

## PRODUCT DATA SHEET

## Sikaflex®-227

## 1-COMPONENT FAST SKINNING SEALANT

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

Chemical base	1-component polyurethane
Color (CQP001-1)	Black, grey, white
Cure mechanism	Moisture-curing
Density (uncured)	depending on color 1.3 kg/l
Non-sag properties	Good
Application temperature	ambient 5 – 35 °C
Skin time (CQP019-1)	40 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	5 %
Shore A hardness (CQP023-1 / ISO 7619-1)	40
Tensile strength (CQP036-1 / ISO 527)	1.7 MPa
Elongation at break (CQP036-1 / ISO 37)	600 %
Tear propagation resistance (CQP045-1 / ISO 34)	6 N/mm
Service temperature (CQP513-1)	-50 – 90 °C
Shelf life (CQP016-1)	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C / 50 % r. h.<sup>B</sup>) storage below 25 °C**DESCRIPTION**

Sikaflex®-227 is a 1-component polyurethane sealant designed for car body sealing. It adheres well to a wide variety of substrates and cures on exposure to atmospheric moisture.

**PRODUCT BENEFITS**

- Excellent application properties, overhead work possible.
- Fast skinning time
- Can be painted, sanded
- Bonds well to a wide variety of substrates
- Resistant to ageing
- Silicon free
- Low odor

**AREAS OF APPLICATION**

Sikaflex®-227 is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound dampening measures in collision repair and vehicle body construction. 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 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.

## 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 1).

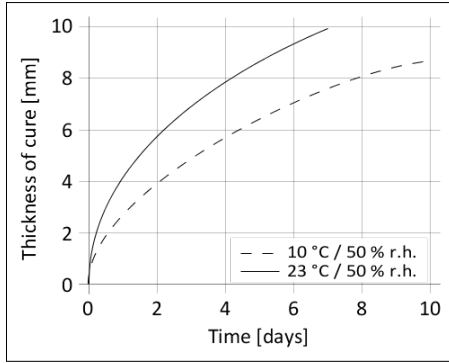


Diagram 1: Curing speed for Sikaflex®-227

## CHEMICAL RESISTANCE

Sikaflex®-227 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 can be processed between 5 °C and 35 °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®-227 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 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®-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. 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®-227 can be best painted after formation of a skin. Painting could be improved by treating the joint surface with Sika® Aktivator-100 or Sika® Aktivator-205 prior to paint process. If the paint requires a baking process (> 80 °C), best performance is achieved by allowing the sealant to fully cure first. 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  
Polyurethane
- General Guidelines  
Bonding and Sealing with 1-component  
Sikaflex®

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	400 ml 600 ml
Pail	23 l
Drum	195 l

## 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

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