Industry

# Sikaflex®-298

## Slightly thixotropic bedding compound for marine applications

Technical Product Data

| | | |
|---|---|---|
| Chemical base | | 1-C polyurethane |
| Colour (CQP[1]001-1) | | Brown, black |
| Cure mechanism | | Humidity-curing |
| Density (uncured) (CQP006-4) | | 1,2 kg/l approx. |
| Non-sag properties | | Slightly thixotropic |
| Application temperature | | +10°C to +35°C |
| Skin time[2] (CQP019-1) | | 100 min. approx. |
| Curing speed (CQP049-1) | | (see diagram) |
| Shrinkage (CQP014-1) | | 6% approx. |
| Shore A hardness (CQP023-1 / ISO 868) | | 30 approx. |
| Tensile strength (CQP036-1 / ISO 37) | | 1,2 N/mm$^2$ approx. |
| Elongation at break (CQP036-1 / ISO 37) | | 600% approx. |
| Tear propagation resistance (CQP045-1 / ISO 34) | | 4 N/mm approx. |
| Glass transition temperature (CQP509-1 / ISO 4663) | | -45°C approx. |
| Service temperature (CQP513-1) | permanent | -40°C to +90°C |
| Shelf life (storage below 25°C) (CQP016-1) | | 12 months for unipac<br>9 months for pail |

[1] CQP = Corporate Quality Procedures [2] 23°C / 50% r.h.

### Description

Sikaflex®-298 is a slightly thixotropic 1-c polyurethane adhesive and sealant which cures on exposure to atmospheric humidity to form a durable elastomer.
Sikaflex®-298 is manufactured in accordance with ISO 9001 / 14001 quality assurance system as well as with the Responsible Care Program and meets the regulations set out by the International Maritime Organization (IMO).

### Product Benefits

- 1-C formulation
- Slightly thixotropic
- Elastic behaviour
- Contains no highly inflammable solvents
- Sound deadening
- Long open time

### Areas of Application

Sikaflex®-298 is suitable for bonding deck covering materials made from synthetic resins (except polyethylene and polypropylene), and for bedding-in and sealing of teak plank decking laid on top of the subdeck surface. Suitable substrates include GRP, marine plywood, steel, aluminum sealed with an anti-corrosion coating (epoxy or polyurethane-acrylic based) and stainless steel.

## Cure Mechanism

Sikaflex®-298 cures by reaction with atmospheric humidity, which may be drawn from the surrounding air, from porous substrates, or from spraying with a fine water mist (approx. 10 g of water per $m^2$ of bond face).

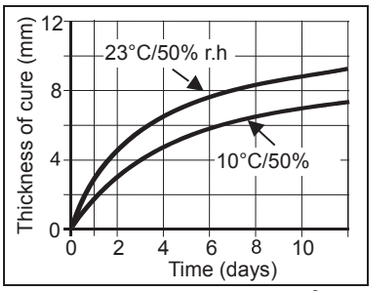


*Diagram 1: Curing speed for Sikaflex®-298*

## Chemical Resistance

Sikaflex®-298 is resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, animal fats and oils; Sikaflex®-298 is not resistant to organic acids and caustic solutions or paint thinners.

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 surfaces must be prepared in accordance with the instructions given in the current edition of the Sika® Primer Chart for Marine Applications

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

*Application*

Unipac: Place the unipac in the application gun and snip off the closure clip. Cut off the tip of the nozzle to suit the application and apply the adhesive with a suitable hand-operated or compressed-air gun.

Once opened, packs should be used up within a relatively short space of time.

Do not apply at temperatures below 10°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C.

The adhesive should be applied over large surface areas with a notched spreader (notch depth approx. 5 mm). Coverage is approximately 1200 ml per $m^2$. If the substrates to be bonded are impervious to moisture or if an accelerated rate of cure is required, the adhesive should be lightly sprayed with a water mist shortly before the substrates are brought together (use an aerosol spray or spray gun to apply approx. 10 g water per $m^2$). Avoid air entrapment when making the bond or filling joints. Assure the complete filling of the space between the deck and the planks. Apply firm pressure when bringing components together and keep the joint under pressure for at least 3 hours until the adhesive has set.

For advice on selecting and setting up a suitable pump system, as well as on the techniques of pump operated application, please contact the System Engineering Department of Sika Industry.

*Removal*

Uncured Sikaflex®-298 can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material only can 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!

## Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- General guidelines for bonding and sealing with Sikaflex® products.
- Marine Application Guide

## Packaging Information

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| Unipac | 600 ml |
| Pail | 10 l |

## Important

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

## Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

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