

PRODUCT DATA SHEET

Sikaflex[®]-1A

Elastomeric joint sealant / adhesive

DESCRIPTION

Sikaflex[®]-1A is a 1-part, polyurethane, coloured, moisture curing non-sag elastomeric sealant. Movement capability $\pm 35\%$. Internal and external use.

USES

Sealing joints for:

- Movement and connections
- Facade elements
- Vertical and horizontal applications
- Window and door frames
- Reglets
- Flashing
- Common roofing detailing
- Canal and reservoir submerged joints.

Adhesive for:

- Most construction components and materials

CHARACTERISTICS / ADVANTAGES

- 1-part no mixing equipment required
- Fast tack-free and final cure times
- High elasticity and flexibility
- Good cut and tear resistance
- Low stress on substrate
- Good adhesion to many construction materials
- Primerless for most substrates and applications
- Resistant to weathering and ageing

PRODUCT INFORMATION

Chemical Base

Polyurethane

Packaging

10 fl. oz. cartridge, 12 cartridges per box
 20 fl. oz. foil pack, 20 foil packs per box
 5 gallon pail
 55 gallon drum
 Refer to current price list for packaging variations

- Suitable for use in most global conditions
- Can be applied to green concrete 24 hours after pour
- Can be applied to damp concrete 1 hour after getting wet
- Low VOC emissions
- Resistant to jet fuel exposure
- Certified to the NSF/ANSI Standard 61 for potable water
- Urethane-based, suggested by EPA for radon reduction
- Over-paintable with oil and rubber based paints
- Movement capability $\pm 35\%$ (ASTM C 719)

ENVIRONMENTAL INFORMATION

- [Add local certificates here](#)

APPROVALS / STANDARDS

- Certified to NSF/ANSI standard 61 for portable water
- [Add local approvals / certificates here](#)

Colour	Colour range to be defined by local sales organisation.	
Shelf Life	Cartridges and foil packs: 12 months from date of production Pails and drums: 6 months from date of production	
Storage Conditions	The product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +41 °F and +77 °F (+5 °C and +25 °C). Always refer to packaging.	
Density	~1,45 kg/l (95 lbs/ft ³)	(ISO 1183-1)

TECHNICAL INFORMATION

Shore A Hardness	~40 (after 21 days) ~40 (after 28 days)	(ASTM C 661) (ISO 868)												
Secant Tensile Modulus	~0,55 N/mm ² (80 psi) at 60 % elongation (23 °C) ~0,90 N/mm ² (131 psi) at 60 % elongation (-20 °C)	(ISO 8339)												
Tensile stress at specified elongation	<table border="1"> <tr> <td>25 %</td> <td>~35 psi (0,24 N/mm²)</td> </tr> <tr> <td>50 %</td> <td>~60 psi (0,41 N/mm²)</td> </tr> <tr> <td>100 %</td> <td>~85 psi (0,59 N/mm²)</td> </tr> </table>	25 %	~35 psi (0,24 N/mm ²)	50 %	~60 psi (0,41 N/mm ²)	100 %	~85 psi (0,59 N/mm ²)	(ASTM D 412)						
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Elastic Recovery	~90 %	(ISO 7389)												
Elongation at Break	~550 % ~450 %	(ASTM D 412) (ISO 37)												
Adhesion in Peel	<table border="1"> <thead> <tr> <th>Substrate</th> <th>Peel Strength</th> <th>Adhesion loss</th> </tr> </thead> <tbody> <tr> <td>Concrete</td> <td>~20 lbs (~9 kg)</td> <td>0 %</td> </tr> <tr> <td>Aluminium</td> <td>~20 lbs (~9 kg)</td> <td>0 %</td> </tr> <tr> <td>Glass</td> <td>~20 lbs (~9 kg)</td> <td>0 %</td> </tr> </tbody> </table>	Substrate	Peel Strength	Adhesion loss	Concrete	~20 lbs (~9 kg)	0 %	Aluminium	~20 lbs (~9 kg)	0 %	Glass	~20 lbs (~9 kg)	0 %	(ASTM C 794)
Substrate	Peel Strength	Adhesion loss												
Concrete	~20 lbs (~9 kg)	0 %												
Aluminium	~20 lbs (~9 kg)	0 %												
Glass	~20 lbs (~9 kg)	0 %												
Tear Strength	~55 lbs./in. (~10 N/ mm)	(ASTM D 624)												
Movement Capability	±35 % ±25 %	(ASTM C 719) (ISO 9047)												
Chemical Resistance	Resistant to many chemicals. Contact Sika Technical Services for additional information													
Resistance to Weathering	0 (no cracks)	(ASTM C 793)												
Service Temperature	-40 °F to +170 °F (-40 °C to +77 °C)													

Joint Design

The joint dimensions must be designed to suit the movement capability of the sealant. The joint width must be $\geq 6,0$ mm ($\frac{1}{4}$ inch) and ≤ 40 mm ($1\frac{1}{2}$ inch). The joint depth must be $\geq 6,0$ mm ($\frac{1}{4}$ inch) and ≤ 12 mm ($\frac{1}{2}$ inch). For joints in facades a width to depth ratio of 2:1 must be maintained (for exceptions, see table below). For floor joints a width to depth ratio of 1:0.8 must be maintained. For use in horizontal joints in traffic areas, the absolute minimum depth of the sealant is 12 mm ($\frac{1}{2}$ inch).

Standard joint widths for joints between concrete facade elements:

Convert table below to imperial units if required.

Standard joint widths for joints between concrete facade elements:

Joint distance	Min. joint width	Min. joint depth
m	mm	mm
2	10	10
4	15	10
6	20	10
8	28	14
10	35	17

The above information is for guidance only. All joints must be correctly designed and dimensioned in accordance with the relevant national stand-

ards and codes of practice before their construction. The basis for calculation of the necessary joint widths are the type of structure, dimensions, technical values of the adjacent building materials, joint sealing material and the specific exposure of the building and the joints.

APPLICATION INFORMATION

Consumption	Joint width	Joint depth	Joint length
	mm	mm	m per sausage (600 ml)
	10	10	6
	15	10	4
	20	10	3
	25	12	2
	30	15	1,3
	Joint width	Joint depth	Joint length
	mm	mm	m per cartridge (300 ml)
	10	10	3
	15	10	2
	20	10	1,5
	25	12	1
	30	15	0,65
	Joint width	Joint depth	Joint length
	inch	inch	ft per sausage (20 fl.oz.)
	$\frac{1}{2}$	$\frac{1}{4}$	24,4
	$\frac{3}{4}$	$\frac{3}{8}$	5,4
	1	$\frac{1}{2}$	3
	$1\frac{1}{2}$	$\frac{3}{4}$	1,4
	Joint width	Joint depth	Joint length
	inch	inch	ft per cartridge (10 fl.oz.)
	$\frac{1}{2}$	$\frac{1}{4}$	12,2
	$\frac{3}{4}$	$\frac{3}{8}$	5,4
	1	$\frac{1}{2}$	3
	$1\frac{1}{2}$	$\frac{3}{4}$	1,4
	Joint width	Joint depth	Joint length
	inch	inch	ft per gallon
	$\frac{1}{2}$	$\frac{1}{4}$	154
	$\frac{3}{4}$	$\frac{3}{8}$	68,4
	1	$\frac{1}{2}$	38,5
	$1\frac{1}{2}$	$\frac{3}{4}$	17,1

Joint width inches	Joint depth inches	Joint length ft per gallon
1/4	1/4	308
3/8	1/4	205
3/8	3/8	137
1/2	1/4	154
1/2	3/8	102
1/2	1/2	77
3/4	1/4	103
3/4	3/8	68
3/4	1/2	51
1	1/2	39
1 1/4	1/2	31
1 1/2	1/2	26

Consumption depends on the roughness and absorbency of the substrate. These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level or wastage etc.

Backing Material	Use closed cell, polyethylene foam backing rods.	
Ambient Air Temperature	+40 °F to +100 °F (+4 °C to +38 °C)	
Substrate Temperature	+40 °F to +100 °F (+4 °C to +38 °C). Min. 5 °F (3 °C) above dew point temperature Sealants must be installed when substrates are at mid-range of their anticipated movement.	
Skin Time	~160 minutes (23 °C / 50 % r.h.)	(CQP 019-1)
Tack Free Time	~160 minutes (23 °C / 50 % r.h.)	(ASTM C 679)

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 DOCUMENTS

- Pre-treatment Sealing and Bonding Chart
- Method Statement: Joint Sealing
- Method Statement: Joint Maintenance, Cleaning and Renovation
- Technical Manual: Facade Sealing

LIMITATIONS

- Allow full curing before using Sikaflex®-1A in total water immersion situations.
- Sikaflex®-1A can be overpainted with most conventional facade coating paint systems. However, paints must first be tested to ensure compatibility by carrying out preliminary trials. The best over-painting results are obtained when the sealant is allowed to fully cure first. Note: non-flexible paint systems may impair the elasticity of the sealant and lead to cracking of the paint film.
- Do not cure in the presence of curing silicones.
- Do not expose uncured Sikaflex®-1A to alcohol containing products as this may interfere with the curing reaction.
- Do not apply when moisture-cured-transmission condition exists from the substrate as this can cause bubbling within the sealant.
- Use opened cartridges and uni-pac sausages the same day.
- Since the system is moisture-cured, permit sufficient exposure to air.
- Color variations may occur due to exposure to chemicals, high temperatures and/or UV-radiation (especially with the colour shade white). However, a change in color is purely of aesthetic nature and does not adversely influence the technical performance or durability of the product.
- The ultimate performance of Sikaflex®-1A depends on good joint design and proper application with joint surfaces properly prepared.
- Do not use Sikaflex®-1A on bituminous substrates,

natural rubber, EPDM rubber or on any building materials which might bleed oils, plasticizers or solvents that could attack the sealant.

- Do not use Sikaflex®-1A on natural stone.
- Do not use Sikaflex®-1A to seal joints in and around swimming pools.

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

SUBSTRATE PREPARATION

The substrate must be sound, clean, dry and free of all contaminants such as dirt, oil, grease, cement laitance, old sealants and poorly bonded paint coatings which could affect adhesion of the sealant. The substrate must be of sufficient strength to resist the stresses induced by the sealant during movement.

Removal techniques such as wire brushing, grinding, grit blasting or other suitable mechanical tools can be used.

Repair all damaged joint edges with suitable Sika repair products

New or refurbished joints must be saw-cut.

Where joints in substrate are saw cut. After sawing, all slurry material, must be flushed away and joint surfaces allowed to dry.

All dust, loose and friable material must be completely removed from all surfaces before application of any activators, primers or sealant.

Sikaflex®-1A adheres without primers and/or activators.

For optimum adhesion, joint durability and critical, high performance applications such as joints on multi-storey buildings, highly stressed joints, extreme weather exposure or water immersion / exposure. The following priming and/or pre-treatment procedures must be followed:

Non-porous substrates

Aluminium, anodised aluminium, stainless steel, PVC, galvanised steel, powder coated metals or glazed tiles. Slightly roughen surface with a fine abrasive pad.

Clean and pre-treat using Sika® Aktivator-205 applied with a clean cloth.

Before sealing, allow a waiting time of > 15 minutes (< 6 hours).

Other metals, such as copper, brass and titanium-zinc, cleaned and pre-treat using Sika® Aktivator-205 applied with a clean cloth. After a waiting time of > 15 minutes (< 6 hours). Apply Sika® Primer-3 N applied by brush. Before sealing, allow a waiting time of > 30 minutes (< 8 hours)

PVC has to be cleaned and pre-treated using Sika® Primer-215 applied with a brush. Before sealing, allow a waiting time of > 30 minutes (< 8 hours).

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks must be primed using Sika® Primer-3 N applied with a brush. Before sealing, allow a waiting time of > 30 minutes (< 8 hours).

Adhesion tests on project specific substrates must be performed and procedures agreed with all parties before full project application. Contact Sika Technical Services for additional information.

Note: Primers and activators are adhesion promoters and not an alternative to improve poor preparation / cleaning of the joint surface. Primers also improve the long term adhesion performance of the sealed joint.

If products mentioned above are not available in local country, replace with the appropriate local products.

For green concrete applications control joints must be cut 8 hours prior to sealant installation. Expansion joint

forms must be removed 4 hours prior to sealant installation. For wet concrete applications all excess or standing water

must be displaced and concrete must then dry for a minimum of 60 minutes prior to sealant installation.

Sikaflex-1a can be applied on green concrete after the concrete has cured for a minimum of 24 hours at +75 °F (+25 °C).

MIXING

1-part ready to use

APPLICATION METHOD / TOOLS

Reference must be made to further documentation where applicable, such as relevant method statement, application manual and installation or working instructions.

Masking

It is recommended to use masking tape where neat or

exact joint lines are required. Remove the tape within the skin time after finishing.

Joint Backing

After the required substrate preparation, insert a suitable backing rod to the required depth.

Priming

If required, prime the joint surfaces as recommended in substrate preparation. Avoid excessive application of primer to avoid causing puddles at the base of the joint.

Application

Sikaflex®-1A is supplied ready to use.

Prepare the end of the foil pack or cartridge, insert into the sealant gun and fit the nozzle. Extrude Sikaflex®-1A into the joint ensuring that it comes into full contact with the sides of the joint and avoiding any air entrapment.

Finishing

As soon as possible after application, sealant must be firmly tooled against the joint sides to ensure adequate adhesion and a smooth finish.

Use a compatible tooling agent (e.g. Sika® Tooling Agent N) to smooth the joint surface. Water can be used. Do not use tooling products containing solvents.

CLEANING OF TOOLS

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

For cleaning skin use Sika® Cleaning Wipes-100.

LOCAL RESTRICTIONS

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

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

Sika Pakistan (Pvt.) Limited

141-CCA Phase IV, DHA

Lahore Punjab 54792

Pakistan

phone: +92 42 3569 4266 - 67

fax: +92 42 3569 4268

<http://pak.sika.com/>

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