

## PRODUCT DATA SHEET

# Sikaflex®-295 UV

EXTERIOR SEALANT AND DIRECT GLAZING ADHESIVE FOR ORGANIC GLASS IN MARINE APPLICATIONS

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component polyurethane
Colour (CQP001-1)	Black, white
Cure mechanism	Moisture-curing
Density (uncured)	1.3 kg/l
Non-sag properties	Good
Application temperature	10 – 35 °C
Skin time (CQP019-1)	60 minutes <sup>A</sup>
Open time (CQP526-1)	45 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram 1)
Shrinkage (CQP014-1)	1 %
Shore A hardness (CQP023-1 / ISO 7619-1)	35
Tensile strength (CQP036-1 / ISO 527)	2 MPa
Elongation at break (CQP036-1 / ISO 527)	500 %
Tear propagation resistance (CQP045-1 / ISO 34)	5 N/mm
Service temperature (CQP509-1 / CQP513-1)	-50 – 90 °C
Shelf life (CQP016-1)	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C / 50 % r. h.<sup>B</sup>) storage below 25 °C**DESCRIPTION**

Sikaflex®-295 UV is a 1-component polyurethane adhesive of paste-like consistency that cures on exposure to atmospheric moisture. It is suitable for interior and exterior sealing applications and to bond organic glass in the Marine business.

Sikaflex®-295 UV meets the requirements set out by the International Maritime Organization (IMO).

**PRODUCT BENEFITS**

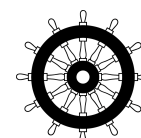
- Excellent application properties
- Resistant to ageing and weathering
- Suitable for organic glasses
- Approved for the OEM market
- Wheelmark approved

**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 weatherability this product can also be used to seal joints in exposed areas.

Suitable substrates are aluminium (bright or anodized), GRP (polyester resin), stainless steel, timber, 2-component coatings and plastic glazing materials (PC, PMMA).

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-295 UV 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 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 generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

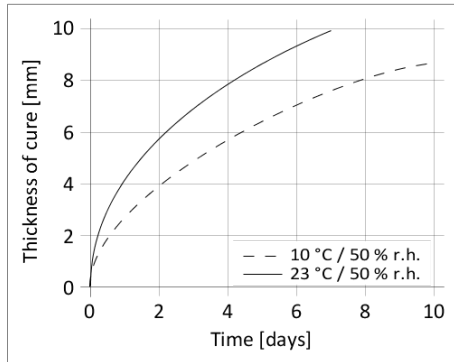


Diagram 1: Curing speed Sikaflex®-295 UV

## CHEMICAL RESISTANCE

Sikaflex®-295 UV 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, dust and contaminants. 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®-295 UV can be processed between 10 °C and 35 °C (climate and product) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and adhesive sealant is between 15 °C and 25 °C.

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

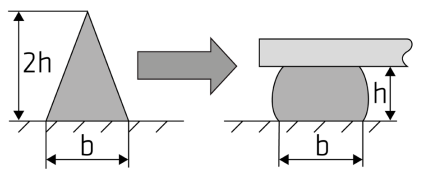


Figure 1: Recommended bead configuration

Sikaflex®-295 UV can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment. The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

## 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®-295 UV can 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 Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water. Do not use solvents on skin.

## Overpainting

Sikaflex®-295 UV can be painted prior and after formation of a skin. If painting process takes place after the sealant has built a skin, the adhesion could be improved by treating the joint surface with Sika® Aktivator-100 or Sika® Aktivator-205 prior to paint process. If the paint requires a baking process (> 80 °C), best performance is achieved by allowing the sealant to fully cure first. All paints have to be tested by carrying preliminary trials under manufacturing conditions.

The elasticity of paints is usually lower than that of sealants. This could lead to cracking of the paint 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 1-component Sikaflex®

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	400 ml
	600 ml

## 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

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.

## 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 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.

## PRODUCT DATA SHEET

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