

Sikaflex®-515

Isocyanate Free Multi Purpose Sealant

Technical Data

Chemical base		Silane Terminated Polymer
Color (CQP001-1)		White, light grey
Cure mechanism		Moisture-curing
Density (uncured)	depending on color	1.5 kg/l.
Non-sag properties		Good
Application temperature	ambient	5 - 40°C
Skin Time (CQP 019-1)		25 minutes ^A
Curing speed (CQP 049-1)		(see diagram)
Shrinkage (CQP 014-1)		3%
Shore A-hardness (CQP 023-1 / ISO 868)		25
Tensile strength (CQP 036-1 / ISO 37)		1.1 MPa
Elongation at break (CQP 036-1 / ISO 37)		300%
Tear propagation resistance (CQP 045-1 / ISO 34)		5.0 N/mm
Service Temperature (CQP 513-1)	4 hours	-50 - 90°C° 120°C
Shelf life (CQP 016-1)	cartridge / unipack pail / drum	12 months ^B 9 months ^B

CQP = Corporate Quality Procedures ^A 23°C (73°F) / 50% r.h. ^B Storage below 25°C

Product Description

Sikaflex®-515 is a 1-component Silane Terminated Polymer (STP) sealant that cures on exposure to atmospheric humidity. It is a universal sealant for indoor and outdoor applications.

Product Benefits

- Fast skinning
- Bonds well to a wide variety of substrates without the need for special pre-treatment
- Excellent workability
- Can be overpainted
- Low odour
- Isocyanate- and solvent-free
- Silicone- and PVC-free

Areas of Application

Sikaflex®-515 is a universal sealant which is suitable for most industrial sealing applications. The product possesses excellent sealing properties for inside and outside applications. Sikaflex®-515 bonds well to materials commonly used in the commercial vehicle industry, e.g. metals, ABS, PC, FRP and wood. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-515 on materials prone to stress cracking. 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.

Industry



Cure Mechanism

Sikaflex®-515 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).

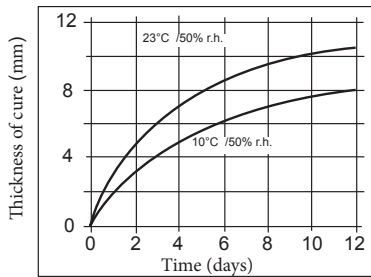


Diagram 1: Curing speed of Sikaflex®-515

Chemical Resistance

Sikaflex®-515 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®-515 can be processed 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.

Sikaflex®-515 can be processed with hand, 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 sealant. It is recommended using Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior the use.

Removal

Uncured Sikaflex®-515 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 have to be washed immediately using Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water. Do not use solvents on skin!

Overpainting

Sikaflex®-515 can be overpainted within the skin formation time. 2 component epoxy paints are usually suitable. Other paints must be tested for compatibility by carrying out preliminary trials under manufacturing conditions. The elasticity of paints is usually lower than of elastomers what could lead to cracking of the paint film 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 Silane Terminated Polymer
- General Guidelines Bonding and Sealing with Sikaflex® and SikaTack®

Packaging Information

Unipack	600 ml
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Value Bases

All technical data stated in this Product Data Sheet 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.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use 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.



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