



SIKA PRODUCT & APPLICATION TECHNOLOGIES

NEW SOLUTIONS FOR THE TRANSPORTATION, MARINE, APPLIANCE AND COMPONENT INDUSTRIES

BUILDING TRUST



Driving Technology Into the Next Generation

Focusing on the Customer

Sika's contact with the customer does not end with the sale of a product. In fact, it starts well before the first product is ever sold. Sika works closely with our customers throughout the development phase to generate added value solutions on a long-term basis and to stay one step ahead of the competition at all times. To Sika, this means not only developing best-in-class technology to match our customer's technical and commercial requirements, but also to ensure appropriate performance throughout the design, prototyping, validation and full production phases. Underlying this mission statement is the belief that long-term success comes not just from high-quality products, but from the development of totally integrated solutions.

Innovative Solutions for Every Challenge

Sika's long history of innovation has led to unparalleled success in becoming a recognized global technology leader. While investing in established and new technology centers around the world, the company also nurtures and develops an international network of scientists, partners, suppliers and customers.

As a valued partner and supplier to OEM manufacturers in transportation, renewable energy, home and commercial appliance, industrial equipment, HVAC, metal and modular buildings, electronic signage and sandwich panel market segments, we provide the broadest range of state-of-the-art technology solutions to assist manufacturers in lowering operation and repair costs, improved reliability and long term durability.



Driving Technologies

Sika is a trusted supplier and strategic partner to leading industry manufacturers across the globe, spanning diverse markets and providing the broadest range of state-of-the-art technology solutions for the most demanding applications. As a specialty chemical company, we concentrate on our core competencies of bonding, sealing, damping and reinforcing. Sika products are used in a wide array of applications and always fulfill the highest quality standards. We are committed to customer satisfaction, innovation and teamwork.



Full Range of Solutions

Our global expertise allows us to specify the right product for our customer's specific needs, whether it is to reduce production time or to ensure a lifetime bond.

- ▣ **Adhesives & Sealants** – one or two component and accelerated sealants and adhesives for a variety of markets and applications.
- ▣ **Hot Melt Lamination** – reactive and non-reactive hot melts for fast and effective production bonding of hard laminates.
- ▣ **Butyl / Noise Vibration** – sealing and acoustic systems developed and optimized to reduce structural and airborne noise propagation.
- ▣ **Structural Adhesives** – designed to bond dissimilar substrates to replace mechanical fixings such as rivets, screws or welding.
- ▣ **Surface Preparation** – pre-treatment solutions designed to improve immediate, as well as long-term adhesion, on a wide range of substrates.



HIGH PERFORMANCE SOLUTIONS FOR THE MOST DEMANDING APPLICATIONS

Sika's range of sealing, bonding, damping and reinforcing solutions are marketed under the brand names of Sikaflex® polyurethane and modified silane-terminated polyurethane adhesive and sealing systems, SikaTack® polyurethanes, Sikasil® engineered silicones, SikaFast®, SikaForce® and SikaPower® structural adhesives, SikaLastomer® elastomeric tapes and non-curing sealants, SikaDamp® sound absorbing materials and Sikagard® underbody protection.



SIKA® PRODUCT TECHNICAL DATA

The current product data sheet supersedes all technical data presented.
Please visit sikaindustry.com for latest product data sheets.

Products	Base Technology	Skin Time	Open Time	Hardness		Tensile Strength	Lap Shear Strength	Elongation at Break	Color	Packaging	Shelf Life (months)
				Shore A	Shore D						
SikaFiresil® N	1-C silicone	25 minutes	-	25	-	85 psi	-	300%	Light gray	Cartridges, unipacks, drums	12
Sikaflex® Textured Sealant	1-C polyurethane	< 6 hours	-	35 +/- 5	-	-	-	-	White, aluminum gray, limestone, dark bronze, buff, stone	Cartridges	12
Sikaflex® TS Plus	1-C polyurethane	5 hours	-	40	-	110 psi (0.75 MPa)	-	750%	White, concrete gray, black	Unipacks	12
Sikaflex®-201 US	1-C polyurethane	4 hours	-	45	-	175 psi	130 psi	550%	White, tan, aluminum gray, MB bronze, deep bronze, black, limestone	Cartridges, unipacks, pails, drums	Cartridges / unipacks - 12; Pails / drums - 6
Sikaflex®-211 SW	1-C polyurethane	35 minute	-	30	-	190 psi	-	650%	Gray	Drums	6
Sikaflex®-211 US	1-C polyurethane	40 minutes	-	30	-	120 psi	-	500%	White, gray, black	Cartridges, unipacks	9
Sikaflex®-219 LM	1-C polyurethane	2 hours	-	25	-	130 psi	-	700%	White, aluminum gray, log home tan, deep bronze, limestone, black	Cartridges, unipacks	12
Sikaflex®-221	1-C polyurethane	60 minutes	-	40	-	260 psi	-	500%	White, gray, black	Drums, pails, cartridges, unipacks	Cartridges / unipacks - 12; Pails / drums - 6
Sikaflex®-227 US	1-C polyurethane	40 minutes	-	40	-	230 psi	-	600%	White, aluminum gray, black, hitachi gray, dessert tan	Drums, pails, cartridges, unipacks	Cartridges / unipacks - 9; Pails / drums - 6
Sikaflex®-232 US	1-C polyurethane	35 minutes	-	40	-	220 psi	-	500%	White	Cartridges, unipacks, drums	Cartridges / unipacks - 9; Drums - 6
Sikaflex®-252	1-C polyurethane	40 minutes	-	50	-	435 psi	360 psi	400%	White, black	Drums, cartridges, unipacks	Cartridges / unipacks - 9; Drums - 6
Sikaflex®-255 FC	1-C polyurethane	40 minutes	-	60	-	870 psi	580 psi	450%	Black	Drums, cartridges, unipacks	Cartridges / unipacks - 9; Drums - 6
Sikaflex®-268	1-C polyurethane	60 minutes	-	55	-	870 psi	650 psi	500%	Black	Drums, unipacks	Unipacks - 12; Drums - 6
Sikaflex®-268 PowerCure	Accelerated polyurethane	-	30 minutes	55	-	870 psi	650 psi	500%	Black	Unipacks with PowerCure pack	9
Sikaflex®-271 with Booster	Accelerated polyurethane	-	5 minutes	65	-	1000 psi	725 psi	350%	Black	Drums	6
Sikaflex®-271 PowerCure	Accelerated polyurethane	-	10 minutes	65	-	1000 psi	725 psi	300%	Black	Unipacks with PowerCure pack	9
Sikaflex®-291	1-C polyurethane	60 minutes	-	40	-	260 psi	-	500%	White, black	Cartridges, unipacks, squeeze tubes	12
Sikaflex®-291 LOT	1-C polyurethane	4 hours	-	45	-	190 psi	-	700%	White, black, mahogany	Cartridges, unipacks, squeeze tubes	12
Sikaflex®-292i	1-C polyurethane	40 minutes	-	50	-	430 psi	290 psi	600%	White	Cartridges	12
Sikaflex®-295 UV	1-C polyurethane	60 minutes	-	35	-	290 psi	-	500%	Black, white	Cartridges, squeeze tubes	12
Sikaflex®-296	1-C polyurethane	45 minutes	-	45	-	870 psi	650 psi	450%	Black	Unipacks	9
Sikaflex®-501	1-C silane terminated polymer	20 minutes	-	40	-	140 psi	-	200%	White, black, gray	Unipacks	12
Sikaflex®-505 UV	1-C silane terminated polymer	< 1 hour	-	45	-	275 psi	275 psi	275%	White, aluminum gray	Drums, cartridges, unipacks	12
Sikaflex®-505 UV Hi Visc	1-C silane terminated polymer	8 minutes	-	50	-	225 psi	275 psi	275%	White	Cartridges, unipacks	9

SEALANT / ADHESIVE

SIKA® PRODUCT TECHNICAL DATA

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Products		Base Technology	Skin Time	Open Time	Hardness		Tensile Strength	Lap Shear Strength	Elongation at Break	Color	Packaging	Shelf Life (months)
					Shore A	Shore D						
Sikaflex®-510 AM	SEALANT / ADHESIVE	1-C silane terminated polymer	60 minutes	-	20	-	130 psi	-	700%	White, black, limestone, off-white, salt box, tan, stone, aluminum gray, redwood tan, medium bronze, marshfield	Cartridges, unipacks	12
Sikaflex®-521 UV		1-C silane terminated polymer	30 minutes	-	40	-	260 psi	-	400%	Black, white, gray	Cartridges, unipacks	12
Sikaflex®-552		1-C silane terminated polymer	40 minutes	-	50	-	435 psi	300 psi	300%	White, black	Drums, cartridges, unipacks	Cartridges / unipacks - 12; Drums - 9
Sikaflex®-715		1-C silane terminated polymer	30 minutes	-	10	-	85 psi	-	500%	White, black	Cartridges, drums	Cartridges - 9; Drums - 6
Sikaflex®-953 L30		2-C silane terminated polymer	40 minutes	-	50	-	360 psi	220 psi	450%	White	Cartridges	9
SikaSeal®-710 LS US		1-C mastic	-	-	-	-	-	-	-	Gray	Drums	6
Sikasil® AS-785 (AB)		2-C silicone	40 minutes	-	45	-	290 psi	-	250%	Black gray - mixed, white	Cartridges, hobbocks, drums	9
Sikasil® GP		1-C silicone	13 minutes	-	20	-	220 psi	-	500%	White, black, aluminum, metallic aluminum, bronze, almond, hi-temp red, translucent	Cartridges	24
Sikasil® GP-101		1-C silicone	20 minutes	-	15	-	150 psi	-	400%	White, black, aluminum, almond, transwhite, translucent, bone	Cartridges, unipacks	24
Sikasil®-N Plus		1-C silicone	15-20 minutes	-	15 - 30	-	190 - 300 psi	-	430%	White, black, aluminum, bronze, clear, colonial white, limestone, transwhite	Cartridges, unipacks, squeeze tubes	12
Sikasil® SG-10		1-C silicone	12 - 18 minutes	-	12 - 35	-	190 - 300 psi	-	400 - 600%	White, black, cameo white, aluminum gray, clear	Cartridges, unipacks	12
Sikasil® SG-15		1-C silicone	15 minutes	-	18	-	210 psi	-	650%	Black, gray	Cartridges, pails, drums	12
Sikasil® SG-20		1-C silicone	25 minutes	-	39	-	320 psi	-	450%	Black	Unipacks	9
Sikasil® WS-290		1-C silicone	50 minutes	-	12	-	165 psi	-	1000%	White, black, aluminum	Cartridges, unipacks	12
Sikasil® WS-295		1-C silicone	50 minutes	-	25	-	200 psi	-	700%	White, black, aluminum, custom	Cartridges, unipacks	12
Sikasil® WS-305 AM		1-C silicone	130 minutes	-	20	-	145 psi	-	750%	White, black, gray, bronze, medium bronze, colonial white, aluminum, anodized light gray, dark gray	Cartridges, unipacks	12
SikaTack® Ultrafast US		1-C polyurethane	15 minutes	-	65	-	1000 psi	580 psi	450%	Black	Drums, cartridges	Cartridges - 9; Drums - 6
SikaFast®-306		STRUCTURAL ADHESIVE	10:1 toughened MMA	-	3 minutes	-	65	1450 psi	2150 psi	-	Black	Cartridges
SikaFast®-308	10:1 toughened MMA		-	4 minutes	-	65	1450 psi	2150 psi	-	Off-white	Cartridges	9
SikaFast®-3215	10:1 toughened MMA		-	6 minutes	-	65	1300 psi	1500 psi	80%	Straw	Cartridges	9
SikaFast®-3121	10:1 toughened MMA		-	5 minutes	-	65	1300 psi	1500 psi	80%	Dark gray, straw	Drums, cartridges	9
SikaFast®-31315	10:1 toughened MMA		-	7 minutes	-	65	1300 psi	1500 psi	50%	Straw	Cartridges, drums, pails	9
SikaFast®-3311	10:1 toughened MMA		-	7 minutes	-	65	1450 psi	2150 psi	-	Light blue/gray	Cartridges	9
SikaFast®-3341	10:1 toughened MMA		-	25 minutes	-	65	1450 psi	2150 psi	-	Blue	Cartridges	9

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				Shore A	Shore D						
SikaFast®-3511	1:1 toughened MMA	-	4 minutes	-	75	3050 psi	3000 psi	-	Light yellow	Cartridges	9
SikaFast®-3531	1:1 toughened MMA	-	20 minutes	-	80	3050 psi	3000 psi	-	Light yellow	Cartridges	9
SikaFast®-3551	1:1 toughened MMA	-	45 minutes	-	70	3350 psi	3300 psi	-	Light brown	Cartridges	9
SikaForce®-311 L45	2-C polyurethane	-	20 minutes	-	45	-	-	-	Dark gray	Drums, pails, cans	12
SikaForce®-315	2-C polyurethane	-	50 seconds	-	70	2850 psi	-	170%	Black	Cartridges	12
SikaForce®-321 L30	2-C polyurethane	30 minute pot life	-	-	80	-	-	-	Beige	Drums	12
SikaForce®-710 L35	2-C polyurethane	35 minute pot life	80 minutes	-	80	11 MPa / 1600 psi	9 MPa / 1300 psi	9%	Beige mixed	Drums, pails	6 - 12
SikaForce®-7570 L03	2-C polyurethane	30 minute pot life	-	60	-	2 MPa / 290 psi	4 MPa / 580 psi	150%	Black	Drums, hobbocks	6
SikaForce®-7780 L05	2-C polyurethane	5 minute pot life	-	80	-	2.2 MPa / 320 psi	-	35%	Gray	Cartridges	12
SikaForce®-7780 L12	2-C polyurethane	12 minute pot life	-	80	-	2.2 MPa / 320 psi	-	35%	Gray	Pails	12
SikaForce®-7800 Blue	2-C polyurethane	-	2 minutes	-	-	-	-	2.50%	Light blue	Cartridges	15
SikaForce®-7800 Red	2-C polyurethane	-	2.5 minutes	-	-	-	-	2.50%	Light red	Cartridges	15
SikaForce®-7810 L80	2-C polyurethane	30 minute pot life	40 minutes	-	75	30 MPa / 4400 psi	20 MPa / 2900 psi	3%	Beige	Drums, pails	12
SikaForce®-7812 L7 MR	2-C polyurethane	-	3 minutes	-	80	40 MPa / 5800 psi	20 MPa / 2900 psi	2%	Beige	Drums, pails, auto-mix pouch	12
SikaForce®-7816 L60	2-C polyurethane	60 minute pot life	45 minutes	-	70	33 MPa / 4780 psi	20 MPa / 2900 psi	4%	Beige	Drums, totes	12
SikaForce®-7818 L7	2-C polyurethane	7 minute pot life	3 minutes	-	75	35 MPa / 5100 psi	20 MPa / 2900 psi	2.50%	Beige	Drums, pails, cartridges, cans	Drums - 12; Cartridges/cans/pails - 9
SikaPower®-1200 (A) / SikaPower®-1040 (B)	2-C Epoxy	-	45 minutes	-	-	40 MPa / 5800 psi	20 MPa / 2900 psi	3.50%	Green	Drums, cartridges	12
SikaPower®-4508	1-C epoxy	25 minute curing time	-	-	65	12 MPa / 1700 psi	10 MPa / 1500 psi	40%	White	Drums, unipacks	6
SikaPower®-492 US	1-C epoxy	20 minute curing time	-	-	-	30 MPa / 4400 psi	20 MPa / 2900 psi	8%	Black	Drums, hobbocks, cartridges	9
SikaPower®-550 G	1-C epoxy	20 minute curing time	-	-	-	-	22 MPa / 3300 psi	-	Green	Drums, pails	3
SikaMelt®-673	1-C PUR hotmelt	-	Long	-	-	9 MPa / 1300 psi	-	-	Red	Drums	9
SikaMelt®-675 IS	1-C PUR hotmelt	-	Long	-	37	13 MPa / 1900 psi	-	-	White	Drums	9
SikaMelt®-677	1-C PUR hotmelt	-	Long	-	72	9 MPa / 1300 psi	-	-	White - beige, opaque	Drums, hobbock, bags	9

STRUCTURAL ADHESIVE

HOTMELT

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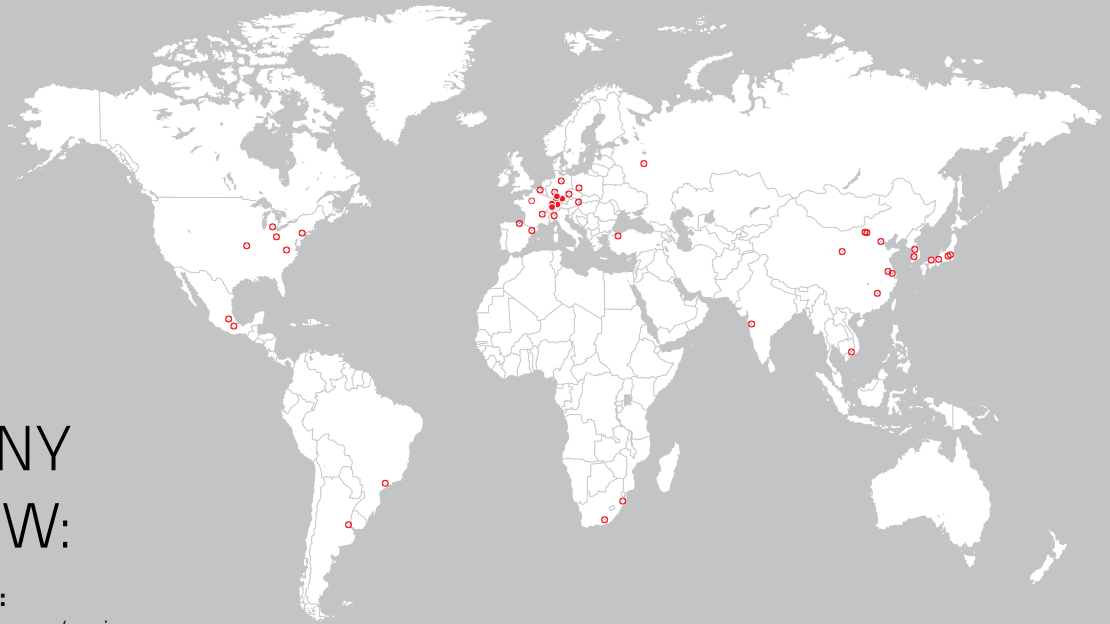
Products	BUTYL	Base Technology	Skin Time	Open Time	Hardness		Tensile Strength	Lap Shear Strength	Elongation at Break	Color	Packaging	Shelf Life (months)
					Shore A	Shore D						
SikaDamp®-630		Elastomeric damper	-	-	-	-	-	-	-	Black	Rolls, sheets	12
Sikagard®-6682		Water based acrylic dispersion	4 - 48 hours	-	-	-	-	-	-	Dark gray	Drums, pails	9
SikaLastomer®-511		Non-skinning butyl	6 months	-	-	-	-	-	-	Off-white	Drums, cartridges, pails	12
SikaLastomer®-65		Butyl	-	-	-	-	20 psi	-	1150%	White	Rolls	18
SikaLastomer®-68		Butyl	-	-	-	-	18 psi	-	700%	Black	Rolls	18
SikaLastomer®-714		Butyl-based sealant	-	3 hours	-	-	-	-	-	Black	Cartridges	24
SikaLastomer®-82		Butyl	-	-	-	-	17-20 psi	-	1100%	Gray	Rolls	18
SikaLastomer®-95		Butyl	-	-	-	-	17-20 psi	-	1100%	Gray	Rolls, flat packs	18

Products	SURFACE PREP	Base Technology	Flash Off / Drying Time	Open Time	Application	Tensile Strength	Lap Shear Strength	Elongation at Break	Color	Packaging	Shelf Life (months)
Sika® Aktivator UH-2 LUM											
Sika® Aktivator-100 US		Solvent-based adhesion promoter	10 minutes - 2 hours	-	Wipe on / wipe off	-	-	-	Colorless to slightly yellow	250 or 1000 ml bottles	12
Sika® Aktivator-110 LUM		Detectable, solvent-based adhesion promoter	10 minutes - 2 hours	-	Wipe on / wipe off	-	-	-	Transparent - clear, yellow, or amber in color	1000 ml bottles	12
Sika® Aktivator-205 US		Solvent-based adhesion promoter	10 minutes	-	Wipe on	-	-	-	Transparent	250 or 1000 ml bottles	12
Sika® Primer-206 G+P		Solvent-based black primer	10 minutes - 2 hours	-	Brush on	-	-	-	Black	250 or 1000 ml bottles	9
Sika® Primer-207 AGR		Solvent-based black primer	10 minutes - 24 hours	-	Brush on	-	-	-	Black	100 or 250 ml bottles	12
Sika® Primer-209 D		Solvent-based black primer	10 minutes - 24 hours	-	Brush on	-	-	-	Black	250 ml bottles	9
Sika® Primer-210		Solvent-based adhesion promoter	10 minutes - 24 hours	-	Brush on	-	-	-	Transparent, yellowish	250 ml bottles	9
Sika® Primer-215		Solvent-based adhesion promoter	30 minutes - 24 hours	-	Brush on	-	-	-	Transparent, yellowish	250 ml bottles	12
Sika® Remover-208		Cleaning Agent	-	-	Wipe on / wipe off	-	-	-	Transparent	1000 ml cans bottles	24
Sika®-Slick US		Tooling Agent	-	-	-	-	-	-	Transparent	1 gallon bottles	12
Sikaflex® Primer-260		Solvent-based adhesion promoter	1 - 8 hours	-	Brush on	-	-	-	Transparent	Pints	6

GLOBAL BUT LOCAL PARTNERSHIP

Sika® is a globally active company supplying the specialty chemicals markets. It is a leader in processing materials used in sealing, bonding, damping, reinforcing and protecting load-bearing structures in construction (buildings and infrastructure construction) and in industry (vehicle, building components, equipment production, solar and wind power).

Sika's product lines feature high-quality concrete admixtures, specialty mortars, sealants and adhesives, damping and reinforcing materials, structural strengthening systems, industrial flooring and membranes. Subsidiaries in more than 101 countries worldwide and approximately 18,000 employees link customers directly to Sika.



START WITH SIKA THROUGH ANY OF THE CONTACT POINTS BELOW:

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TECHNICAL SERVICE

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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 shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **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 Sika's Terms and Conditions of Sale available at <http://usa.sika.com/> or by calling 201-933-8800.