

PRODUCT DATA SHEET

Sikaflex® Fillet

Polyurethane fillet joint sealant

DESCRIPTION

Sikaflex® Fillet is a one-component, fast curing, flexible fillet joint sealant for use in professional waterproofing applications.

USES

Sikaflex®-Fillet Joint is ideally suited to, and forms part of, Sika's waterproofing system. Sikaflex® Fillet is designed for use as a fillet joint for movement junctions (wall to wall, wall to floor) in waterproofing installations.

CHARACTERISTICS / ADVANTAGES

- One-component, ready to use
- Permanent flexible
- Non Corrosive
- Very good adhesion to many substrates
- Excellent workability
- High tear resistance

PRODUCT INFORMATION

Composition	Polyurethane
Packaging	600ml Sausages (20 sausages per box)
Shelf life	12 months from the date of production if the storage conditions are met.
Storage conditions	Must be stored in original, undamaged, sealed container in dry conditions protected from direct sunlight and at temperatures between +10°C and +25°C.
Colour	Concrete Grey
Density	~1.3 kg/l
Movement capability	±10%
Joint design	<p>The joint width must be designed to suit the movement capability of the sealant. In general the joint width must be greater than 10 mm and less than 35 mm. A width to depth ratio of 2 : 1 must be maintained for joints over 12mm wide with a minimum depth of 8mm.</p> <p>All joints must be properly designed and dimensioned by the specifier and the main contractor in accordance with the relevant standards.</p> <p>Backing: Depending on application closed cell, polyethylene foam backing rods or open cell foam backing rod must be used.</p>
Ambient air temperature	+5°C to +35°C

Substrate temperature	+5°C to +35°C
Curing rate	~3-4mm per 24 hours (+23°C & 50% relative humidity)
Skimming time	~40 minutes (+23°C & 50% relative humidity)

BASIS OF PRODUCT DATA

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.

FURTHER INFORMATION

- Safety Data Sheet (SDS)

IMPORTANT CONSIDERATIONS

- Elastic sealants may not be over painted with rigid or less flexible coatings.
- Compatibility testing of proposed coatings must be undertaken to ensure suitability.
- If there is no history of a particular coating/paint being applied over cured Sikaflex® Fillet for a period of six months or more, an overpaintability test should be made to determine:
 - That the paint dries properly within the expected time frame.
 - That if the paint film dries satisfactorily it is not subsequently softened and/or stained where it comes into contact with the Sikaflex® Fillet when exposed to the heat of the sun.
 - That the adhesion of the paint/coating is satisfactory.
- Colour deviations may occur due to exposure to chemicals, high temperatures, UV-radiation. However a change in colour will not adversely influence the technical performance or the durability of the product.
- Do not use Sikaflex® Fillet as a glass sealer, on bituminous substrates, natural rubber, EPDM rubber or on building materials which might bleed oils, plasticizers or solvents which could attack the sealant.
- Sikaflex® Fillet should be used with care resealing joints that were previously filled with silicone sealant. Consult our Technical Department.
- Do not use Sikaflex® Fillet to seal swimming pools.
- Only use in well ventilated areas
- Do not mix with or expose uncured Sikaflex® Fillet to substances that may react with isocyanates, especially alcohols which are often components within e.g. thinners, solvents, cleaning agents and formwork releasing compounds. Such contact could interfere or prevent the cross linking curing reaction of the material.
- Epoxy resin coatings should be fully cured prior to the application of the adhesive / sealant as the uncured amine component could inhibit the cure of polyurethane adhesives / sealants.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) con-

taining physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. Sikaflex® Fillet adheres without primers and/or activators. However, for optimum adhesion and critical, high performance applications, such as on multi-story buildings, highly stressed joints, extreme weather exposure or water immersion, the following priming and/or pretreatment procedures shall be followed:

Non-porous substrates

Aluminium, anodised aluminium, stainless steel, galvanised steel, powder coated metals or glazed tiles have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. Before sealing, allow a flash-off time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, also have to be cleaned and pre-treated using Sika® Aktivator-205, wiped on with a clean towel. After the necessary flash-off time, use a brush to apply Sika® Primer-3 N and allow a further flash-off time of > 30 minutes (< 8 hours) before sealing the joints. PVC has to be cleaned and pre-treated using Sika® Primer-215 applied with a brush. Before sealing, allow a flash-off time of > 30 minutes (< 8 hours).

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks shall be primed using Sika® Primer-3 N applied with a brush. Before sealing, allow a flash-off time of > 30 minutes (< 8 hours). For more detailed advice and instructions please contact the local Sika Technical Services Department.

Note: Primers are adhesion promoters. They are neither a substitute for the correct cleaning of a surface, nor do they improve the strength of the surface significantly.

APPLICATION METHOD / TOOLS

Sikaflex® Fillet is supplied ready to use. After the necessary substrate preparation, insert a suitable backing rod to the required depth and apply any primer if necessary. Insert a foil pack into the sealant gun and extrude Sikaflex® Fillet into the joint making sure that it comes into full contact with the sides of the joint and avoids any air entrapment. Sikaflex® Fillet sealant must be firmly tooled against the joint sides to ensure adequate adhesion. It is recommended to use masking tape where exact joint lines or neat lines are required. Remove the tape within the skin time. Use a compatible tooling agent (e.g. Sika® Tooling Agent N) to smooth the joint surfaces. Do not use

tooling products containing solvents.

CLEANING OF EQUIPMENT

Clean all tools and application equipment with Sika® Remover-208 immediately after use. Hardened / cured material can only be mechanically removed.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product 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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