

Sikaflex®-295 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	
Density (uncured) (CQP 006-4)	1.2 kg/L approx.	
Non-sag properties	Good	
Cure mechanism	Humidity-curing	
Tack free time ²⁾ (CQP 019-1)	60 min. approx.	
Curing speed (CQP 049-1)	See diagram	
Shrinkage (CQP 014-1)	1% approx.	
Shore A hardness (CQP 023-1 / ISO 868)	35 approx.	
Elongation at break (CQP 020-4 / ISO 8339)	> 300% approx	
Tensile strength (CQP 020-3 / ISO 8339)	1.1 N/mm ² approx.	
Tear propagation resistance (CQP 045-1 / ISO 34)	5 N/mm approx.	
Glass transition temperature (CQP 509-1 / ISO 4663)	-45°C approx.	
Movement accommodation factor	12.5%	
Application temperature	10°C to 35°C	
Service temperature (CQP 513-1)	permanent	-40°C to 90°C
Short term	36 hours	120°C
	4 hours	140°C
	1 hour	150°C
Shelf life (storage below 25°C) (CQP 016-1)	cartridge & sausage	12 months 9 months

¹⁾ CQP = Corporate Sika Quality Procedures

²⁾ At 23°C and 50% relative humidity

Description

Sikaflex®-295 UV is a 1-C polyurethane adhesive of paste-like consistency that cures on exposure to atmospheric moisture to form a durable elastomer.

Sikaflex®-295 UV meets the requirements set out by the International Maritime Organisation (IMO). Sikaflex®-295 UV is manufactured in accordance with the ISO 9001/ 14001 quality assurance system.

Product Benefits

- 1-C formulation
- Fast cure time
- Short cut-off string
- Approved for the OEM market
- Resistant to ageing and weathering
- Suitable for organic glasses

Areas of Application

Sikaflex®-295 UV has been specially developed for the marine industry, where it is used to bond and seal organic glazing materials in boats and ships. Because of its excellent UV-resistance this product can also be used to seal joints in areas of severe exposure.

Suitable substrates include:

- Aluminum (bright or anodized)
 - GRP (polyester resin)
 - Stainless steel
 - Timber
 - 2-C coatings
 - Organic glazing materials (PC, PMMA)
- Seek advice from our technical service before using Sikaflex®-295 UV on thermoformed plastics. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



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).

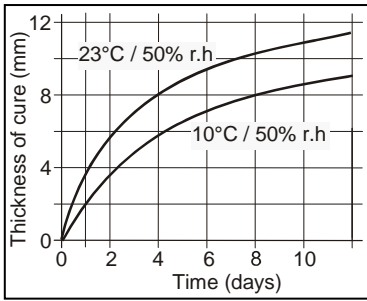


Diagram 1: Curing speed for Sikaflex®-295 UV

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 and dust. As a rule the faces must be prepared in accordance with the instructions given in the current Sika® Primer Chart for Marine Applications.

Advice on specific projects is available from the technical service department of Sika Canada.

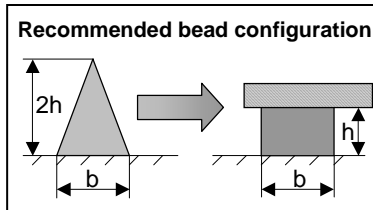
Application

Cartridges: Pierce cartridge membrane.

Sausages: Place sausage 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 compressed-air gun. Once opened, 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 is applied in the form of a triangular bead (see illustration).



Correct joint design is essential when bonding organic 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 Canada.

Tooling and finishing

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. Do not use alcohol or alcohol containing solvent.

Clean up

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 Sika® Hand Cleaner or a suitable industrial hand cleaner and water. Do not use solvents!

Overpainting

Sikaflex®-295 UV can be overpainted when tack-free. The paint must be tested for compatibility by carrying out preliminary trials. It should be understood that the hardness and film thickness of the paint may impair the elasticity of the adhesive and lead to cracking of the paint film.

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Primer Chart
- Sika Marine Application Guide

Packaging Information

Cartridge	300 mL
Sausage	600 mL
Pail	23 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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