

## PRODUCT DATA SHEET

# Sikaflex®-215

Brushable seam sealant for low bake paint cycle conditions

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

Chemical base	1-component polyurethane
Color (CQP001-1)	White, grey
Cure mechanism	Moisture-curing
Density (uncured)	depending on color 1.40 kg/l
Application temperature	ambient 5 – 40 °C
Skin time (CQP019-1)	20 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	1.5 %
Shore A hardness (CQP023-1 / ISO 48-4)	55
Tensile strength (CQP036-1 / ISO 527)	1.4 MPa
Elongation at break (CQP036-1 / ISO 527)	170 %
Tear propagation resistance (CQP045-1 / ISO 34)	6 N/mm
Service temperature (CQP513-1)	-50 – 90 °C
Shelf life	drum 9 months <sup>B</sup> cartridge 12 months <sup>B</sup>

CQP = Corporate Quality Procedure

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

Sikaflex®-215 is a brushable 1-component polyurethane sealant. It has been designed for seam sealing applications on e-coated surfaces. Sikaflex®-215 can be painted and withstand common industrial paint oven conditions.

**PRODUCT BENEFITS**

- Can be painted
- Withstands paint oven condition even up to 120 °C
- Can be pumped over long distances
- Very good application properties
- Easy to brush
- Low odor and free of solvents

**AREAS OF APPLICATION**

Sikaflex®-215 has been designed for seam sealing applications on e-coated chassis and body structures in the transportation and collision repair industry. It withstands paint oven temperatures even up to 120 °C for max. 2 hours.

Sikaflex®-215 is applied in bead form and can be easily brushed or smoothed to get the desired finish. It must be painted if used on exterior joints.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-215 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.

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## CURE MECHANISM

Sikaflex®-215 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).

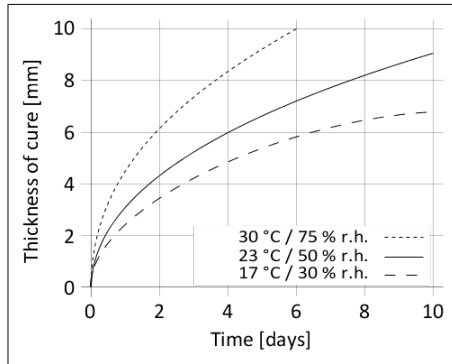


Diagram 1: Curing speed Sikaflex®-215

## CHEMICAL RESISTANCE

Sikaflex®-215 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® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

### Application

Sikaflex®-215 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 process material is between 15 °C and 25 °C.

Sikaflex®-215 can be processed with manual, pneumatic or electric driven piston guns as well as 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. Do not use any tooling agent, since it might impair a good painting process.

## Removal

Uncured Sikaflex®-215 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.

## Overpainting

Sikaflex®-215 can be painted in fresh or cured state. Recommended thickness of Sikaflex®-215 is up to 3 mm. Baking temperature must not exceed 120 °C.

Due to the wide variety of paints preliminary trials under manufacturing conditions are required.

The elasticity of paints is usually lower than that of sealants. This could lead to cracking of the paint in the joint area.

## 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
- Sika Pre-treatment Chart
  - For 1-component Polyurethane
- General Guideline
  - Bonding and Sealing with 1-component Sikaflex®

## PACKAGING INFORMATION

Cartridge <sup>A</sup>	300 ml
Pail	23 l
Drum	195 l

<sup>A)</sup> Cartridge only available in white

## 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.

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