

PRODUCT DATA SHEET

SikaBiresin® CF230 (Formerly CF 230)

Flame Retardant, Epoxy Edge Filling Paste

TYPICAL PHYSICAL PROPERTIES (FOR FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaBiresin® CF230 (A) Resin	SikaBiresin® CF234 (B) Hardener
Composition	Epoxy	Amine
Mix ratio – by weight	100	24
Aspect	Paste	Paste
Color	White, Black	Green
Color (mixed)	Light green, charcoal	
Specific gravity at 77°F (25°C)	0.63 g/cm ³	0.43 g/cm ³
Specific gravity at 77°F (25°C) Cured mix		0.58 g/cm ³
Pot life (116g) at 77°F (25°C)	11 Minutes	

DESCRIPTION

SikaBiresin® CF230 is a 2-component, epoxy-based, edge filling paste designed for edging aluminum and other forms of honeycomb sandwich structures, cell densification for insert anchoring, and repairs on honeycomb sandwich structures/panels.

PRODUCT BENEFITS

- Meets FAR 25.853(a) flame testing for aircraft interiors and other areas where flame retardant performance is required
- Easy to use
- Self-extinguishing
- Lightweight (low density)
- Smooth paste composition
- Minimal shrinkage
- Easy to machine by hand

AREAS OF APPLICATION

Typical applications include edging, cell densification, insert anchoring, and repairs on honeycomb sandwich structures/panels.

Tests with actual materials and conditions have to be performed to ensure satisfactory performance.

TYPICAL MECHANICAL AND THERMAL PROPERTIES^A

Properties, Test Method	SikaBiresin® CF230 (A) Resin	SikaBiresin® CF234 (B) Hardener
Hardness, Shore D, ASTM D2240	65	
Compressive strength, ASTM D695	4,317 psi (30 MPa)	
Glass Transition Temperature (T _g per TMA), ASTM E1545 <ul style="list-style-type: none"> Cured 24 hours at room temperature: 77°F (25°C) Cured 16 hours at 104°F (40°C) Cured 1 hour at 248°F (120°C) Cured 2 hours at 248°F (120°C) Cured 24 hours at 248°F (120°C) 	125°F (51.7°C) 131°F (55.0°C) 169°F (76.0°C) 173.3°F (78.5°C) 181.9°F (83.3°C)	
Coefficient of thermal expansion (CTE) - TMA	72 ppm/°F (130 ppm/°C)	
Hardening time (10 mm thickness), Cured at 77°F (25°C)	20 hours	

^AAverage values obtained on standard specimens. Hardening 16 hours at 104°F (40°C) (unless noted otherwise)

PROCESSING

Mix resin and hardener mixture to required mix ratio to obtain a homogenous paste. Apply, with pressure, on the edge of the cell of the honeycomb structure.

Normal health and safety precautions should be observed when handling these products:

- Ensure adequate ventilation
 - Wear gloves, glasses, and protective clothes
- For further information, please consult the Safety Data Sheets

STORAGE CONDITIONS

Shelf life of resin and hardener is 12 months when stored in original, unopened containers between 65-77°F (15 - 25°C). Keep containers tightly closed.

PACKAGING INFORMATION

Packaging information is available upon request. Please contact your local Sika sales representative.

FURTHER INFORMATION

Advice on specific applications will be given on request. To contact Sika Corporation's Industry Technical Services Department, send an email to tsmh@us.sika.com. Copies of Safety Data

Sheets and Product Data Sheets are available upon request.

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 or by contacting

SIKA's Technical Service Department via email at 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. SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.