

PRODUCT DATA SHEET

Sikaflex®-227 US

1-component fast skinning sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component polyurethane
Color (CQP001-1)	Black, white, aluminum gray, hitachi gray, desert tan
Cure mechanism	Moisture-curing
Density (uncured)	depending on color 1.3 kg/l (10.8 lb/gal)
Non-sag properties	Good
Application temperature	5 – 35 °C (41 – 95 °F)
Skin time (CQP019-1)	40 minutes ^A
Curing speed (CQP049-1)	(see diagram 1)
Shrinkage (CQP014-1)	5 %
Shore A hardness (CQP023-1 / ISO 48-4)	40
Tensile strength (ASTM D412)	1.6 MPa (230 psi)
Elongation at break (ASTM D412)	600 %
Service temperature (CQP513-1)	-50 – 90 °C (-58 – 194 °F)
Shelf life	Cartridges / unipacks 9 months ^B Drums / pails 6 months ^B

CQP = Corporate Quality Procedure

A) 23 °C (73 °F) / 50 % r. h

B) storage below 25 °C (77 °F)

DESCRIPTION

Sikaflex®-227 US is a 1-component polyurethane sealant that cures on exposure to atmospheric moisture. It adheres well to a wide variety of substrates like metals, metal primers and paint coatings (2-component systems), ceramic materials and plastics.

PRODUCT BENEFITS

- Very good application properties, overhead work possible.
- Fast skinning time
- Can be painted, sanded
- Bonds well to a wide variety of substrates
- Resistant to aging
- Low odor

AREAS OF APPLICATION

Sikaflex®-227 US is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound damping measures in trailers, recreational vehicles, metal buildings, and HVAC units. Suitable substrates are metal primers and paint coatings (2-c systems), metals, painted plastics and plastics. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-227 US 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.

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Version 03.01 (04 - 2023), en_US

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CURE MECHANISM

Sikaflex®-227 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).

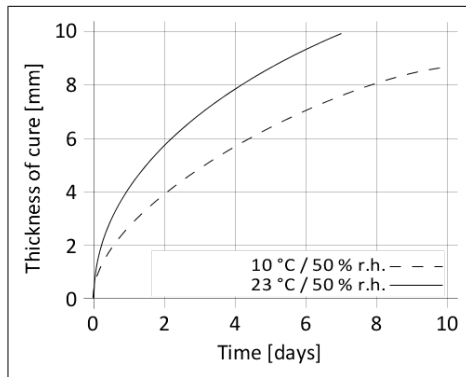


Diagram 1: Curing speed Sikaflex®-227 US

CHEMICAL RESISTANCE

Sikaflex®-227 US 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 and dust.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-227 US can be processed between 5 °C and 35 °C (41 °F and 95 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and process material is between 15 °C and 25 °C (59 °F and 77 °F). Sikaflex®-227 US can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment.

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 skin time of the product. It is recommended using Sika® Slick. Other finishing agents must be tested for suitability and compatibility prior the use.

Removal

Uncured Sikaflex®-227 US 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 a suitable industrial hand cleaner and water.

Do not use solvents on skin.

Overpainting

Sikaflex®-227 US can be painted after formation of a skin. If the paint requires a baking process, best performance is achieved by allowing the sealant to fully cure first. 1C-PUR and 2C-acrylic based paints are usually suitable. 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
- Sika Pre-treatment Chart For 1-component Polyurethane
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Pail	4.5 gal
Drum	50 gal

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.

ENVIRONMENTAL, HEALTH AND SAFETY

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

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or 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 label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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