

PRODUCT DATA SHEET

Sikaflex[®]-552

Assembly adhesive with reduced substrate preparation

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Silane Terminated Polymer
Color (CQP001-1)		White, black
Cure mechanism		Moisture-curing
Density (uncured)	depending on color	1.46 kg/l (12.2 lb/gal)
Non-sag properties		Good
Application temperature	ambient	5 – 40 °C (41 – 104 °F)
Skin time (CQP019-1)		40 minutes ^A
Open time (CQP526-1)		30 minutes ^A
Curing speed (CQP049-1)		See diagram 1
Shrinkage (CQP014-1)		2 %
Shore A hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (CQP036-1 / ISO 527)		3 MPa (430 psi)
Elongation at break (CQP036-1 / ISO 527)		300 %
Tear propagation resistance (CQP045-1 / ISO 34)		10 N/mm (55 pli)
Tensile lap-shear strength (CQP046-1 / ISO 4587)		2 MPa (290 psi)
Service temperature (CQP509-1 / CQP513-1)		-50 - 90 °C (-58 – 194 °F)
	4 hours	140 °C (284 °F)
	1 hour	150 °C (302 °F)
Shelf life	cartridge / unipack drum	12 months ^B
		9 months ^B

CQP = Corporate Quality Procedure

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

Sikaflex[®]-552 is a high-performance elastic gap-filling 1-component Silane Terminated Polymer (STP). It is suitable for bonding various materials and in many cases adheres with limited surface preparation.

PRODUCT BENEFITS

- Bonds well to a wide variety of substrates with minimal pre-treatment
- Capable of withstanding dynamic stresses
- Isocyanate- and solvent-free
- Can be painted
- Good aging and weathering resistance
- Non-corrosive
- Silicone- and PVC-free

AREAS OF APPLICATION

Sikaflex[®]-552 is suitable for joints that will be subjected to dynamic stresses. Suitable substrate materials are metals, particularly aluminium (including anodized components), sheet steel (including phosphated, chromated and zinc-plated components), ceramic materials and plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex[®]-552 on materials prone to stress cracking.

Sikaflex[®]-552 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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CURE MECHANISM

Sikaflex®-552 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).

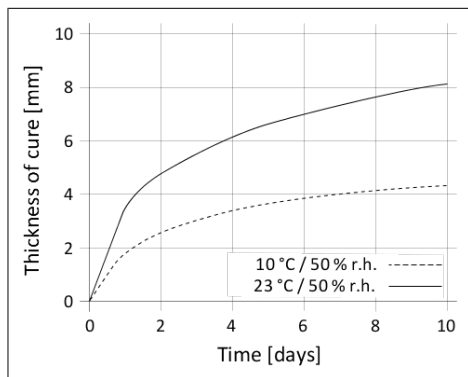


Diagram 1: Curing speed for Sikaflex®-552

CHEMICAL RESISTANCE

Sikaflex®-552 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, dust and contaminants.

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 Sika® Pre-treatment Chart for silan terminated polymer.

Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-552 can be processed at temperatures (climate and product) 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). Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use.

To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1)

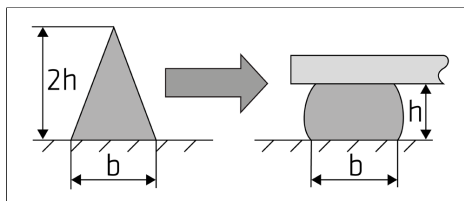


Figure 1: Recommended bead configuration

Sikaflex®-552 can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment.

The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

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

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®-552 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®-552 can be best painted within the skin formation time. If painting process takes place after the sealant has built a skin, adhesion could be improved by treating the joint surface with Sika® Aktivator-100 or Sika® Aktivator-205 prior to paint process.

If the paint requires a baking process (> 80 °C / 176 °F), best performance is achieved by allowing the sealant to fully cure first.

All paints have to be tested by carrying preliminary trials under manufacturing conditions.

The elasticity of paints is usually lower than that of sealants. This could lead to cracking of the paint 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 Sheet
- Sika Pre-treatment Chart
For Silane Terminated Polymers (STP)
- General Guideline
Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Drum	195 l

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.

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