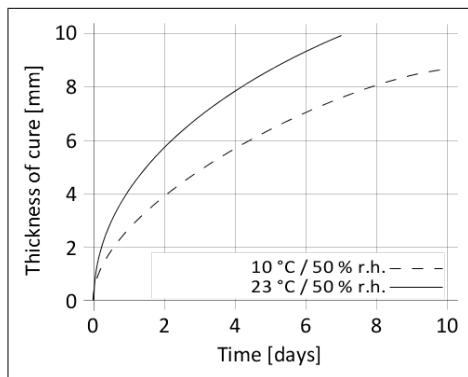


Diagram 1: Curing speed Sikaflex®-227 US

CHEMICAL RESISTANCE

Sikaflex®-227 US is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-227 US can be processed between 5 °C and 35 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and process material is between 15 °C and 25 °C. Sikaflex®-227 US can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment.

For advice on selecting and setting up a suitable pump system, contact Sika Canada.

Tooling and finishing

Tooling and finishing must be carried out within the skin time of the product. It is recommended using Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior the use.

Removal

Uncured Sikaflex®-227 US 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 have to be washed immediately using hand wipes such as Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

Overpainting

Sikaflex®-227 US can be painted after formation of a skin. If the paint requires a baking process, best performance is achieved by allowing the sealant to fully cure first. 1C-PUR and 2C-acrylic based paints are usually suitable. All paints have to be tested by carrying preliminary trials under manufacturing conditions.

Note: The elasticity of paints is usually lower than that of sealants which could lead to cracking of the paint in the joint area.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from Sika Canada.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart For 1-component Polyurethane
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 mL
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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

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.

DISCLAIMER

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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

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