Construction

Sikaflex®-68 TF

Elastic 2-component sealant for floor joints

Product Description	**Sikaflex®-68 TF** is an elastic, self levelling PU based 2-component sealant for floor joints. It is suitable for horizontal joints with a slope of max. 3 %.
Fields of application	Floor and connection joints between concrete elements which are exposed to traffic and pedestrian load
Characteristics / Advantages	■ Tar free and nearly odourless ■ Tested according to US Federal Specification SS-S-200 E ■ High chemical resistance (according US federal specification item 4.4.7.) ■ High mechanical resistance (according US federal specification item 4.4.9.)

Tests

Approval / Standards	- Test report according to US Federal Specification SS-S-200 E

Product Data

Colour shade	Black and grey
Packaging	component A 10 kg = 5.9 l component B 1 kg = 0.9 l separately packed
Storage Conditions / Shelf-Life	12 months from the date of production, if stored at temperatures between +10° C and +25°C in original sealed packaging, in dry conditions and protected from direct sunlight.

Technical data

Chemical base	2-component polyurethane polymer
Density	~ 1,6 kg/l
Application time	Minimum 2 h
Curing time	Approx. 24 hours
Total movement capability	25 %
Joint width	10-30 mm in exposed area, depending on the load
Non sag properties	self levelling, can be used with a slope of 3 % (Depending on the temperature)
Service temperature	-40°C up to + 80°C

Mechanical / Physical Properties

Shore A hardness	~ 25 after 28 days DIN 53 505
Tensile strength	0.6 N/mm² approx. DIN EN ISO 527
Elongation at break	500 % approx. DIN EN ISO 527
Elastic recovery	> 80 % DIN EN ISO 7389 B

Resistance

Chemical Resistance	Resistant to water, seawater, diluted alkalis, cement grout , water dispersed detergents and aromatic (hydro-carbons) fuel (according US federal specification SS-S200E) Not resistant to alcohols, organic acids, concentrated alkalis ,concentrated acids and chlorinated

System information

Consumption / joint design

All joints must be properly designed and dimensioned by the specifier and the main contractor in accordance with the relevant standards (e.g. IVD Merkblatt Nr 1). The basis for the calculation of the necessary joint width are the technical values of the joint sealant and the adjacent building materials, plus the exposure of the building, its method of construction and its dimensions.

The joint width must be between 10 and 20 mm, floor joints have to keep a joint width to depth ratio of 1:1 / 1:0,8.

Minimum joint width for movement joints: 10 mm.

Joint design acts in accordance with the general technical guidelines.

Standard joint widths for joints between concrete elements:

Floor joints according to IVD (German Association of Sealant Manufacturers) Data Sheet no. 1
For a temperature differential of 40 °C:

Joint distance in [m]	2,0	3,0	4,0	5,0	6,0	8,0
Min. joint width in [mm]	10	10	10	10	10	15
Thickness of sealant [mm]	10	10	10	10	10	12

For exterior areas max. temperature differential of 80 °C:

Joint distance in [m]	2,0	3,0	4,0	5,0	6,0	8,0
Min. joint width in [mm]	10	12	15	18	20	30
Thickness of sealant [mm]	10	10	12	15	15	25

Consumption approximately:

Joint width in [mm]	10	15	20	25
Joint depth in [mm]	10	12-15	17	20
Joint length/1000 ml in [m]	~10	~5	~3	~2

Surface Preparation / Primer	All bonding areas must be dry, clean and free of loose particles, mortar residues, dust, grease and dirt. Additional for : Porous substrates e.g. concrete: Porous substrates have to be primed with **SikaPrimer-115**. Flash-off time of about 30 minutes to max. 8 hours, depending on the ambient temperature. Non-porous substrates e.g. galvanised steel, stainless steel and cast steel: Pre-treat with abrasive pad and SikaAktivator®-205 by using a clean towel / cloth. Before sealing allow a flash off time of at least 15 min. - max 6 hrs Primers are only adhesion promoters. They neither substitute for the correct cleaning of the surface nor improve their strength significantly. Primers improve long term performance of a sealed joint. Do not use any other Sika primers. Backing: Use only closed cell, polyethylene foam backing rods (e.g. Sika-backing rod PE) or in exceptional cases PE-foil. At chamfered elements it shall not fill the chamfer with sealant.

Application Conditions:

Material Temperature	Mind. +10°C Max. +35°C
Substrate Temperature	Between +5°C and +35°C
Ambient Temperature	Between +5°C and +40°C
Substrate	Clean and dry, homogeneous, free from oils and grease, dust and loose or friable particles. Cement laitance must be removed.

Application Instructions

Mixing ratio by mass	A : B = 100 : 10
Mixing instruction / mixing time	The separately packed B-component has to be given to the component A and stir with slow speed. A perfect mixture is completely homogenous and without stripes. Avoid air traps. (The mixing time shall be 3-5 min. at 300-500 rpm, let it de-aerate before application)
Application methods / tools	Can be directly poured out into joint. Within application time remove adjusted adhesive tape. Remove air bubbles by gently brushing over the surface with a soft flat brush before the sealant is cured.
Note	Do not use **Sikaflex®-68 TF** for joints in swimming pools or in areas that are exposed to strong oxidising acids (e.g. nitric acid) and bases. Sealant shall be cured min. 48 hours at 20°C (material-/floor-temperature) for full capacity. The colour shade can be affected by environmental influences (chemicals, high temperatures, UV-radiation). However a change in colour will not adversely influence the technical performance or the durability of the product. Elastic sealants may not be over painted. Compatible coatings may cover the joint sides to max. 1 mm. The compatibility must be tested according to DIN 52 452-2. Do not use **Sikaflex®-68 TF** as a glass sealer, on bituminous substrates, natural rubber, EPDM rubber or on building materials which might bleed oils or plasticizers which will attack the sealant.

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Value Base

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.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet 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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