

Technical Data Sheet

Sikaflex®-295 UV

UV Resistant Adhesive/Sealant

Properties:

Density	10 lb/gal.
Tack free time*	50 minutes approximately
Rate of cure	1/8" /24 hours
Shore A hardness (ASTM D2240)	35 to 40 at 77°F
Elongation at break (ASTM D412)	>500%
Tensile strength (ASTM D412)	450 psi approximately
Lap shear strength (ASTM D1002)	250 psi approximately
E-modulus at 100% elongation	70 psi
Application temperature**	40°F to 95°F
Service range	-40°F to 195°F
Color	Black, white

* = temperature 73°F/50% R.H.

** = refers to ambient temperature of substrates For optimum application, Sikaflex®-295 UV should be conditioned to 70°-80°F before use.

Where to Use:

- Sikaflex®-295 UV black is intended to be used as an adhesive and/or sealant in bonding applications for:
 - polycarbonate
 - acrylic (PMAA)

Use in conjunction with Sika®-Primer 209. Always seek the manufacturer's advice prior to bonding these plastics that are prone to stress cracking.

- Sikaflex®-295 UV white is intended to be used as a sealant in open joints exposed to sunlight for sealing:
 - glass
 - ceramics
 - metals
 - many plastics
 - fiberglass
 - many types of paint

Use in conjunction with Sika®-Cleaner 226 or Sika®-Aktivator. Refer to the Surface Preparation Guidelines for further information.

Packaging:

- * 10.3-fl-oz cartridges packaged 12 per carton

Advantages Offered by Sikaflex®-295 UV:

- 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

Aging Resistance:

Lab trials of performance and aspect after 2000 hours of exposure to QUV showed that Sikaflex®-295 UV maintains all of its adhesion, elasticity and aspect. This demonstrated its strong resistance to not only solar rays but also hydrolysis.

Chemical Resistance:

Sikaflex®-295 UV has very good long term resistance to fresh water, sea water, aqueous cleaning agents, weak acids and weak bases and to most teak oils. Brief contact with fuels and lubricants has no significant effect. It is

Description:

Sikaflex®-295 UV is a one-component polyurethane adhesive with very high thixotropy that cures on exposure to ambient humidity to form a high-quality elastomer of about 35 on the Shore A scale at 70°F.

Sikaflex®-295 UV has been formulated especially for marine applications where resistance to direct sunlight is required. Sikaflex®-295 UV has also been specifically designed for bonding polycarbonate or acrylic windows or hatches.

recommended to test on a small area first to ensure compatibility. Sikaflex®-295 UV has very reduced resistance to solvents, concentrated acids and bases and caustic solutions.

Physical Performance of Aging:

Lab trials of accelerated aging (heat, cold, humidity, salt spray) according to GM 9505P, cycle F, 3 cycle duration on PMMA and polycarbonate substrates prepared with Scotchbrite, cleaning and Sika®-Primer 209 yielded cohesive breaks and values (lapshear) greater than 290 psi.

Storage:

Sikaflex®-295 UV should not be stored at temperatures in excess of 77°F. Properly stored in cool, dry conditions, the unopened cartridges have a shelf life of 9 months.

Coverage:

- * 10.3-fl-oz cartridge yields 24 lineal feet of 1/4-in x 1/4-in bead

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HOW TO USE:

Surface preparation for acrylic (PMAA) or Polycarbonate:

- Scuff the bond area with sand paper or a Scotchbrite pad.
- Degrease the bond area with Sika®-Cleaner 226 (drying time 10 minutes)
- Apply Sika®-Primer 209 in one continuous, homogeneous coat with a brush or dauber (drying time 20 minutes at 75°F).

If there is an abrasion/scratch resistant coating, it must be completely removed with sandpaper (80x - 120x) prior to surface preparation (i.e. Margard coating on Lexan). Organic windows with special tinting or coating should be pretested for adhesion. Refer to the Surface Preparation Guidelines or Sika's Technical Service Department for further information.

Adhesive Application:

Sikaflex-295 UV should be applied in a triangular bead through an appropriately cut nozzle. 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.

Width: The adhesive width is dependant upon the constraints of the assembly (available glazing area and degree of compression). The joint width must be a minimum of 3/8"

Substrate and Working Conditions:

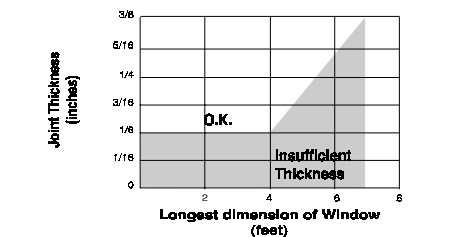
- During these operations, the bonding surfaces must be free of dirt, debris and standing moisture.
- Keep the work area shielded from direct sunlight and temperature extremes; apply system

at a maximum ambient temperature of 95°F.

- Joint thickness can be maintained using self-adhesive rubber spacers of Shore A 30 hardness.
- Once the window is installed, it must be braced for at least 12 hours.
- During assembly/bracing, take care not to twist or bend the window excessively.

Thickness: For bonding on metal or composite framing, the adhesive thickness is dependant upon the longest dimension of the window.

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.

CAUTION:

Irritant; Sensitizer:

Contains polyisocyanate prepolymer, xylene. May cause skin/eye/respiratory

irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. Xylene may cause headaches, dizziness or other CNS effects; and may cause liver or kidney effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH/MSHA approved respirator. Remove contaminated clothing.

First Aid:

In case of skin contact, wash immediately and thoroughly with soap and water. If symptoms persist, consult physician. For eye contact, flush immediately with plenty of water for at least 15 minutes, contact a physician. For respiratory problems, remove person to fresh air; if symptoms persist, contact a physician. In case of ingestion, dilute with water and consult physician. Remove contaminated clothing.

Clean Up:

Uncured sealant may be removed with solvent. Cured sealant is only removed mechanically. In case of spills or leaks, wear suitable protective equipment, contain spill, collect with absorbent material and transfer to suitable container. Ventilate area. Avoid contact. Dispose of in accordance with current, applicable local, state, and federal regulations.

IN CASE OF EMERGENCY CALL CHEMTREC, 1-800-424-9300

Consult Material Safety Data Sheets and Surface Preparation Guidelines available through SikaFax: 877-663-9727

Visit our website at <http://www.sikasolutions.com>

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KEEP OUT OF REACH OF CHILDREN

NOT FOR INTERNAL CONSUMPTION

CONSULT MATERIAL SAFETY DATA SHEET FOR MORE INFORMATION

KEEP CONTAINER TIGHTLY CLOSED

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