



TBP Converting, Inc.
SikaFlex 1a+
Product Data Sheet

Product Data Sheet

Edition 7.6.2017
Sikaflex® -1a+

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Description	Sikaflex-1a+ is a premium-grade, high-performance, moisture-cured, 1-component, polyurethane-based, non-sag elastomeric sealant. Sikaflex-1a+ can be used in green and damp concrete applications. Meets Federal Specification TT-S-00230C, Type II, Class A. Meets ASTM C-920, Type S, Grade NS, Class 35, use T, NT, O, M, G, I, A.
Where to Use	<ul style="list-style-type: none"> ■ Designed for all types of joints where maximum depth of sealant will not exceed 1/2 in. ■ Excellent for small joints and fillets, windows, door frames, reglets, flashing, common roofing detail applications, and many construction adhesive applications. ■ Suitable for vertical and horizontal joints; readily placeable at 40°F ■ Has many applications as an elastic adhesive between materials with dissimilar coefficients of expansion. ■ Submerged conditions, such as canal and reservoir joints.
Advantages	<ul style="list-style-type: none"> ■ Eliminates time, effort, and equipment for mixing, filling cartridges, pre-heating or thawing, and cleaning of equipment. ■ Fast tack-free and final cure times. ■ High elasticity - cures to a tough, durable, flexible consistency with exceptional cut and tear -resistance. ■ Stress relaxation. ■ Excellent adhesion - bonds to most construction materials without a primer. ■ Excellent resistance to aging, weathering. ■ Proven in tough climates around the world. ■ Can be applied to green concrete 24 hours after pour ■ Can be applied to damp concrete 1 hour after getting wet ■ Odorless, non-staining. ■ Jet fuel resistant. ■ Certified to the NSF/ANSI Standard 61 for potable water. ■ Urethane-based; suggested by EPA for radon reduction. ■ Paintable with water-, oil- and rubber-based paints. ■ Capable of ±35% joint movement.
Chemical Resistance	Good resistance to water, diluted acids, and diluted alkalines. Consult Technical Service for specific data.
Packaging	10.1 fl. oz. (300 mL) Cartridge 20 fl. oz. uni-pac Sausages

Typical Data (Material and curing conditions @ 75°F (24°C) and 50% RH)

RESULTS MAY DIFFER BASED UPON STATISTICAL VARIATIONS DEPENDING UPON MIXING METHODS AND EQUIPMENT, TEMPERATURE, APPLICATION METHODS, TEST METHODS, ACTUAL SITE CONDITIONS AND CURING CONDITIONS.

Shelf Life:	Cartridge and Sausage: 12 months in original, unopened packaging. Pail: 6 months in original, unopened packaging.
Storage:	Store at 40°-95°F (4°-35°C).
Product Conditioning:	Condition material to 65°-75°F before using.
Colors:	White & Limestone
Application Temperature:	40° to 100°F. Sealant should be installed when joint is at mid-range of its anticipated movement.
Service Range:	-40° to 170°F
Curing Rate:	Tack-free time 3 to 6 hours Tack-free to touch 3 hours
Final cure:	4 to 7 days
Tear Strength (ASTM D-624):	55 lb./in.
Shore A Hardness (ASTM C-661):	21 day 45±5
Movement Capability (ASTM C-719):	+/- 35%
Tensile Properties (ASTM D-412):	
21 day Tensile Stress	175 psi (1.21 MPa)
Elongation @ Break	550%
Stress @ 100%	85 psi (0.59 MPa)
Adhesion in Peel (TT-S-00230C, ASTM C 794):	
Substrate Peel Strength Adhesion Loss	Concrete 20 lb. 0% Aluminum 20 lb. 0% Glass 20 lb. 0%



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 SAFETY DATA SHEET WHICH ARE AVAILABLE ONLINE AT [HTTP://USA.SIKA.COM/](http://usa.sika.com/) OR BY CALLING SIKA'S TECHNICAL SERVICE DEPARTMENT AT 800.933.7452 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, PRODUCT LABEL AND SAFETY DATA SHEET PRIOR TO PRODUCT USE.

Coverage

10.1 oz Cartridge: Yield in Linear feet				
Depth	1/4"	3/8"	1/2"	
Width	1/4"	24.3		
	3/8"	16.2	10.8	
	1/2"	12.1	8.1	6.1
	3/4"	8.1	5.4	4.0
	1"			3.0
	1.25"			2.4
	1.5"			2.0

20 oz Sausage: Yield in Linear feet				
Depth	1/4"	3/8"	1/2"	
Width	1/4"	48.1		
	3/8"	32.1	21.4	
	1/2"	24.1	16.0	12.0
	3/4"	16.0	10.7	8.0
	1"			6.0
	1.25"			4.8
	1.5"			4.0

How to Use

Surface Preparation

Clean all surfaces. Joint walls must be sound, clean, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter must be thoroughly removed. A roughened surface will also enhance bond. Install bond breaker tape or backer rod to prevent bond at base of joint. Priming is not usually necessary. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure.

For green concrete applications control joints must be cut 8 hours prior to sealant installation and in expansion joint forms must be removed 4 hours prior to sealant installation. For wet concrete applications all excess or standing water must be displaced and concrete must then dry for a minimum of 60 min prior to sealant installation. Consult Sikaflex Primer Technical Data Sheet or Technical Service for additional information on priming.

Application

Recommended application temperatures: 40°-100°F. For cold weather application, condition units at approximately 70°F; remove prior to using. For best performance, Sikaflex-1a+ should be gunned into joint when joint slot is at mid-point of its designed expansion and contraction. Place nozzle of gun into bottom of the joint and fill entire joint. Keep the nozzle in the sealant, continue on with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping of sealant to eliminate entrapment of air.

Sikaflex-1a+ can be applied on green concrete after the concrete has cured for a minimum of 24 hours at 75°F. Control joints must be cut and open for min of 8 hours prior to application. Expansion joints must have forms removed a minimum of 4 hours prior to application. For damp concrete applications Sikaflex-1a+ can be applied 60 minutes after any and all water has been displaced.

Tooling and Finishing

Tool sealant to ensure full contact with joint walls and remove air entrapment. Joint dimension should allow for 1/4 inch minimum and 1/2 inch maximum thickness for sealant. Proper design is 2:1 width to depth ratio. For use in horizontal joints in traffic areas, the absolute minimum depth of the sealant is 1/2 in. and closed cell backer rod is recommended.

Removal

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

Over Painting

Allow 1-week cure at standard conditions when using Sikaflex-1a+ in total water immersion situations and prior to painting.

Limitations

- Allow 1 week cure at standard conditions when using Sikaflex-1a+ in total water immersion situations.
- When overcoating with water, oil and rubber based paints, compatibility and adhesion testing is essential.
- Sealant should be allowed to cure for 7 days prior to overcoating
- Avoid exposure to high levels of chlorine. (Maximum continuous level is 5 ppm of chlorine.)
- Maximum depth of sealant must not exceed 1/2 in.; minimum depth is 1/4 in.
- Maximum expansion and contraction should not exceed 35% of average joint width.
- Do not cure in the presence of curing silicone sealants.
- Avoid contact with alcohol and other solvent cleaners during cure.
- Do not apply when moisture-vapor-transmission condition exists from the substrate as this can cause bubbling within the sealant.
- Use opened cartridges and uni-pac sausages the same day.
- When applying sealant, avoid air-entrapment.
- Since system is moisture-cured, permit sufficient exposure to air.
- White color tends to yellow slightly when exposed to ultraviolet rays.
- Light colors can yellow if exposed to direct gas fired heating element.
- The ultimate performance of Sikaflex-1a+ depends on good joint design and proper application with joint surfaces properly prepared.
- The depth of sealant in horizontal joints subject to traffic is 1/2 in.
- Do not tool with detergent or soap solutions.
- Do not use in contact with bituminous/asphaltic materials.
- In green concrete applications sealing joints in poor or low strength concrete 24 hours after pour may impact ability of sealant to gain proper adhesion.
- In damp concrete applications all standing water and excess water must be eliminated prior to the 60 minute waiting time.



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Construction



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KEEP CONTAINER TIGHTLY CLOSED. KEEP OUT OF REACH OF CHILDREN. NOT FOR INTERNAL CONSUMPTION. FOR INDUSTRIAL USE ONLY. FOR PROFESSIONAL USE ONLY.

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

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