

PRODUCT DATA SHEET

SikaHyflex®-355

HIGH PERFORMANCE WEATHER SEALANT FOR NATURAL STONE APPLICATIONS

**DESCRIPTION**

SikaHyflex®-355 is a 1-component, moisture curing, low-modulus elastic weather sealant.

USES

SikaHyflex®-355 is designed for weather proofing and sealing applications where non-staining and non-streaking properties are required. SikaHyflex®-355 is particularly suited for use as a weather sealant for natural stone and metal cladding facades.

APPROVALS / STANDARDS

- EN 15651-1 F EXT-INT CC 25 LM
- EN 15651-2 G CC 25 LM
- ISO 11600 F 25 LM & G 25 LM
- ASTM C920 class 35
- ISO 16938-1
- ASTM C1248

CHARACTERISTICS / ADVANTAGES

- Non-staining
- Non-streaking
- Very good weathering resistance
- Movement capability of $\pm 35\%$ (ASTM C 719)
- Very good workability
- Low stress to the substrate
- Solvent-free
- Very low emissions

PRODUCT INFORMATION

Chemical base	Neutral cure silicone
Packaging	600 ml foil pack, 20 foil packs per box
Colour	Different colors available
Shelf life	SikaHyflex®-355 has a shelf life of 12 months from the date of production, if it is stored in undamaged, original, sealed packaging, and if the storage conditions are met.
Storage conditions	SikaHyflex®-355 shall be stored in dry conditions, where it is protected from direct sunlight and at temperatures between +5 °C and +25 °C.
Density	~ 1.45 kg/l (ISO 1183-1)

TECHNICAL INFORMATION

Shore A Hardness	~ 25 (after 28 days)	(ISO 868)
Secant Tensile Modulus	~ 0.40 N/mm ² at 100% elongation (23 °C) ~ 0.50 N/mm ² at 100% elongation (-20°C)	(ISO 8339)
Elongation at Break	~ 800%	(ISO 37)
Elastic Recovery	~ 85%	(ISO 7389)
Tear Propagation Resistance	~4.0 N/mm	(ISO 34)
Movement Capability	± 25% ±35%	(ISO 9047) (ASTM C 719)
Resistance to Weathering	10	(ISO / DIS 19862)
Service Temperature	-40 °C to +150 °C	

Joint Design

The joint width must be designed to suit the joint movement required and the movement capability of the sealant. The joint width shall be ≥ 6 mm and ≤ 35 mm. The joint depth shall be ≥ 6 mm and ≤ 15 mm. A width to depth ratio of 2:1 must be maintained (for exceptions, see table below).

Typical joint dimensions

Joint Width [mm]	Joint Depth [mm]
10	6
15	8
20	10
30	15
45	15

All joints must be correctly designed and dimensioned in accordance with the relevant standards, before their construction. The basis for calculation of the necessary joint widths are the type of structure and its dimensions, the technical values of the adjacent building materials and the joint sealing material, as well as the specific exposure of the building and the joints. For larger joints please contact Sika technical service.

SYSTEMS

Compatibility

SikaHyflex®-355 is compatible with most SikaHyflex® and Sikasil® silicone weather sealants. All other sealants and adhesives have to be approved by Sika before using them in direct contact with SikaHyflex®-355. Where two or more different reactive sealants and/or adhesives are used, allow the first one to cure completely before applying the next one. For specific information regarding compatibility contact Sika technical service.

APPLICATION INFORMATION

Consumption	Joint length [m] per 600 ml foil pack	Joint width [mm]	Joint depth [mm]
	10	10	6
	5	15	8
	3	20	10
	2	25	12
	1.3	30	15
Backing Material	Use closed cell, polyethylene foam backing rods.		
Sag Flow	~ 2 mm (20 mm profile, 50 °C)		(ISO 7390)
Ambient Air Temperature	+5 °C to +40 °C, min. 3 °C above dew point temperature		
Substrate Temperature	+5 °C to +40 °C		

Curing Rate	~ 2 mm/24 hours (23 °C / 50% r.h.)	(CQP 049-2)
Skin time	~ 20 minutes (23 °C / 50% r.h.)	(CQP 019-1)

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. The following priming and/or pre-treatment procedures shall be followed:

Non-porous substrates

Float glass, coated glass, anodised aluminium and stainless steel have to be pre-treated using Sika® Aktivator-205, Sika® Aktivator-100 or Sika® Cleaner P. Powder coated and PVDF coated metals have to be pre-treated using Sika® Aktivator-205. For details like application and flash-off times refer to the most recent PDS of the respective pre-treatment product.

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks shall be primed using Sika® Primer-3 N or Sika® Primer-210. For details like application and flash-off times refer to the most recent PDS of the respective pre-treatment product.

Adhesion tests on project specific substrates must be performed prior to application. For more detailed advice and instructions please contact Sika technical service. Note: Primers are adhesion promoters. They are neither a substitute for the correct cleaning of a surface, nor do they improve the strength of the surface significantly.

APPLICATION METHOD / TOOLS

SikaHyflex®-355 is supplied ready to use. After the necessary substrate preparation, insert a suitable backing rod to the required depth and apply pre-treatment if necessary. Insert a foil pack into the sealant gun and extrude SikaHyflex®-355 into the joint making sure that it comes into full contact with the sides of the joint and avoids any air entrapment. SikaHyflex®-355 sealant must be firmly tooled against the joint sides to ensure adequate adhesion. It is recommended to use masking tape where exact joint lines or neat lines are required. Remove the tape within the skin time.

CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208 and/or Sika® Top-Clean T. Once cured, residual material can only be removed mechanically.

FURTHER DOCUMENTS

- Safety Data Sheet (SDS)
- Pre-treatment Chart Sealing & Bonding
- General Guidelines SikaHyflex and Sikasil Weather Sealants

LIMITATIONS

- SikaHyflex®-355 cannot be overpainted.
- Colour variations may occur due to exposure to chemicals or other extreme external influences. However, a change in colour is purely of aesthetic nature and does not adversely influence the technical performance or durability of the product.
- Before using SikaHyflex®-355 on natural stone, please refer to Sika technical service for advice.
- Do not use SikaHyflex®-355 on bituminous substrates, natural rubber or any building materials which might bleed oils, plasticizers or solvents that could attack the sealant. EPDM or other gaskets in direct contact with SikaHyflex®-355 have to be tested for compatibility prior to application. For specific advice contact Sika technical service.
- Do not use SikaHyflex®-355 on pre-stressed polyacrylate and polycarbonate as it may cause environmental stress cracking (crazing).
- Do not use SikaHyflex®-355 to seal joints in and around swimming pools.
- Do not use SikaHyflex®-355 for joints under water pressure or for permanent water immersion.
- Do not expose uncured SikaHyflex®-355 to alcohol containing products as this may interfere with the curing reaction.

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.

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.

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.

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 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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