BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-521 FC

Transparent sealant, with very good weathering resistancet

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Hybrid
Color (CQP001-1)	Transparent
Cure mechanism	Moisture-curing
Density (uncured)	1.06 kg/l
Non-sag properties	Good
Application temperature	5 – 40 °C
Skin time (CQP019-1)	30 minutes [A]
Curing speed (CQP049-1)	see diagram
Shore A hardness (CQP023-1 / ISO 48-4)	38
Tensile strength (CQP036-1 / ISO 527)	2.2 MPa
Elongation at break (CQP036-1 / ISO 527)	250 %
Tear propagation resistance (CQP045-1 / ISO 34)	2 N/mm
Service temperature (CQP513-1)	-40 – 90 °C
Shelf life	18 months [B, C]

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r. h.

B) stored (unopened) in a dry place at ≤ 25 °C

DESCRIPTION

Sikaflex®-521 FC is a transparent, weathering-resistant 1-component sealant, which cures by reaction with atmospheric moisture. After curing, the sealant forms a permanant elastic joint.

PRODUCT BENEFITS

- Transparent
- Good weathering resistance
- None corrosive
- Low odor
- Isocyanate free

AREAS OF APPLICATION

Sikaflex®-521 FC adheres well to a wide variety of substrates and is suitable for elastic sealing and bonding. Suitable substrate materials include timber, metals, metal primers and paint coatings and ceramic materials.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-521 FC on materials prone to stress cracking. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

Sikaflex®-521 FC cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

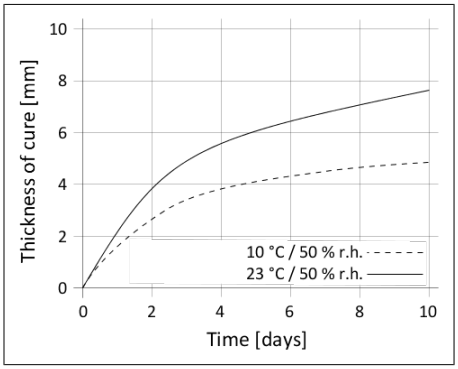

Diagram 1: Curing speed Sikaflex®-521 FC

CHEMICAL RESISTANCE

Sikaflex®-521 FC 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, dust and contaminants.
Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-521 FC can be processed between 5 °C and 40 °C (climate and product) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and process material is between 15 °C and 25 °C.
Sikaflex®-521 FC can be processed with manual, pneumatic or electric driven piston guns.

Tooling and finishing

Tooling and finishing must be carried out within the skin time of the product. It is recommended using Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior the use.

Removal

Uncured Sikaflex®-521 FC may 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 Sheet
- Sika Pre-treatment Chart
  For Silane Terminated Polymers
- General Guideline
  Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	290 ml
Unipack	600 ml
Hobbock	27 kg
Drum	207 kg

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

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