

## Sikaflex® Fix

The multipurpose polyurethane sealer

### Technical Product Data

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Chemical base		1-C polyurethane
Colour (CQP <sup>1</sup> 001-1)		White, grey, black
Cure mechanism		Moisture-curing
Density (uncured) (CQP 006-4)		1.2 kg/l approx.
Non-sag properties		Good
Application temperature		5 - 45°C (40 - 115°F)
Tack free time <sup>2</sup> (CQP 019-1)		20 min. approx.
Open time <sup>2</sup> (CQP 526-1)		20 min. approx.
Curing speed (CQP 049-1)		see diagram 1
Shrinkage (CQP 014-1)		6 % approx.
Shore A-hardness (CQP 023-1 / ISO 868)		30 approx
Tensile strength (CQP 036-1 / ISO 37)		1.8 N/mm <sup>2</sup> approx.
Elongation at break (CQP 036-1 / ISO 37)		700 % approx.
Tear propagation resistance (CQP 045-1 / ISO 34)		6 N/mm approx.
Service temperature (CQP 513-1)	permanent	-40 -90°C (-40 - 195°F)
Short term	1 day	120 °C (248°F)
	1 hour	140 °C (284°F)
Shelf life (storage below 25°C) (CQP 016-1)	cartridge	9 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23°C (73°F) / 50% r.h.

### Description

Sikaflex® Fix is a multipurpose polyurethane sealer for various applications at vehicles. It cures on exposure to atmospheric moisture to form a durable elastomer.

Sikaflex® Fix is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

### Product Benefits

- Polyurethane Technology
- Cost Effective
- Easy to Use
- Can be overpainted
- Can be sanded
- Non-corrosive
- Bonds well to a wide variety of substrates

### Areas of Application

Sikaflex® Fix bonds well to a wide variety of substrates such as glass, metal, paint coatings, ceramic materials and plastics.

Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility. Seek manufacturer's advise before using on transparent materials or in joints that are exposed to direct sunlight.



### Cure Mechanism

Sikaflex® Fix 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).

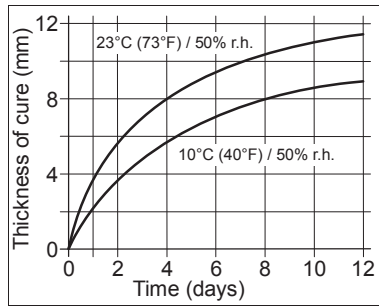


Diagram 1: Curing speed for Sikaflex® Fix

### Chemical Resistance

Sikaflex® Fix is resistant to fresh water, seawater, limewater, sewage effluent, diluted acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions and solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

### Method of Application

#### Surface preparation

Surfaces must be clean, dry and free from all traces of grease, oil and dust. As a rule, the substrates must be prepared in accordance with the instructions given in the current Sika Primer Chart.

Advice on specific applications is available from the Technical Service Department of Sika Industry.

#### Application

Cartridges: Pierce cartridge membrane.

Cut off the tip of the nozzle to suit joint width and apply the sealant into the joint with a suitable hand operated or compressed air gun, taking care to avoid air entrapment. Once opened, packs should be used up within a relatively short time.

Do not apply at temperatures below 5°C or above 45°C. The

optimum temperature for substrate and sealant is between 15°C and 25°C.

#### Tooling and finishing

Tooling and finishing must be carried out within the tack-free time of the sealant. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for suitability / compatibility.

#### Removal

Uncured Sikaflex® Fix 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 should be washed immediately using Sika® Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

#### Overpainting

Sikaflex® Fix can be overpainted when tack-free.

The paint must be tested for compatibility by carrying out preliminary trials. Baked enamels should not be applied to Sikaflex® Fix until the adhesive has attained full cure. It should be understood that the hardness and film thickness of the paint may impair the elasticity of the adhesive and lead to cracking of the paint film.

### Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Primer Chart
- General Guidelines for bonding and sealing with Sikaflex® products

### Packaging Information

Cartridge	300 ml
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### Value Bases

All technical data stated in this Product Data Sheet 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 Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

### Legal Notes

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.



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