

Sikaflex[®]-298 FC

Slightly thixotropic bedding compound for marine applications

Technical Product Data

Chemical base	1-C polyurethane	
Color (CQP ¹ 001-1)	Black	
Cure mechanism	Moisture-curing	
Density (uncured) (CQP006-4)	1.2 kg/l approx.	
Non-sag properties	Slightly thixotropic	
Application temperature	10 - 35 °C (50 – 95 °F)	
Skin time ² (CQP019-1)	50 min. approx.	
Curing speed (CQP049-1)	(see diagram 1)	
Shrinkage (CQP014-1)	6 % approx.	
Shore A hardness (CQP023-1 / ISO 868)	25 approx.	
Tensile strength (CQP036-1 / ISO 37)	1.2 N/mm ² approx.	
Elongation at break (CQP036-1 / ISO 37)	400 % approx.	
Tear propagation resistance (CQP045-1 / ISO 34)	4 N/mm	
Glass transition temperature (CQP509-1 / ISO 4663)	-45 °C approx.	
Service temperature (CQP513-1)	-40 - 90 °C (105 – 195 °F)	
Shelf life (storage below 25 °C) (CQP016-1)	unipack	12 months
	pail	9 months

¹⁾ CQP = Corporate Quality Procedures²⁾ 23 °C (73 °F) / 50 % r.h.**Description**

Sikaflex[®]-298 FC is a slightly thixotropic 1-component polyurethane adhesive and sealant which cures on exposure to atmospheric humidity to form a durable elastomer. Sikaflex[®]-298 is manufactured in accordance with ISO 9001 / 14001 quality assurance system as well as with the Responsible Care Program and meets the regulations set out by the International Maritime Organization (IMO).

Product Benefits

- 1-C formulation
- Slightly thixotropic
- Elastic behaviour
- Contains no highly inflammable solvents
- Sound deadening
- Fast skin formation

Areas of Application

Sikaflex[®]-298 FC is suitable for bonding deck covering materials made from synthetic resins (except polyethylene and polypropylene), and for bedding-in of teak plank decking laid on top of the sub deck surface. Suitable substrates include GRP, marine plywood, steel, aluminum sealed with an anti-corrosion coating (epoxy or polyurethane-acrylic based) and stainless steel.

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®-298 FC cures by reaction with atmospheric moisture, which may be drawn from the surrounding air, from porous substrates or from spraying with a fine water mist (approx. 10 g of water per m² of bond face).

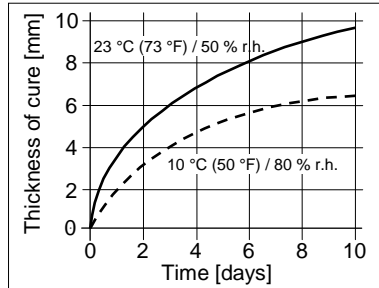


Diagram 1: Curing speed Sikaflex®-298 FC

Chemical Resistance

Sikaflex®-298 FC is resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, animal fats and oils; Sikaflex®-298 FC is not resistant to organic acids and caustic solutions or paint thinners.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. As a rule surfaces must be prepared in accordance with the instructions given in the current edition of the Sika® Pre-treatment Chart for Marine Applications

Advice on specific applications is available from the Technical Department of Sika Industry.

Application

Cut off the tip of the nozzle to suit the application and apply the adhesive with a suitable hand-operated or compressed-air gun.

Do not apply at temperatures below 10 °C or above 35 °C. The optimum temperature for substrate and adhesive is between 15 °C and 25 °C.

The adhesive is applied over large surface areas with a notched spreader (notch depth approx. 4 mm). Coverage is approximately 1200 ml per m². If the substrates to be bonded are impervious to moisture or if an accelerated rate of cure is required, the adhesive could be lightly sprayed with a water mist shortly before the substrates are brought together (use an aerosol spray or spray gun to apply approx. 10 g water per m²). Avoid air entrapment when making the bond or filling joints. Apply firm pressure when bringing components together and keep the joint under pressure for at least 3 hours until the adhesive has set.

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

Removal

Uncured Sikaflex®-298 FC can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material only can be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleanser and water. Do not use solvents!

Overpainting

Sikaflex®-298 FC can be over-painted after formation of a skin. In case the paint requires a bake process it may be necessary to wait for a full cure. 1C-PUR and 2C-acrylic based paints are usually suitable. Not suitable are oil based paints. All paints have to be tested by carrying preliminary trials under manufacturing conditions. The elasticity of paints is lower than of polyurethanes. This could lead to cracking of the paint film in the joint area.

Further Information

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart
- General guidelines for bonding and sealing with Sikaflex® products
- Marine Application Guide

Packaging Information

Unipack	600 ml
Pail	10 l

Important

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.

Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:
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