

## PRODUCT DATA SHEET

# Sikaflex®-227 Tube

One component polyurethane car body sealant

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Chemical base	1-component polyurethane
Colour (CQP001-1)	Black, white
Cure mechanism	Moisture-curing
Density (uncured)	depending on colour 1.23 kg/l
Non-sag properties	Good
Application temperature	ambient 5 - 40 °C
Skin time (CQP019-1)	35 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	15 %
Shore A hardness (CQP023-1 / ISO 48-4)	35
Tensile strength (CQP036-1 / ISO 527)	1.8 MPa
Elongation at break (CQP036-1 / ISO 527)	700 %
Tear propagation resistance (CQP045-1 / ISO 34)	7.5 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)	1 MPa
Service temperature (CQP513-1)	- 40 - 90 °C
Shelf life	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r. h.

B) storage below 25 °C

**DESCRIPTION**

Sikaflex®-227 Tube is a high quality multi-purpose non-sag 1-component polyurethane sealant, and exclusively for crash body repair (CBR), which is used to create a continuous, bonding seal on interior and exterior automotive body joints and is suitable for making permanent elastic seals of high adhesive strength.

**PRODUCT BENEFITS**

- Polyurethane technology
- Easy to use
- Can be over painted
- Can be sanded
- Non-corrosive
- Low odour
- Elastic
- Bonds well to a wide variety of substrates

**AREAS OF APPLICATION**

Sikaflex®-227 Tube bonds well to materials commonly used in body shops, e.g. metals, metal primers and paint coatings (2-c systems), and plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-227 Tube on materials prone to stress cracking.

This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

## CURE MECHANISM

Sikaflex®-227 Tube 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 for Sikaflex®-227 Tube

## CHEMICAL RESISTANCE

Sikaflex®-227 Tube is resistant to fresh water, seawater, limewater, sewage effluent, diluted acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids 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 Pre-treatment Chart.

Advice on specific applications is available from the Technical Service Department of Sika Industry.

### Application

Pierce the membrane, cut off the tip of the nozzle to suit joint width and squeeze the tube to extrude the sealant into the joint, taking care to avoid air entrapment. Once opened packs should be used up within a relatively short time.

Do not apply at temperatures below 5°C or above 40°C. The optimum temperature for substrate and sealant is between 15°C and 25°C.

## Tooling and finishing

Sikaflex®-227 Tube can be tooled and finished with a paint brush or spatula. Tooling and finishing must be carried out within the open time of the sealant. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for suitability and compatibility.

## Removal

Uncured Sikaflex®-227 Tube 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 Sika® Cleaner-350H Towel or a suitable industrial hand cleaner and water. Do not use solvents!

## Overpainting

Sikaflex®-227 Tube can be over painted 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. Oil based paints are not suitable. All paints have to be tested by carrying preliminary trials under manufacturing conditions. The elasticity of paints is lower than of polyurethanes. This could lead to cracking of the paint film in the joint area.

## FURTHER INFORMATION

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart
- General guidelines for bonding and sealing with Sikaflex® products

## PACKAGING INFORMATION

Tube	150 ml
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## 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.

## 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.

## DISCLAIMER

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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