

PRODUCT DATA SHEET

Sikaflex®-950

Two component STP adhesive sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Sikaflex®-950 A	Sikaflex®-950 B
Chemical base	2-component silane terminated polymer (STP)	
Color (CQP001-1)	White	Grey
	mixed	
	Grey	
Density (uncured)	1.3 kg/l	1.6 kg/l
	mixed, calculated	
	1.5 kg/l	
Mixing ratio	A:B by volume 1:1	
	A:B by weight 1:1.2	
Non-sag properties (CQP061-1)	Fair	
Application temperature	5 – 40 °C	
Open time (CQP526-1)	30 minutes ^A	
Curing speed (CQP046-1)	See table 1	
Shore A hardness (CQP023-1 / ISO 48-4)	35	
Tensile strength (CQP036-1 / ISO 527)	2.0 MPa	
Elongation at break (CQP036-1 / ISO 37)	500 %	
Tensile lap-shear strength (CQP046-1 / ISO 4587)	1.2 MPa	
Service temperature (CQP513-1)	-50 °C – 80 °C	
Shelf life (CQP016-1)	12 months ^B	
Mixer	Cartridges Quadro MFQ 10-24T	
	Pails / Drums Statomix® MS 13-18-G	

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.^{B)} stored below 25 °C

DESCRIPTION

Sikaflex®-950 is a 2-component Silane Terminated Polymer (STP) adhesive sealant which cures by chemical reaction of the two components. It is well suited for bonding larger surfaces and where pumping over long distances is required.

PRODUCT BENEFITS

- Excellent pumpability
- Bonds well to a wide variety of substrates without the need for special pre-treatment
- Meets highest EHS standards
- Low assembly forces yet good non-sag properties
- Very low emission
- Isocyanate, solvent, PVC and phthalate free
- Meets EC1+ classification

AREAS OF APPLICATION

Sikaflex®-950 is suitable for bonding large components due to its good compressibility and since it is pumpable over long distances. Suitable substrate materials include metals, particularly aluminum (incl. anodized), steel (incl. phosphated, chromated, zinc plated), metal primers and paint coatings (2-component systems), XPS/EPS, ceramic materials, composites and plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-950 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.

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CURE MECHANISM

The curing of Sikaflex®-950 takes place by chemical reaction of the two components. Information regarding strength build-up can be seen in the table below.

Time [h]	Strength [MPa]
2	0.2
4	0.4
6	0.6

Table 1: Lap shear strength (CQP 046-1) at 23 °C / 50 % r.h.

CHEMICAL RESISTANCE

Sikaflex®-950 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. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application

Sikaflex®-950 need to be processed with an adequate dispensing system. The mixer type needs to be respected (see table Typical Product Data). Sikaflex®-950 can be applied 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.

The open time is significantly shorter in hot and humid climate. The parts must always be joint within the open time.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured Sikaflex®-950 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 hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin.

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

PACKAGING INFORMATION

Sikaflex®-950

Dual Cartridge (A+B)	400 ml
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Sikaflex®-950 A

Pail	23 l
Drum	195 l

Sikaflex®-950 B

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

The information, and, in particular, the recommendations relating to the application and enduse 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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Sika South Africa (Pty) Ltd
9 Hocking Place,
Westmead, 3608
Phone: +27 31 792 6500
www.sika.co.za

