

PRODUCT DATA SHEET

SikaFast®-5215 NT

Fast curing, flexibilized, 2-component structural adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaFast®-5215 NT	Component B SikaFast®-5200
Chemical base	Acrylate	
Color (CQP001-1)	White	Black
	mixed Grey	
Cure mechanism	Radical polymerization	
Density (uncured)	1.15 kg/l	1.5 kg/l
	mixed (calculated) 1.19 kg/l	
Mixing ratio	by volume 10 : 1	
	by weight 10 : 1.3	
Consistency	Thixotropic paste	
Application temperature	5 – 40 °C	
Open time (CQP526-2)	5 minutes ^A	
Fixing time	time to reach 80 % of final strength 15 minutes ^A	
Shore A hardness (CQP023-1 / ISO 48-4)	90	
Shore D hardness (CQP023-1 / ISO 48-4)	50	
Tensile strength (CQP036-1 / ISO 527)	10 MPa ^A	
Elongation at break (CQP036-1 / ISO 527)	200 % ^A	
E-Modulus (CQP036-1 / ISO 527)	250 MPa ^A	
Tensile lap-shear strength (CQP046-6 / ISO 4587)	10 MPa ^A	
Glass transition temperature (CQP509-1 / ISO 6721)	60 °C	
Service temperature (CQP513-1)	-40 – 80 °C	
Shelf life	cartridge 50 ml 15 months ^B	
	cartridge other sizes 9 months ^B	
	pail / drum 12 months ^B 9 months ^B	

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) stored below 25 °C and not exposed to direct sun light
DESCRIPTION

SikaFast®-5215 NT is a fast curing, flexibilized structural, two-part adhesive system, which is based on Sika's Acrylic Double Performance (ADP) polymer technology.

Uncured SikaFast®-5215 NT is a pasty, non-sagging, hardly inflammable material which allows an easy and precise application.

PRODUCT BENEFITS

- Strength development within minutes after application
- Adhesion to a wide range of substrates without or with limited surface preparation
- High strength and impact resistance
- Solvent and acid free
- Lower odor than products containing MMA
- Easy mixing

AREAS OF APPLICATION

SikaFast®-5215 NT is a fast curing, flexibilized structural adhesive designed to replace mechanical fixings such as rivets, screws or welding. It is suitable for high strength fastening of concealed joints and exhibits very good adhesion on different types of substrates including top coats, plastics, glass, wood, etc. 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

SikaFast®-5215 NT cures according to radical chain polymerization.

Open and fixture time are influenced by mixing ratio deviations as well as temperature, e.g., as higher the temperature as shorter the open and fixture time and vice versa.

Adjustment of the bonded assembly is only possible within the open time.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct a project related testing.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly, for example with an IPA wipe.

For best adhesion performance on non-porous substrates pre-treat the bonding area with Sika® ADPrep prior to the bonding process.

Due to the diversity of materials, preliminary tests with original substrates are necessary.

Application

SikaFast®-5215 NT is applied with a mixing ratio of 10:1 by volume through a 24 elements static mixer. If applied in large masses, heat is generated by the exothermic reaction. To avoid excessive temperature increase, bond line thickness is limited to 3 mm, but must measure at least 0.5 mm.

Optimum temperature for the bonding process is between 15 °C and 25 °C. The approved temperature range for substrates and adhesive is between 5 °C and 40 °C. The influence of the reactivity by temperature changes has to be respected.

After the open time has elapsed the bonded parts must not be moved against each other anymore. When the fixture time is reached the parts can be moved if no additional stress is distributed to the bond line. For support in evaluation of the appropriate application equipment contact the Sika System Engineering department of Sika Industry.

Removal

Uncured excess of SikaFast®-5215 NT can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Cleaner-350H towels 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

PACKAGING INFORMATION

SikaFast®-5215 NT

Dual cartridge	50 ml 250 ml
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SikaFast®-5215 NT (A)

Pails	20 l 169 l
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SikaFast®-5200 (B)

Pail	18 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

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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