

## PRODUCT DATA SHEET

## Sikaflex®-235

Sealant with specific chemical resistance

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured)	1.2 kg/l
Application temperature	product, ambient 15 – 35 °C
Skin time (CQP019-1)	60 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	1 %
Shore A hardness (CQP023-1 / ISO 48-4)	40
Tensile strength (CQP036-1 / ISO 527)	2.0 MPa
Elongation at break (CQP036-1 / ISO 527)	700 %
Tear propagation resistance (CQP045-1 / ISO 34)	8 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)	1.5 MPa
Service temperature (CQP513-1)	-40 – 90 °C 4 hours 120 °C 1 hour 140 °C
Shelf life	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r.h.<sup>B)</sup> stored below 25 °C

## DESCRIPTION

Sikaflex®-235 is a 1-component polyurethane sealant of paste-like consistency that cures on exposure to atmospheric moisture. It is designed for general sealing applications.

## PRODUCT BENEFITS

- Easy application
- Good ageing resistant
- Short cut-off string
- Very low VOC content

## AREAS OF APPLICATION

Sikaflex®-235 is a multipurpose joint sealant for different plastics (e.g. PBT, PA), where temporary resistance against fluids (e.g. fuels, mineral oils) is required. Any specific resistance has been tested and approved by the customer.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-235 on materials prone to stress cracking.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

## CURE MECHANISM

Sikaflex®-235 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).

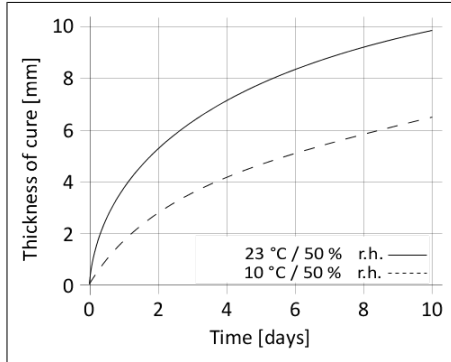


Diagram 1: Curing speed Sikaflex®-235

## 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®-235 can be processed between 15 °C and 35 °C (product and ambient) but changes in reactivity and application properties have to be considered. The temperature for substrate need to be at least 3 °C above the dew point.

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

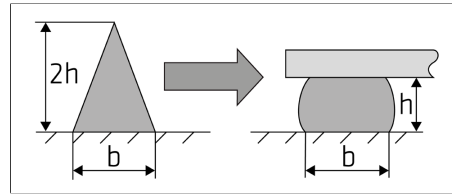


Figure 1: Recommended bead configuration

Consider: The skin time is significantly shorter in hot and humid climate.

Sikaflex®-235 is processed with pump equipment. 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® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior the use.

### Removal

Uncured Sikaflex®-235 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 such as Sika® Cleaner-350H 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
- General Guideline Bonding and Sealing with 1-component Sikaflex®

## PACKAGING INFORMATION

Pail	23 l
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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.

## 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

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