

Sikaflex® AT-Connection

The universal construction sealant for window and door perimeter and connection joints

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| Description | Sikaflex AT-Connection is a 1-part, moisture-curing elastic sealant based on a proprietary Hybrid Polyurethane technology. Ideal for window and door connection and perimeter joints between porous and non-porous substrates. Sikaflex AT-Connection is odorless and solvent-free, suitable for both interior and exterior use. Meets ASTM C-920, Type S, Grade NS, Class 25, use NT, G, A & M. |
| Where to Use | ■ Sikaflex AT-Connection meets the requirements for all kinds of connection joints, window and door perimeter joints, facade and metal cladding joints applications as well as construction and expansion joints. Ideal sealant for vinyl windows, doors and fiber cement board (FCB). |
| Advantages | ■ Superior adhesion to vinyl/PVC. ■ Movement capability +/- 25% ■ Silicone-free and paintable ■ Excellent primerless adhesion on porous and non-porous substrates ■ Good UV resistance and color stability, non-yellowing ■ Odorless and solvent-free. ■ Very good workability, (low extrusion force, excellent tooling) ■ High mechanical properties |
| Packaging | 10.1 300 ml. cartridges, 12 pc/box. |

Typical Data (Material and curing conditions @ 73°F (23°C) and 50% R.H.)

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| Shelf Life | 12 months | |
| Storage Conditions | Store in undamaged original sealed containers in dry conditions and protected from direct sunlight at temperatures between 50°-77°F (10°-25°C). | |
| Color | White | |
| Chemical Base | Hybrid Polyurethane technology, moisture-curing | |
| Tack-free Time | ~ 60 minutes [74°F (23°C) / 50% r.h.] | |
| Curing Rate | >2 mm/24 hours [74°F (23°C) / 50% r.h.] Full cure 7-10 days | |
| Movement Capability | +/- 25% | |
| Joint Dimensions | Min. width = ¼ in. (10 mm) max. width = 1¼ in. (35 mm) | |
| Sag Flow | 0 mm, very good. | |
| Service Temperature | -40°-158°F (40°-70°C) | |
| Shore A Hardness | 25 +/-5 after 28 days. | |
| Elongation at Break | ~ 450% [74°F (23°C) / 50% r.h.] (DIN 53504) | |
| Elastic Recovery | > 70% [74°F (23°C) / 50% r.h.] | |
| Adhesion in Peel (ASTM C-794) | | |
| Substrate | Peel Strength | Adhesion Loss |
| Concrete | 13 lbf. | 0% |
| Aluminum | 12 lbf. | 0% |
| Glass | 13 lbf. | 0% |

How to Use

Surface Preparation

Sikaflex AT-Connection has excellent adhesion to most clean, sound substrates. Clean all surfaces. Joint walls must be sound, clean, dry, frost-free, and free of dirt, dust, 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.

Application

Recommended application temperatures: 40°-100°F. For cold weather application, condition at approximately 70°F.

For best performance, Sikaflex AT-Connection 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 sealant to ensure full contact with joint walls and remove air entrapment. 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,

Limitations

- If there is painting of the sealant, surface crazing and higher tackiness as well as slight color variation can occur.
- For correct curing of the sealant, sufficient relative humidity is necessary.
- Before using on natural stone, contact our Technical Service Department at 800-933-7452.
- Do not use Sikaflex AT-Connection as a glass sealer, on bituminous substrates, natural rubber, EPDM rubber or on building materials which might bleed oils, plasticizers or solvents which could attack the sealant.
- Do not use Sikaflex AT-Connection to seal swimming pools.
- Not suitable for joints under water pressure or permanent water immersion.

Substrate Temp. 40°-100°F (5°C min./40°C max.)

Ambient Temp. 40°-100°F (5°C min./40°C max.)

Substrate Humidity Dry

Caution

Irritant

Contains Trimethoxyvinylsilane (CAS 2768-02-7). May cause eye/skin/respiratory irritation. Maybe be harmful if swallowed.

First Aid

Eyes: Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin:** Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation:** Remove person to fresh air. **Ingestion:** Do not induce vomiting. Dilute with water. Contact a physician. **In all cases, contact a physician immediately if symptoms persist.**

Clean Up

Avoid direct contact. Uncured material can be removed from tools and equipment using a suitable solvent. Follow solvent manufacturer's warning and instructions for use. Cured product can only be removed mechanically. Wash thoroughly with soap and water after handling. Do not use solvents! Ventilate area and collect spill. If ventilation is poor, use properly fitted NIOSH respirator. Contain spill and collect with absorbent material. Dispose of excess product and container in accordance with applicable environmental regulations.

KEEP CONTAINER TIGHTLY CLOSED
NOT FOR INTERNAL CONSUMPTION
CONSULT MATERIAL SAFETY DATA SHEET FOR MORE INFORMATION

KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY

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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Visit our website at www.sikaconstruction.com

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Quality Certification Numbers: Lyndhurst: FM 69711 (ISO 9000), FM 70421 (QS 9000), Marion: FM 69715, Kansas City: FM 69107, Santa Fe Springs: FM 69408

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