

PRODUCT DATA SHEET

Sikaflex®-558

STP assembly and glazing adhesive with acceleration option

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

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| Chemical base | Silane Terminated Polymers |
| Color (CQP001-1) | Black |
| Cure mechanism | Moisture-curing |
| Density (uncured) | 1.5 kg/l |
| Non-sag properties (CQP061-1) | Very good |
| Application temperature | 5 – 40 °C |
| Skin time (CQP019-1) | 30 minutes ^A |
| Open time (CQP526-1) | 20 minutes ^A |
| Curing speed (CQP049-1) | (see diagram 1) |
| Shore A hardness (CQP023-1 / ISO 7619-1) | 55 |
| Tensile strength (CQP036-1 / ISO 527) | 3 MPa |
| Elongation at break (CQP036-1 / ISO 527) | 300 % |
| Tear propagation resistance (CQP045-1 / ISO 34) | 20 N/mm |
| Tensile lap-shear strength (CQP046-1 / ISO 4587) | 2.3 MPa |
| Service temperature (CQP509-1 / CQP513-1) | -50 – 90 °C |
| Shelf life (CQP016-1) | unipack 9 months ^B pail / drum 6 months ^B |

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) storage below 25 °C

DESCRIPTION

Sikaflex®-558 is an elastic 1-component Silane Terminated Polymer (STP) direct-glazing and assembly adhesive with good gap-filling capabilities. It is designed for bonding and sealing applications in the commercial-vehicle industry.

Sikaflex®-558 is textured and has a mat black color. This texture cannot be eliminated and will remain visible after full cure.

Sikaflex®-558 can be accelerated with Sika's PowerCure system.

PRODUCT BENEFITS

- Solvent-, PVC-, isocyanate- and phthalate-free
- Curing can be accelerated with Sika Power-Cure
- Very good weathering stability
- Suitable for bonding and sealing
- Low-modulus and highly elastic
- Very good processing and tooling characteristics

AREAS OF APPLICATION

The Sikaflex®-558 is designed for assembly and direct-glazing applications in the commercial-vehicle industry. It exhibits very good weathering, tooling and application properties and is therefore suitable for exterior joints.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-558 on materials prone to stress cracking.

Sikaflex®-558 is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

Sikaflex®-558 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).

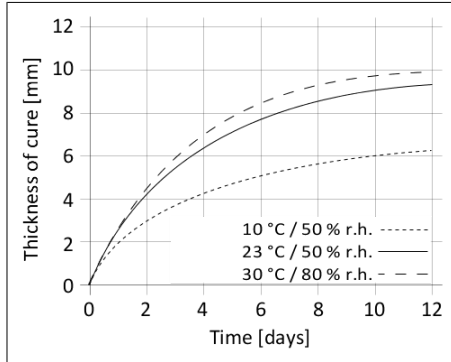


Diagram 1: Curing speed Sikaflex®-558

CHEMICAL RESISTANCE

Sikaflex®-558 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 appropriate Sika® Pretreatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-558 can be processed between 5 °C and 40 °C (climate and product) 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.

Consider the viscosity 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).

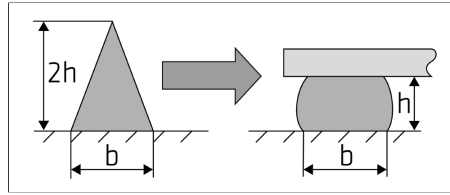


Figure 1: Recommended bead configuration

Sikaflex®-558 can be processed with hand, pneumatic or electric driven piston guns as well as pump equipment. Contact the System Engineering Department of Sika Industry in advance if it is intended to process Sikaflex®-558 with pumps.

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.

Removal

Uncured Sikaflex®-558 can 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 such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin.

Application limits

Pumpability of Sikaflex®-558 is limited and requires special attention i.e. pump equipment needs to be carefully selected (see also indications above).

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.

- Safety Data Sheets
- Sika Pre-treatment Chart
For Silane Terminated Polymer
- General Guidelines
Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

| | |
|---------|--------|
| Unipack | 600 ml |
| Pail | 23 l |
| 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.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

PRODUCT DATA SHEET

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