

PRODUCT DATA SHEET

# Sikaflex®-298

SLIGHTLY THIXOTROPIC BEDDING COMPOUND FOR MARINE APPLICATIONS

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane
Color (CQP001-1)		Brown
Cure mechanism		Moisture-curing
Density	depending on color	1.2 kg/l
Non-sag properties		Slightly thixotropic
Application temperature	ambient	10 – 35 °C
Skin time (CQP019-1)		100 minutes <sup>A</sup>
Curing speed (CQP049-1)		(see diagram 1)
Shrinkage (CQP014-1)		6 %
Shore A hardness (CQP023-1 / ISO 7619-1)		30
Tensile strength (CQP036-1 / ISO 527)		1.2 MPa
Elongation at break (CQP036-1 / ISO 527)		600 %
Tear propagation resistance (CQP045-1 / ISO 34)		4 N/mm
Service temperature (CQP509-1 / CQP513-1)		-50 – 90 °C
Shelf life (CQP016-1)	unipack	12 months <sup>B</sup>
	pail	9 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup> 23 °C / 50 % r. h.

<sup>B</sup> storage below 25 °C

**DESCRIPTION**

Sikaflex®-298 is a slightly thixotropic 1-component polyurethane adhesive which cures on exposure to atmospheric humidity. It is used for Teak deck bedding.

Sikaflex®-298 meets the regulations set out by the International Maritime Organization (IMO).

**PRODUCT BENEFITS**

- Long open time
- Slightly thixotropic
- Sound deadening properties
- Elastic behavior
- Contains no highly inflammable solvents

**AREAS OF APPLICATION**

Sikaflex®-298 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.

Sikaflex®-298 has a longer skinning time as the Sikaflex®-298 FC version and might be used where elevated temperature and/or higher humidity are expected.

Sikaflex®-298 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

Sikaflex®-298 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).

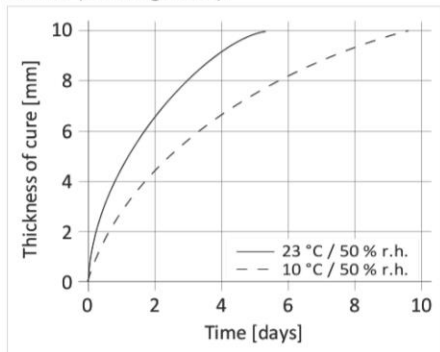


Diagram 1: curing speed Sikaflex®-298

## CHEMICAL RESISTANCE

Sikaflex®-298 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®-298 can be processed between 10 °C and 35 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrates 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). The consumption is approx. 1.2 l per m<sup>2</sup>. 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 joined together (use an aerosol spray or spray gun to apply approx. 10 g water per m<sup>2</sup>). Avoid air entrapment when joining the parts or filling joints. Apply firm pressure when bringing components together and keep the bond under pressure for at least 3 hours until the adhesive has set.

The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

## Removal

Uncured Sikaflex®-298 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
- Sika Pre-treatment Chart  
For Marine Applications
- General Guidelines  
Bonding and Sealing with 1-component  
Sikaflex®
- Marine Application Guide

## PACKAGING INFORMATION

Unipack	600 ml
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## 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

The information, and, in particular, the recommendations relating to the application and enduse 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.