

PRODUCT DATA SHEET

Sika® Hybriflex® 40

A high modulus, one component, hybrid based adhesive

PRODUCT DESCRIPTION

Sika® Hybriflex® 40 is a high modulus, one component, hybrid based adhesive which adheres strongly to most substrates. Provides excellent mechanical resistance, resistance to most common chemicals and solvents and can be overpainted when cured.

USES

- Bonding metal panels and trim.
- Bonding in container fabrication.
- Suitable for construction and engineering.

CHARACTERISTICS / ADVANTAGES

- Excellent chemical resistance.
- Excellent resistance to solvents when cured.
- Bonds to concrete, wood, metal, aluminium, polyester, glass, uPVC, stone, ceramics, etc.
- Over paintable with water based gloss and emulsion paints - preliminary test required before use.
- Moisture cure.

APPROVALS / STANDARDS

EN15651-1:2012 type F-EXT-INT-CC Class F20HM.

PRODUCT INFORMATION

Chemical Base	STP
Packaging	295 ml Cartridges
Colour	Grey
Shelf Life	12 months from date of manufacture
Storage Conditions	Store in cool dry conditions between + 5 °C and + 25 °C
Density	1.40 - 1.50 g/cm ³

TECHNICAL INFORMATION

Shore A Hardness	50 ± 5
Shrinkage	< 5 % (ISO 10563)
Elastic Recovery	> 60 %
Movement Capability	± 20 %
Chemical Resistance	Resistance to Acids / Bases / Solvents: Average. Mild acids / bases at < 10 % concentration
Service Temperature	-40 °C to +90 °C

Joint Design

Joint depth should never exceed width. Where joint depth does exceed width, the user should use Fix & Fill Expanding Foam or Joint Backer Rod. Ensure that the joint design only permits adhesion to two surfaces, as three-sided adhesion will impair flexibility.

Joint Calculation

Joint widths are calculated according to BS6213:

$$\text{Width} = \frac{M \times 100}{F} + M$$

Where M = movement and F = movement accommodation factor

APPLICATION INFORMATION

Consumption	Joint Size in mm	Litre per Metre Run	Metre per 295 ml Tube
	5 x 5	0.025	12
	5 x 10	0.050	6
	10 x 10	10 0.1	3
	15 x 10	0.15	2
	20 x 10	0.2	1.5

Ambient Air Temperature	+5 °C to +30 °C
Curing Rate	2 mm per 24 hours (+23 °C and 50 % RH)
Skin Time	20 - 40 mins (+20 °C and 50 % RH)

VALUE BASE

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LIMITATIONS

It is the user's responsibility to determine suitability for use. If in doubt, please contact Technical Services Department for advice.

- Not for use on substrates that may bleed oils, solvents or plasticisers.
- Do not use on bitumen or asphalt.
- Do not use for potable water tanks.
- Yellowing can occur in predominantly dark conditions.
- In areas of high UV some darkening/ discolouration may occur. This does not affect product performance.
- Staining from plasticiser migration may occur when used on cast, reconstituted or natural stone such as granite, marble or limestone substrates. Customers should test a sample prior to application.

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) containing physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

All surfaces must be clean, dry and dust free. All loose or flaking surface coatings, and old sealant and mastic joints, should be removed before application. Glass, metal and aluminium should be cleaned with a proprietary solvent cleaner prior to application for optimum adhesion. When using solvents, always ensure adequate ventilation. Avoid heat, sparks and open flames. Observe and follow all precautions listed on the solvent container label. It is not recommended for application to surfaces that are below +5 °C as it is impossible to guarantee a dry, frost-free surface at these temperatures.

Priming

- On porous substrates like concrete use Sika® Primer 3N.
- On non-porous if needed use silicone Sika® Aktivator 205.
- Metals – Priming not always necessary.

APPLICATION METHOD / TOOLS

Tool down within 15 minutes, clean tools and any excess adhesive with white spirit or Sika® Wonder Wipes.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

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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Product Data Sheet
Sika® Hybriflex® 40
December 2024,
Version 01.01
02051302000000105

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SikaHybriflex40-en-GBEVER-(12-2024)-1-1.pdf