

PRODUCT DATA SHEET

Sikaflex®-985

Fast-curing, 2-component STP assembly adhesive / sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Sikaflex®-985 (A)	Sikaflex®-985 (B)
Chemical base	2-component silane terminated polymer (STP)	
Color (CQP001-1)	White	Black
Density (uncured)	1.18 kg/l	1.35 kg/l
	mixed	1.21 kg/l
Mixing ratio	A : B by volume	4 : 1
	A : B by weight	3.5 : 1
Application temperature	ambient	5 – 40 °C
Open time (CQP526-1)	20 minutes ^A	
Shore A hardness (CQP023-1 / ISO 48-4)	68	
Tensile strength (CQP036-1 / ISO 527)	8 MPa	
Elongation at break (CQP036-1 / ISO 527)	150 %	
Tensile lap-shear strength (CQP046-1 / ISO 4587)	8 MPa	
Service temperature (CQP513-1)	-45 – 90 °C	
Shelf life	pail	6 months ^B
	cartridge	9 months ^B

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) stored below 25 °C in unopened container

DESCRIPTION

Sikaflex®-985 is a 2-component Silane Terminated Polymer (STP) assembly adhesive which cures by chemical reaction of the two components. Owing to its good weathering resistance and gap-filling performance it can also be used for exterior sealing joints.

PRODUCT BENEFITS

- Solvent- and isocyanate-free
- Good gap-filling capabilities
- Good weathering and ageing resistance
- Minimal pre-treatment required for most common substrates

AREAS OF APPLICATION

Sikaflex®-985 is suitable for bonding large components exposed to dynamic stress and where the attainment of early strength is required. Common substrates are metals, particularly aluminium (including anodised), steel (including phosphated, chromated, galvanised), metal primers and paint coatings (2-part systems), ceramic materials and plastics. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-985 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.

CURE MECHANISM

The curing of Sikaflex®-985 takes place by chemical reaction of the two components. For typical strength build up data see table below.

Time [h]	Strength [MPa]
1	0.6
2	1.0
4	1.5

Table 1: Lap-shear strength at 23 °C / 50% r.h.

CHEMICAL RESISTANCE

Sikaflex®-985 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.

All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application

Sikaflex®-985 can be processed with pneumatic or electric driven piston guns as well as pump equipment.

Sikaflex®-985 can be applied between 5 °C and 40 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C.

The open time is significantly shorter in hot and humid climate. The parts must always be joined within the open time. As a rule of thumb, a change of + 10 °C reduces the open time by half.

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 open time of the adhesive. We recommend the use of Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility.

Removal

Uncured Sikaflex®-985 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®-985 can be best painted within the skin formation time. If painting process takes place after the sealant has built a skin, adhesion could be improved by treating the joint surface with Sika® Aktivator-100 or Sika® Aktivator-205 prior to paint process. If the paint requires a baking process (> 80 °C), best performance is achieved by allowing the sealant to fully cure first. All paints have to be tested by carrying preliminary trials under manufacturing conditions. 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
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Sikaflex®-985 (A+B)

Dual Cartridge	400 ml
Mixer: OC-MFQX 10-24T	

Sikaflex®-985 (A)

Pail	23 l
------	------

Sikaflex®-985 (B)

Pail	23 l
------	------

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.

PRODUCT DATA SHEET

Sikaflex®-985
Version 02.01 (06 - 2026), en_IN
012501219850001000

Sika India Pvt. Ltd.
Plot No. D102/2, TTC Industrial Area
Navi Mumbai, Darave
Thane - 400706
Maharashtra, India
Phone: +91 22 6270 4038/4039
info.india@in.sika.com

