

PRODUCT DATA SHEET

Sikaflex® WS-272 FK + SikaBooster® B-1M

(formerly WS-272FK + B-1M)

Accelerated curing direct glazing adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing ^A
Density (uncured)	Adhesive 1.27 kg/l SikaBooster® B-1M 1.29 kg/l
Solid content (JASO M338-89)	Adhesive 99 % SikaBooster® B-1M 98.5 %
Booster content	by weight 10.0 %
Viscosity (JASO M338-89)	Adhesive 75 Pa·s SikaBooster® B-1M 17 Pa·s
Application temperature	Adhesive 20 – 35 °C SikaBooster® B-1M 20 – 35 °C ambient 10 – 40 °C
Tack-free time (JASO M338-89)	15 minutes ^B
Shore A hardness (JASO M338-89)	57
Tensile strength (JASO M338-89)	5.9 MPa
Elongation at break (JASO M338-89)	400 %
Tensile lap-shear strength (JASO M338-89)	6.2 MPa
Shelf life	Adhesive 6 months ^C SikaBooster® B-1M 6 months ^C
Mixer	MIXPAC™ ME 13-24T

CQP = Corporate Quality Procedure

^A) moisture provided by SikaBooster® B-1M^B) 20 °C / 65 ° r.h.^C) stored below 25 °C in unopened container

DESCRIPTION

Sikaflex® WS-272 FK + SikaBooster® B-1M is an accelerated adhesive system for glazing applications. With the use of SikaBooster® B-1M, it cures largely independent of atmospheric moisture. Suited for bonding materials relevant for direct glazing such as paints, glass, ceramic frits and e-coated systems in commercial vehicle production.

PRODUCT BENEFITS

- Accelerated curing and adhesion build-up
- Very good working characteristics
- Suitable for automated application

AREAS OF APPLICATION

Sikaflex® WS-272 FK + SikaBooster® B-1M is suitable for automated direct glazing as well as elastic bonding in the automotive industry. Sikaflex® WS-272 FK + SikaBooster® B-1M bonds well to numerous substrates. Common substrates are pre-treated ceramic frits and glasses with corresponding UV protection as well as cleaned e-coated and painted surfaces and plastic panels.

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 (09 - 2026), en_US

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CURE MECHANISM

Sikaflex® WS-272 FK + SikaBooster® B-1M cures by reaction with moisture provided by SikaBooster® B-1M and largely independent from atmospheric moisture. For typical strength build up data see table below.

Time [h]	Tensile lap-shear strength at 20 °C [MPa]
0.5	1.4
1	3.5
2	4.6
4	5.2

Table 1: Strength build-up of Sikaflex® WS-272 FK + SikaBooster® B-1M

CHEMICAL RESISTANCE

Sikaflex® WS-272 FK + SikaBooster® B-1M 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.

All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application

Sikaflex® WS-272 FK + SikaBooster® B-1M can be processed between 10 °C and 40 °C (ambient) but changes in reactivity and application properties have to be considered.

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 recommended to apply the adhesive in form of a triangular bead (see figure 1).

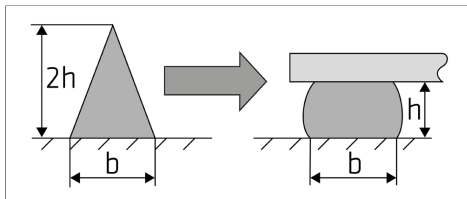


Figure 1: Recommended bead configuration

Sikaflex® WS-272 FK + SikaBooster® B-1M can be processed with pump equipment.

The open time is significantly shorter in hot and humid climate. The glass 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.

For transparent substrates, bond faces must be fully UV protected by suitable design or means.

Removal

Uncured Sikaflex® WS-272 FK + SikaBooster® B-1M 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 hand wipes or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

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

PACKAGING INFORMATION

Sikaflex® WS-272 FK

Pail	4 gal (US)
Drum	54 gal (US)

SikaBooster® B-1M

Pail	20 kg
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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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