



TBP Converting, Inc.
SikaFlex 227 PDS

Sikaflex®-227

Fast Skinning, Elastic Adhesive/Sealant

Technical Product Data (typical values)

Chemical base		1-C polyurethane
Color	Standard Special Order	White, Aluminum Gray, Black, Colonial White, Designer Beige
Cure mechanism		Humidity Curing
Density (uncured)		10.6 lb/gal depends on color
VOC (EPA method 24)		0.41 lb/gal (48.9 g/l)
Non-sag properties		Good
Application temperature	product	41 °F - 100 °F (5 °C - 38 °C)
Tack free time ¹		40 min
Curing speed		(see diagram 1)
Shrinkage		5%
Shore A-hardness (ASTM D 2240)		40
Tensile strength (ASTM D 412)		245 psi
Elongation at break (ASTM D 412)		600%
Tear propagation resistance (ASTM D 624)		34 pli
Tensile-shear strength (ASTM D 1002)		160 psi
Glass transition temperature		-49 °F (-45 °F)
Movement accommodation factor		12.5%
Service temperature	permanent	-40 °F - 194 °F (-40 °C - 90 °C)
Shelf life (storage below 77 °F (25 °C))		9 months Cartridges/ Unipac 6 months Drums/Pails

¹) 73 °F (23 °C) / 50% r.h.

Description

Sikaflex®-227 is a 1-component, fast-curing, fast-skinning polyurethane based, elastomeric adhesive/sealant. It is a moisture-cured, non-sag system. Sikaflex®-227 provides a permanently elastic bond to fasten materials which have dissimilar coefficients of expansion. Meets ASTM C920 Type S, Grade NS, class 12.5, Federal specification TT-S-00230C, Type II, Class A. Sikaflex®-227 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, without primer in many cases.
- Exhibits tenacious adhesion to aluminum, FRP, steel, wood, SMC, RIM, prepainted metals, ZINCALUME, Zincgrip, and aluminized steel, without attacking the metal coating.
- Fast tack free time.
- Cures rapidly to a permanently elastic consistency with excellent cut and tear resistance.
- Odorless, non-staining.
- Can be painted over with water, oil, and rubber based coatings.

- Exhibits high recovery (> 90%), making it ideal for sealing dynamically moving joints.
- Weather resistant.
- Resistant to road salts.

Areas of Application

- Waterproofing exterior lap seams in many applications, including truck trailers, RV's, metal roofs, window perimeters, grain bins and HVAC units.
- Waterproofing rivet seams.
- Sealing of exposed and concealed joints of aluminum, steel, coated

Industry



metals, wood, roof rails, and door hinges in transport equipment.

- Sealing and caulking expansion joints and pre-cast concrete panel joints.
- Suitable substrates are metal primers and paint coating (2-c systems), metals, painted plastics and plastics.
- Seek manufacturer's advice before using on transparent and pigmented materials that are prone to stress cracking.
- This product is suitable for experienced professional users only.
- Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Cure Mechanism

Sikaflex®-227 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).

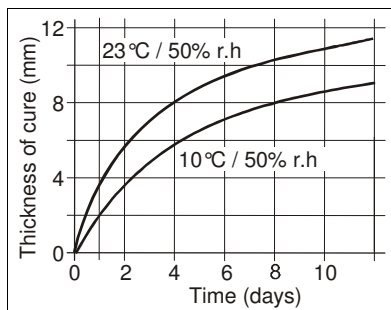


Diagram 1: Curing speed Sikaflex®-227

Chemical Resistance

Sikaflex®-227 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 current Sika Primer Chart.

Application

Cartridges: Pierce cartridge membrane. Unipacs: Place unipac in the application gun and snip off the closure clip. Cut off the tip of the nozzle to suit joint width and gun the sealant into the joint with a suitable compressed air or hand operated gun, taking care to avoid air entrapment. Once opened, packs should be used up within a relatively short space of time. Do not apply at temperatures below 41°F (5°C) or above 100°F (38°C). The optimum temperature for substrate and sealant is between 59°F (15°C) and 77°F (25°C).

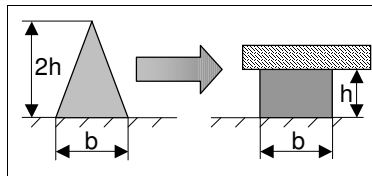


Figure 1: Recommended bead configuration

Tooling and finishing

Tooling and finishing must be carried out within the tack free time of the sealant. We recommend the use of Sika®-Slick Cutout Lubricant and Tooling Agent. Other finishing agents or lubricants must be tested for suitability/ compatibility.

Removal

Uncured Sikaflex®-227 can be removed from tools and equipment with Sika®Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Strictly follow solvent

manufacturer's instructions for use and warnings. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin!

Overpainting

Sikaflex®-227 can be overpainted when tack-free. The paint and paint process must be tested for compatibility by carrying out preliminary trials. Sikaflex®-227 should not be exposed to baking temperatures until it has attained full cure. The hardness and film thickness of the paint may impair the elasticity of the sealant and lead to cracking of the paint film with time.

Limitations

Avoid application below 41°F (5°C) and above 100°F (38°C). Do not apply on frozen or wet surfaces or through standing water. Do not apply over silicones or in the presence of curing silicones. Contact with alcohol or alcohol-containing solvents will prevent cure.

WARNING: SENSITIZER.

Contains Polyisocyanate Prepolymer (Mixture), Xylene (CAS 1330-20-7). Causes eye irritation. May cause skin/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged contact. May be harmful if swallowed. Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. Headaches and dizziness may result. **Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions.**

IRRITANT,

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Health	2
Flammability	1
Reactivity	0
Personal Protection	C

First Aid

Eyes – Hold eyelids apart and flush thoroughly with tepid water for 15 minutes. **Skin** – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and tepid water. **Inhalation** –

Remove to fresh air. **Ingestion** – Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further Information

Copies of the following publications are available on our website www.sikaindustry.com:

- Material Safety Data Sheets
- Product Data Sheet
- Sika Primer Chart
- General guidelines for bonding and sealing with Sika products

In case of emergency call:
Chemtrec: 800-424-9300
International: 703-527-3887

Health and Safety Information

For further 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. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

- **KEEP OUT OF REACH OF CHILDREN**
- **NOT FOR INTERNAL CONSUMPTION**
- **FOR INDUSTRIAL USE ONLY**
- **KEEP CONTAINER TIGHTLY CLOSED**

Packaging Information

Cartridge	300 ml
Unipac	300 ml 600 ml
Pails	4.5 gal
Drum	50 gal

Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Handling and Storage

Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.

Product Storage: Although a storage temperature range of 40-95°F is acceptable, maintaining a storage temperature of <77°F is most highly recommended to ensure maximum shelf life.

Clean Up

Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable environmental regulations.

Limited Material Warranty

SIKA 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 IMPLIED OR EXPRESS 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.**

Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without



notice.

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, product label and Material Safety Data Sheet

Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.



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