

## 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) |                      |
| Colour (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 <sup>A</sup>                     |                      |
| 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 527)         | 500 %                                       |                      |
| Tensile lap-shear strength (CQP046-1 / ISO 4587) | 1.2 MPa                                     |                      |
| Service temperature (CQP513-1)                   | -50 °C – 80 °C                              |                      |
| Shelf life                                       | 12 months <sup>B</sup>                      |                      |
| Mixer  | Cartridges                                  | Quadro MFQ 10-24T    |
|  | Pails / Drums                               | Statomix® MS 13-18-G |

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r. h.<sup>B)</sup> 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 adhesive sealant is between 15 °C and 25 °C.

The open time is significantly shorter in hot and humid climate. The parts must always be joined together 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 |
|----------------------|--------|

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

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## DISCLAIMER

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