

Sikaflex®-295 UV

Marine UV Resistant Adhesive/Sealant

Technical Product Data (typical values)

Chemical base		1-C polyurethane
Color		Black, White
Cure Mechanism		Moisture-curing
Density (uncured)		10.3 lbs/gal
VOC Content		0.11 lbs / gal (13.1 g/l)
Non-sag properties		Good
Application temperature	product	50°F - 95°F (10°C - 35°C)
Tack free time ¹		60 minutes
Curing speed		(see diagram 1)
Shrinkage		1%
Shore A-hardness (ASTM D 2240)		35
Tensile strength (ASTM D 412)		160 psi
Elongation at break (ASTM D 412)		500%
Tear propagation resistance (ASTM D 624)		29 pli
Service temperature	permanent	-40°F -194°F (-40°C - 90°C)
Shelf life (storage below 77°F (25°C))	Cartridge & Unipac Drum & Pail	12 months 6 months

¹⁾ 73°F (23°C) / 50% r.h.

Description

Sikaflex®-295UV is a one-component polyurethane adhesive/sealant specifically formulated for bonding acrylic and polycarbonate windows and hatches. It is also an excellent color stable, non-chalking sealant for general marine sealing.

Product Benefits

- UV resistant, no cracking or chalking
- Salt water resistant
- Fast tack-free time
- Paintable and sandable
- Stable
- Bonds and seals in one step
- Initial load bearing capacity
- High thixotropy/good gap filling properties
- Non-yellowing
- Non-chalking

Areas of Application

Sikaflex®-295 UV black is intended to be used as an adhesive and/or sealant in bonding applications for polycarbonate windows and acrylic (PMMA) windows. Black: Use in conjunction with Sika®-Cleaner 226 and Sika® Primer 209N. Prior to use, always refer to installation guide available at www.sikaindustry.com/ipd-marine-window-295.

Sikaflex®-295 UV white is intended to be used as a sealant in open joints between glass, ceramics, metals, many plastics, fiberglass and many types of paint. Use in conjunction with Sika®-Cleaner 226 or Sika®-Aktivator. Refer to the Surface Preparation Guidelines for further information. It is not intended to bond mineral glass.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be

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performed to ensure adhesion and material compatibility.

Cure Mechanism

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

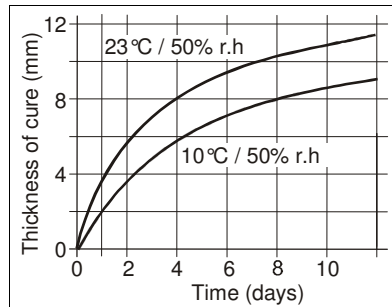


Diagram 1: Curing speed Sikaflex®-295 UV

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, dust, and standing moisture. As a rule the surfaces must be prepared in accordance with the instructions given in the current Sika® Primer Chart for Marine Applications. Keep the work area shielded from direct sunlight and temperature extremes. Advice on specific projects is available from the Technical Service Department of Sika Industry 888-832-7452.

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 pneumatic gun. Once opened, cartridges or 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 be applied as a triangular bead (see illustration). The nozzle cut dimensions and the number of beads applied are dependent upon the required width and thickness of the adhesive bead in the final assembly. 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 at 888-832-7452.

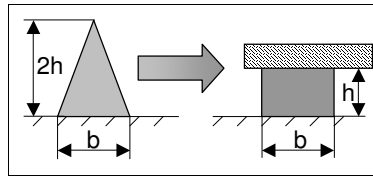


Figure 1: Recommended bead configuration

Tooling and finishing

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

Removal

Uncured Sikaflex®-295 UV 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 a suitable industrial hand cleaner and water. Do not use solvents on hands!

Overpainting

Sikaflex®-295 UV may be overpainted when tack-free. The paint and paint process must be tested for compatibility by carrying out preliminary trials. Sikaflex®-295UV should not be exposed to baking temperatures until it has attained full cure. It should be understood that the hardness and film thickness of the paint might impair the elasticity of the sealant and lead to cracking of the paint film with time.

Limitations

- Do not apply on frozen surface or through standing water or under water.
- Do not apply over silicones or in the presence of curing silicones.
- Avoid contact with alcohol and alcohol containing solvents during cure.
- Allow minimum of 1-week full cure prior to total water immersion situations.
- Maximum chlorine exposure 2.5 ppm.
- Do not use as a deck seam sealant.
- Do not use for bonding glass.

Important Considerations:

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

WARNING:

IRRITANT, SENSITIZER.

Contains Polyisocyanate Prepolymer (Mixture). Causes eye irritation. May cause skin and/or respiratory sensitization after prolonged contact. May be harmful if swallowed. Use only in well ventilated areas. **Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions.**

HMIS

Health	*2
Flammability	1
Reactivity	0
Personal Protection	C

First Aid Measures

Eyes – Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin** – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation** – Remove to fresh air. **Ingestion** – Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further Information

Copies of the following publications are available on our website www.sikaindustry.com:
 -Material Safety Data Sheets
 -Product Data Sheet
 -Sika Primer Chart
 -General guidelines for bonding and sealing with Sika products

Further information available at:
www.sikaindustry.com

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In case of emergency call:
Chemtrec: 800-424-9300
International: 703-527-3887

For further 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. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

-KEEP OUT OF REACH OF CHILDREN
-NOT FOR INTERNAL CONSUMPTION
-FOR INDUSTRIAL USE ONLY
-KEEP CONTAINER TIGHTLY CLOSED

Packaging Information

Cartridge	300 ml
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Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Handling and Storage

Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse. Store below 77°F (25°C) in a cool dry place away from sunlight.

Clean Up

Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and placed in suitable sealed container. Dispose of excess product and container in accordance with applicable environmental regulations.

Limited Material Warranty

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current

Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at www.sikaindustry.com. Nothing contained in any Sika materials relieves

the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at:
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