

## PRODUCT DATA SHEET

# Sikaflex®-211 US

Multi-purpose general sealant

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

Chemical base		1-component polyurethane
Color (CQP001-1)		White, Gray
Cure mechanism		Moisture-curing
Density (uncured)	depending on color	1.5 kg/l (12.5 lb/gal)
Non-sag properties		Good
Application temperature	ambient	5 – 40 °C (41 – 104 °F)
Skin time (CQP019-1)		40 minutes <sup>A</sup>
Curing speed (CQP049-1)		(see diagram 1)
Shore A hardness (CQP023-1 / ISO 7619-1)		30
Tensile strength (ASTM D412)		0.8 MPa (120 psi)
Elongation at break (ASTM D412)		500 %
Service temperature (CQP513-1)		-40 – 90 °C (-40 – 194 °F)
Shelf life (CQP016-1)		9 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C (73 °F) / 50 % r.h.<sup>B</sup>) storage below 25 °C (77 °F)**DESCRIPTION**

Sikaflex®-211 US is a multi-purpose 1-component polyurethane sealant that cures on exposure to atmospheric moisture. It bonds well to a wide variety of substrates and is suitable for making permanent elastic seals.

**PRODUCT BENEFITS**

- Bonds to a wide variety of substrates often without surface treatments/primers
- Very good gunnability and tooling characteristics
- Can be sanded and painted
- Good aging resistance
- Short cut-off string
- Non-corrosive

**AREAS OF APPLICATION**

Sikaflex®-211 US is a multi-purpose sealant suitable for industrial sealing applications on most common substrates such as metals, metal primers and paint coatings (2-component systems), and fiber reinforced plastics. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-211 US 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 ensuring adhesion and material compatibility.

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Version 01.01 (08 - 2021), en\_US

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## CURE MECHANISM

Sikaflex®-211 US 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).

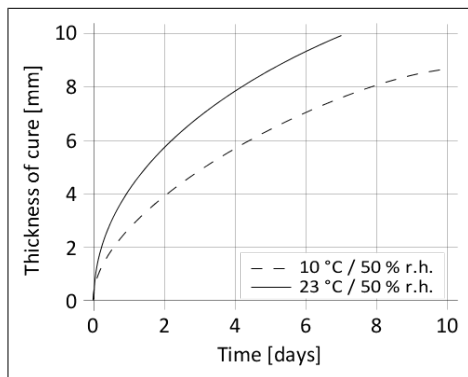


Diagram 1: Curing speed of Sikaflex®-211 US

## CHEMICAL RESISTANCE

Sikaflex®-211 US 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 and dust.

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®-211 US can be processed between 5 °C and 40 °C (41 °F and 104 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C (59 °F and 77 °F). Sikaflex®-211 US can be processed with manual, pneumatic or electric driven piston guns.

## Tooling and finishing

Tooling and finishing must be carried out within the skin time of the product. It is recommended using Sika® Slick. Other finishing agents must be tested for suitability and compatibility prior the use.

## Removal

Uncured Sikaflex®-211 US 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 have to be washed immediately using a suitable industrial hand cleaner and water.

Do not use solvents on skin.

## Overpainting

Sikaflex®-211 US can be painted after formation of a skin. If the paint requires a baking process, best performance is achieved by allowing the sealant to fully cure first.

1C-PUR and 2C-acrylic based paints are usually suitable. All paints have to be tested by carrying preliminary trials under manufacturing conditions.

The elasticity of paints is usually lower than of sealants what could lead to cracking of the paint film in the joint area.

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart  
For 1-component Polyurethane
- General Guideline  
Bonding and Sealing with 1-component Sikaflex®

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	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.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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