



TBP Converting, Inc.
SikaFlex 232
Product Data Sheet

Sikaflex® -232 US

Elastic Adhesive/Sealant with High Green Strength

Typical Product Data

Chemical base	1-C polyurethane
Color	White
Cure mechanism	Humidity Curing
Density (uncured)	10.8 lb/gal
Non-sag properties	Good
Application temperature product	40°F - 100°F (5°C - 38°C)
Skin time ¹ (CQP 019-1)	35 min
Shore A-hardness (ASTM D 2240)	40
Tensile strength (ASTM D 412)	210 psi
Elongation at break (ASTM D 412)	500%
Tensile-shear strength (ASTM D 1002)	210 psi
Service temperature permanent	-40°F - 195°F (-40°C - 90°C)
Shelf life (storage below 77°F (25°C))	9 months

¹⁾ 73°F (23°C) / 50% r.h.

Industry

Description

Sikaflex®-232 US is a non-sag, one-component polyurethane adhesive/sealant of stiff, paste-like consistency that exhibits high initial green strength and cures on exposure to atmospheric humidity to form a durable elastomer.

Sikaflex® -232 US is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the Responsible Care Program.

Product Benefits

- Adheres to a wide range of substrates
- Good gap-filling properties
- Excellent sag resistance
- Low odor, non-staining
- Paintable with excellent green strength

Areas of Application

Used in bonding applications where high green strength is required to improve the assembly process in many applications, including trailers, RV's, industrial assembly and HVAC units, etc. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available on request at tsmh@us.sika.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

Cure Mechanism

Sikaflex[®]-232 US 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).

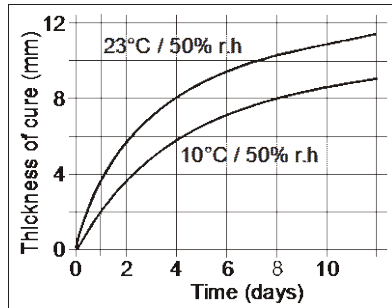


Diagram 1: Curing speed Sikaflex[®]-232 US

Chemical Resistance

Sikaflex[®]-232 US is resistant to fresh water, aqueous cleaning solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic and mineral acids, alcohol, and caustic solutions or 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 Sika[®] Pre-Treatment Chart for 1-component Polyurethanes.

Application

The optimum temperature for substrate and sealant is between 60°F (15°C) and 77°F (25°C).

Tooling and finishing

Tooling and finishing must be carried out within the skin time of the sealant. It is recommended using Sika[®]-Slick.

Prior to use, finishing agents or lubricants must be tested for suitability and compatibility.

Removal

Uncured Sikaflex[®]-232 US can 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 a suitable industrial hand cleaner and water. **Do not use solvents on skin!**

Overpainting

Sikaflex[®]-232 US can be overpainted after formation of a skin. In case the paint requires a bake process it may be necessary to wait for a full cure. 1C-PUR and 2C-acrylic based paints are usually suitable. Not suitable for oil based paints. All paints have to be tested by carrying preliminary trials under manufacturing conditions. The elasticity of paints is lower than that of polyurethanes. This could lead to cracking of the paint film in the joint area.

Further Information

To contact Sika Corporations' Technical Services Department please send an e-mail to tsmh@us.sika.com.

Copies of the following publications are available on request:

- Safety Data Sheets
- Pre-Treatment Chart
- Sika[®] Pre-Treatment Chart for 1-component Polyurethanes

Packaging Information

Unipack	600 ml
Cartridge	300 ml

Basis of Product Data

All technical data stated in this Product Data Sheet are based on laboratory tests only. 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.

Limited Material Warranty

Sika Corporation warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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