

## PRODUCT DATA SHEET

# SikaBiresin® AF246

Two-component polyurethane adhesive for aerospace air filtration systems

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

Properties	SikaBiresin® AF246 (A)	SikaBiresin® AF246 (B)
Chemical base	Polyol	Isocyanate
Color (CQP001-1)	White	Brown
	mixed	White
Density	1.0 kg/l	1.22 kg/l
	cured	1.02 kg/l
Mixing ratio	by weight	100 : 14
	by volume	100 : 11.5
Viscosity (CQP538-2)	205 Pa·s	0.021 Pa·s
	mixed	17.5 Pa·s
Application temperature	15 – 30 °C	
Pot life (CQP021-3 / Gel Timer TECAM)	150 g at 23 °C	8 minutes
Open time (CQP046-11 / ISO 4587)	15 minutes	
Shore D hardness (CQP023-1 / ISO 868)	42 <sup>A</sup>	
Floating roller peel strength	aluminum 2017A (sandblasted)	4 kN/m
Tensile lap-shear strength (ISO 4587)	aluminum 2017A (sandblasted)	5.5 MPa <sup>B, C</sup>
	stainless steel 304 (sandblasted)	6 MPa <sup>B, C</sup>
	electro-galv. steel (sandblasted)	5 MPa <sup>B, C</sup>
Shelf life	6 months	

CQP = Corporate Quality Procedure

<sup>A)</sup> curing: 2 hours at 80 °C<sup>B)</sup> curing: 16 hours at 70 °C<sup>C)</sup> cohesive failure, according to EN ISO 10365 Standard
**DESCRIPTION**

SikaBiresin® AF246 is a 2-component self-extinguishing polyurethane adhesive specifically developed for use in aerospace air filtration systems.

**PRODUCT BENEFITS**

- 2-component polyurethane liquid adhesive
- Solvent and halogen free
- Self-extinguishing
- Semi-flexible

**AREAS OF APPLICATION**

SikaBiresin® AF246 is a self-extinguishing adhesive designed for high-performance bonding applications in aerospace air filtration systems.

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

## APPROVAL / CERTIFICATES

- Smoke, toxicity: meets the requirements of ABD0031 issue C for smoke and toxicity flaming and non-flaming tests
- Self-extinguishing: meets the requirements of the FAR 25§853 AMDT.25-83(a) App F Part I for flammability 12 seconds (6 mm thickness)

## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific process conditions.

### Application

SikaBiresin® AF246 is dispensed with adequate 2-component equipment. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

### Removal

Uncured SikaBiresin® AF246 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.

## STORAGE CONDITIONS

SikaBiresin® AF246 has to be kept between 15 °C and 25 °C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has to be protected against humidity.

## 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

SikaBiresin® AF246 (A)

Hobbock	25 kg
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SikaBiresin® AF246 (B)

Canister	4.2 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.

## 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 end-use 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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