

# Construction

**Packaging** Disposable 10.3 fl. oz., moisture-proof composite cartridges, 24/case; and uni-pac sausages, 20 fl. oz., 20/carton.

**How to Use**  
**Surface Preparation** Clean all surfaces. Joint walls must be sound, clean, dry, frost-free, and free of oil and grease. Curing compound residues and any other foreign matter must be thoroughly removed. Install bond breaker tape or backer rod to prevent bond at base of joint.

**Priming** Priming is not usually necessary. Most substrates only require priming if testing indicates a need or where sealant will be subjected to water immersion after cure. Consult Sikaflex Primer Technical Data Sheet or Technical Service for additional information on priming.

**Application** Recommended application temperatures: 40°-100°F. For cold weather application, condition units at approximately 70°F; remove prior to using. For best performance, Sikaflex-1a should be gunned into joint when joint slot is at mid-point of its designed expansion and contraction. Place nozzle of gun into bottom of the joint and fill entire joint. Keep the nozzle in the sealant, continue on with a steady flow of sealant preceding the nozzle to avoid air entrapment. Avoid overlapping of sealant to eliminate entrapment of air. Tool as required. Joint dimension should allow for 1/4 inch minimum and 1/2 inch maximum thickness for sealant. Proper design is 2:1 width to depth ratio. For use in horizontal joints in traffic areas, the absolute minimum depth of the sealant is 1/2 in. and closed cell backer rod is recommended. Tool as necessary.

**Limitations**

- Allow 1-week cure at standard conditions when using Sikaflex-1a in total water immersion situations and prior to painting.
- When overcoating with water, oil and rubber based paints, compatibility and adhesion testing is essential.
- Avoid exposure to high levels of chlorine. (Maximum continuous level is 5 ppm of chlorine.)
- Maximum depth of sealant must not exceed 1/2 in.; minimum depth is 1/4 in.
- Maximum expansion and contraction should not exceed 25% of average joint width.
- Do not cure in the presence of curing silicone sealants.
- Avoid contact with alcohol and other solvent cleaners during cure.
- Do not apply when moisture-vapor-transmission condition exists from the substrate as this can cause bubbling within the sealant.
- Use opened cartridges and uni-pac sausages the same day.
- When applying sealant, avoid air-entrapment.
- Since system is moisture-cured, permit sufficient exposure to air.
- White color tends to yellow slightly when exposed to ultraviolet rays.
- Light colors can yellow slightly if exposed to direct gas fired heating elements prior to formation of initial skin.
- The ultimate performance of Sikaflex-1a depends on good joint design and proper application with joint surfaces properly prepared.
- The depth of sealant in horizontal joints subject to traffic is 1/2 in.
- Do not tool with detergent or soap solutions.
- Do not use in contact with bituminous/asphaltic materials without prior adhesion and compatibility testing

**Caution**  
**Irritant** Keep away from open flames and high heat. Contains xylene; avoid breathing vapors. Use with adequate ventilation.

**Combustible** Avoid skin and eye contact. Use of NIOSH approved organic vapor respirator, safe and chemical-resistant gloves recommended. Remove contaminated clothing and shoes.

**First Aid** In case of skin contact, wash thoroughly with soap and water. For eye contact, flush immediately with plenty of water for at least 15 minutes; contact physician. Wash clothing before re-use. Discard contaminated shoes.

**Clean Up** Uncured material can be removed with approved solvent. Cured material can only be removed mechanically. For spillage, collect, absorb, and dispose of in accordance with current, applicable local, state, and federal regulations.

## Linear Feet of Sealant per Gallon

| Inches | Depth |      |      |      |      |     |
|--------|-------|------|------|------|------|-----|
|        | ¼     | ½    | ¾    | 1    | 1¼   | 1½  |
| ¼      | 308.0 |      |      |      |      |     |
| ½      | 154.0 | 77.0 |      |      |      |     |
| ¾      | 102.7 | 51.3 | 34.2 |      |      |     |
| 1      | 77.0  | 38.5 | 25.7 | 19.3 |      |     |
| 1¼     | 61.6  | 30.8 | 20.5 | 15.4 | 12.3 |     |
| 1½     | 51.3  | 25.7 | 17.1 | 12.8 | 10.3 | 8.6 |

Vermont Agency of Transportation

**RECEIVED**

CK'D BY WDL OK'D BY WDL

May 3, 2017

RESUBMIT No Approved

BY RSY DATE 05/10/2017

KEEP CONTAINER TIGHTLY CLOSED  
 NOT FOR INTERNAL CONSUMPTION

KEEP OUT OF REACH OF CHILDREN  
 FOR INDUSTRIAL USE ONLY

CONSULT MATERIAL SAFETY DATA SHEET FOR MORE INFORMATION

Sika warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Technical Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor.

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