

PRODUCT DATA SHEET

Sikaflex[®]-545

HIGH INITIAL GRAB STP ASSEMBLY ADHESIVE

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Silane Terminated Polymer
Colour (CQP001-1)		White
Cure mechanism		Moisture-curing
Density (uncured)		1.4 kg/l
Non-sag properties (CQP061-1)		Excellent
Application temperature	ambient	5 – 40 °C
Skin time (CQP019-1)		15 minutes ^A
Open time (CQP526-1)		10 minutes ^A
Curing speed (CQP049-1)		(see diagram)
Shore A hardness (CQP023-1 / ISO 7619-1)		45
Tensile strength (CQP036-1 / ISO 527)		2.5 MPa
Elongation at break (CQP036-1 / ISO 527)		400 %
Tear propagation resistance (CQP045-1 / ISO 34)		7 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		1.5 MPa
Service temperature (CQP509-1 / CQP513-1)		-50 – 90 °C
Shelf life (CQP016-1)	Unipack Drum	12 months ^B 9 months ^B

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r.h.^{B)} Storage below 25 °C**DESCRIPTION**

Sikaflex[®]-545 is a very low emission one-component adhesive based on Sika's Silane Terminated Polymer (STP) technology that cures on exposure to atmospheric humidity. Sikaflex[®]-545 is a high initial grab adhesive with high load capacity.

PRODUCT BENEFITS

- Powerful initial grab
- Very low emission
- Isocyanate, solvent, phthalate free
- Bonds well to a wide variety of substrates without the need for special pre-treatments
- Low odour
- Meets highest EHS standards
- EC1 certificate

AREAS OF APPLICATION

Sikaflex[®]-545 adheres well to a wide variety of substrates and is suitable for bonding applications where a high initial grab is required. Suitable substrate materials include timber, glass, metals, metal primers and paint coatings (2-part systems), ceramic materials and plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex[®]-545 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.

PRODUCT DATA SHEETSikaflex[®]-545Version 03.01 (11 - 2019), en_GB
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CURE MECHANISM

Sikaflex®-545 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).

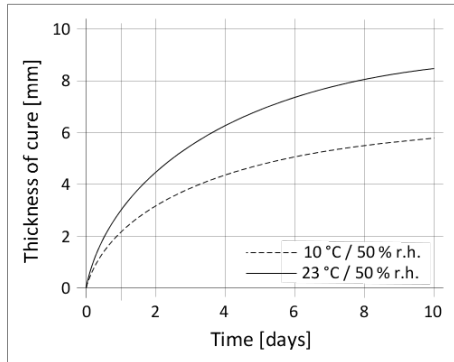


Diagram 1: Curing speed Sikaflex®-545

CHEMICAL RESISTANCE

Sikaflex®-545 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. 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

Apply the adhesive with a suitable caulking gun. Take care to avoid air entrapment in the joint.

Sikaflex®-545 can be processed between 5 °C and 40 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and adhesive is between 15 °C and 25 °C.

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

Tooling and finishing

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

Removal

Uncured Sikaflex®-545 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 cleaning towels 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 application 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 Silane Terminated Polymers (STP)
- General Guideline Bonding Sealing with Sikaflex® and SikaTack®

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 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 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.

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SIKA LIMITED

Watchmead
Welwyn Garden City
Hertfordshire, AL7 1BQ
Tel: 01707 394444
Web: www.sika.co.uk
Twitter: @SikaLimited

