

Sikaflex[®]-228

Fluid adhesive

Technical Product Data

Chemical base	1-C polyurethane
Colour (CQP ¹ 001-1)	Greyish white
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.45 kg/l approx.
Application temperature (ambient)	5 - 35°C (40 - 95°F)
Tack-free time ² (CQP 019-1)	60 min. approx.
Curing speed (CQP 049-1)	see diagram 1
Shrinkage (CQP 014-1)	10% approx.
Shore A hardness (CQP 023-1 / ISO 868)	35 approx.
Tensile strength (CQP 036-1 / ISO 37)	1 N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	400% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	4 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	1 N/mm ² approx.
Service temperature (CQP 513-1)	-50 - 80°C (-60 - 175°F)
Shelf life (storage below 25°C) (CQP 016-1)	cartridge / unipack drum / pail
	12 months 9 months

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C (73°F) / 50% r.h.

Description

Sikaflex[®]-228 is a self levelling one-component polyurethane adhesive that cures on exposure to atmospheric moisture to form a durable elastomer.

Sikaflex[®]-228 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- One-component formulation
- Self levelling / low viscosity
- Can be over painted
- Elastic
- Low odour
- Does not contain highly inflammable solvents

Areas of Application

Sikaflex[®]-228 is an elastic panel adhesive suitable for bonding a variety of panel materials, including solvent-resistant foams (PUR), stainless steel sheets, aluminium sheets, timber-based building boards and plasterboards. It can also be used to seal seams and lap joints and to fill construction joints in floors. For exterior sealing applications, thin layers of Sikaflex[®]-228 must be shielded from sunlight (e.g. by over painting, the use of cover strips, etc.).

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.



Cure Mechanism

Sikaflex®-228 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).

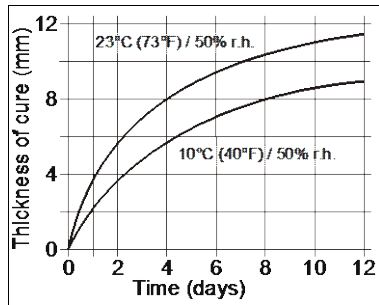


Diagram 1: Curing speed Sikaflex®-228

Chemical Resistance

Sikaflex®-228 is resistant to fresh water, seawater, limewater, sewage effluent, diluted acids and caustic solutions; temporarily resistant to fuels, animal fats and oils; not resistant to organic 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 oil and dust. As a rule, the substrates must be prepared in accordance with the instructions given in the current Sika Pre-treatment Chart.

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

Application

Cut off the tip of the nozzle to suit joint width and apply the sealant into the joint with a suitable hand operated or compressed-air gun, taking care to avoid air entrapment.

Do not apply at temperatures below 5°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C.

The adhesive is to be applied over large surface areas with a notched spreader (notch depth approx. 3 mm). Coverage varies between 600 - 1200 ml/m². When bonding materials impervious to moisture or when an accelerated rate of cure is required, a water aerosol shortly before joining the components has to be applied. Use a spray-bottle or spray gun to apply approx. 10 g water per m². Avoid air entrapment when making the bond or filling joints. Apply firm pressure when joining components together and keep the joint under pressure for at least 3 hours until the adhesive has set.

For advice on selecting and setting up a suitable pump system please contact the System Engineering Department of Sika Industry.

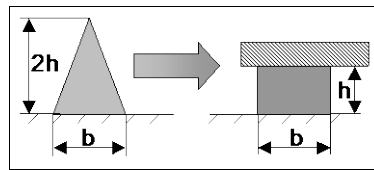


Figure 1: Recommended bead configuration

Removal

Uncured Sikaflex®-228 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 Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Pre-treatment Chart
- General Guidelines - Bonding and Sealing with Sikaflex®

Packaging Information

Cartridge	300 ml
Unipack	600 ml
Pail	23 l
Drum	195 l

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 Material 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, or 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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