

Sikaflex[®]-295i UV

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)	depending on colour	1.3 kg/l approx.
Non-sag properties		Good
Application temperature	ambient	10 - 35°C (50 - 95°F)
Tack free time ²⁾ (CQP 019-1)		50 min. approx.
Curing speed (CQP 049-1)		(see diagram)
Shrinkage (CQP 014-1)		1% approx.
Shore A-hardness (CQP 023-1 / ISO 868)		40 approx.
Tensile strength (CQP 036-1 / ISO 37)		2.0 MPa approx.
Elongation at break (CQP 036-1 / ISO 37)		700% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)		8 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)		1.5 MPa approx.
Glass transition temperature (CQP 509-1 / ISO 4663)		-45°C (-50°F) approx.
Service temperature (CQP 513-1)		-40 - 90°C (-40 - 195°F)
Short term	4 hours 1 hour	120°C (250°F) 140°C (280°F)
Shelf life (storage below 25°C) (CQP 016-1)	cartridge	12 months

¹⁾ CQP= Corporate Quality Procedures ²⁾ 23°C / 50% r.h.

Description

Sikaflex[®]-295i UV is a 1-C polyurethane adhesive of paste-like consistency that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex[®]-295i UV meets the requirements set out by the International Maritime Organisation (IMO).

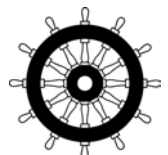
Sikaflex[®]-295i UV is manufactured in accordance with the ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- Suitable for organic glasses
- Wheel mark approved
- Ageing and weathering resistant
- Short cut-off string
- Very low VOC, solvent free

Areas of Application

Sikaflex[®]-295i UV has been specially developed for the marine industry, where it is used to bond and seal organic glasses (PC, PMMA) as well as other commonly used marine substrates. Because of its excellent UV-resistance this product can also be used to seal joints exposed to direct sun light. Special care is required for materials that are prone to environmental stress cracking (ESC) such as thermoplastics, etc. In such cases project related testing is mandatory. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



Cure Mechanism

Sikaflex®-295i UV cures by reaction with atmospheric moisture. At low temperature the water content of the air is generally lower and the curing reaction proceeds slower (see diagram 1).

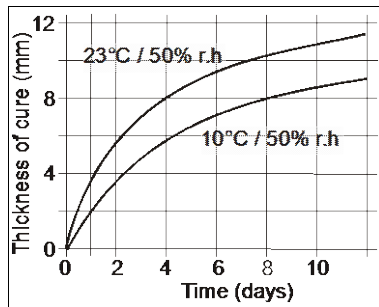


Diagram 1: Curing speed Sikaflex®-295i UV

Chemical Resistance

Sikaflex®-295i UV is resistant to fresh water, seawater, and proprietary aqueous cleaning agents; temporarily resistant to fuels, mineral oils, vegetable and animal fats; not resistant to organic acids, concentrated mineral acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

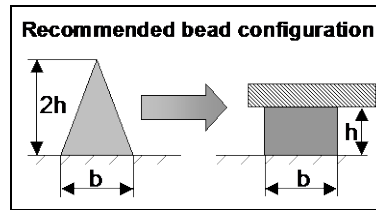
Surfaces must be clean, dry and free from grease, oil and dust. The surfaces must be prepared in accordance with the instructions given in the current edition of the "Sika® Pre-Treatment Chart for Marine Applications".

Advice on specific applications is available from the Technical Department of Sika Industry.

Application

Cut off the tip of the nozzle. Ensuring uniform thickness of adhesive when compressed, we recommend do apply the adhesive in the form of a triangular bead (see illustration).

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. It is recommended to use compressed air piston guns.



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 suitability/ compatibility.

Removal

Uncured Sikaflex®-295i 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 Sika® Handclean towels or a suitable industrial hand cleanser and water. Do not use solvents!

Overpaintability

Sikaflex®-295i UV can be overpainted after formation of a skin. In case the paint requires a bake process it may be necessary to wait for a full cure. 1C-PUR and 2C-acrylic based paints are usually suitable. Not suitable are oil based paints. All paints have to be tested by carrying out preliminary trials under manufacturing conditions. The elasticity of paints is lower than that of polyurethanes. This could lead to cracking of the paint film in the joint area.

Further Information

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-Treatment Chart for Marine Applications
- General Guidelines Bonding and Sealing with Sikaflex®

Packaging Information

Cartridge	300 ml
Unipack	400 ml
	600 ml

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 shall refer to the actual 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.

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