BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-68 TF

ELASTIC 2-COMPONENT SEALANT FOR FLOOR JOINTS

DESCRIPTION

Sikaflex®-68 TF is an elastic, self-levelling, 2-component sealant.

USES

Sikaflex®-68 TF is designed for floor and connection joints between concrete elements which are exposed to traffic and pedestrian loads. Sikaflex®-68 TF is also designed for application in aprons, hangars and hard stands.

CHARACTERISTICS / ADVANTAGES

- Tar free
- High chemical resistance according to US Federal Specification SS-S-200E
- Self-levelling
- Movement capability ± 25 % (ASTM C 719)

APPROVALS / CERTIFICATES

- Tested according to US Federal Specification SS-S-200E
- ASTM C 920 class 25

PRODUCT INFORMATION

Composition	Polyurethane		
Packaging	Component A 10 kg (5.9 L) Component B 1 kg (0.9 L)		
Colour	Black, grey		
Shelf life	Sikaflex®-68 TF has a shelf life of 12 months from the date of production, if it is stored properly in undamaged, original, sealed packaging, and if the storage conditions are met.		
Storage conditions	Sikaflex®-68 TF shall be stored in dry conditions, protected from direct sunlight and at temperatures between +5 °C and +25 °C.		
Density	Component A: Component B: Mixed:	~1.70 kg/L ~1.10 kg/L ~1.60 kg/L	(ISO 1183-1)

TECHNICAL INFORMATION

Shore A Hardness	After 28 days	~30	(ISO 868)
Tensile Strength	~0.6 N/mm²		(ISO 37)
Elongation at Break	~500 %		(ISO 37)
Elastic Recovery	~80 %		(ISO 7389)

Movement Capability	± 25 %	(ASTM C 719)

Chemical Resistance

Sikaflex®-68 TF is resistant to water, seawater, diluted alkalis, cement slurry and water dispersed detergent.
Sikaflex®-68 TF is not resistant to alcohols, organic acids, concentrated alkalis and concentrated acids.
According to US Federal Specification SS-S-200E, Sikaflex®-68 TF is resistant to diesel and jet fuel.

Service Temperature

−40 °C min. / +70 °C max.

Joint Design

The joint width must be designed to suit the joint movement required and movement capability of the sealant. The joint width shall be ≥ 8 mm and ≤ 40 mm. A width to depth ratio of 1:0.8 shall be maintained with the depth always ≥ 8 mm. The joint shall be recessed below the surface half of the joint width but always ≥ 10 mm (see table below). At chamfered elements, the chamfer shall not be filled with the sealant.

Standard joint dimensions for joints between concrete elements for interior applications:

Joint distance [m]	Min. joint width [mm]	Min. joint depth [mm]	Recessed below surface [mm]
2	8	8	10
4	8	8	10
6	10	8	10
8	15	12	10

Standard joint dimensions for joints between concrete elements for exterior applications:

Joint distance [m]	Min. joint width [mm]	Min. joint depth [mm]	Recessed below surface [mm]
2	10	8	10
4	15	12	10
6	20	15	10
8	30	25	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.

APPLICATION INFORMATION

Mixing Ratio

10 : 1 by mass (component A : component B)

Yield

Joint length per 1 000 ml	Joint width [mm]	Joint depth [mm]
12 m	10	8
5.5 m	15	12
3.3 m	20	15
2.0 m	25	20

Backing Material

Use closed cell polyethylene foam backing rods

Sag Flow

Self-levelling, can be used on slopes < 3 %

Ambient Air Temperature

+5 °C min. / +40 °C max., min. 3 °C above dew point temperature

Substrate Temperature

+5 °C min. / +40 °C max.

Pot Life

~30 minutes (23 °C)

Curing Time

~48 hours in order to reach full mechanical properties

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. Paint, cement laitance and other poorly adhering contaminants must be removed.

Non- porous substrates
Galvanised steel, aluminium, anodised aluminium, stainless steel and cast steel have to be treated with a very fine abrasive pad and Sika® Aktivator-205 shall be applied using a clean towel. Before sealing allow a flash-off time of > 15 minutes.

Porous substrates
Concrete has to be primed with Sika® Primer-206 G+P with a clean brush or roller. Before sealing allow a flash-off time of > 30 minutes (< 8 hours).

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.

MIXING

Add the separately packaged component B to the component A container. Stir at a slow speed (300–500 rpm) for 3–5 minutes with a paddle mixer. Let the mixture deaerate before application.

APPLICATION METHOD / TOOLS

After mixing, the sealant can be applied into the joint using a pump, sealant gun or simple container for pouring by hand. It is important that the joint is filled from the bottom to ensure that the joint is completely filled with minimal voids.

CLEANING OF EQUIPMENT

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 INFORMATION

- Safety Data Sheet
- Pre-treatment Chart Sealing and Bonding

IMPORTANT CONSIDERATIONS

- Sikaflex®-68 TF cannot be overpainted.
- Do not use Sikaflex®-68 TF to seal joints in and around swimming pools.
- Do not use Sikaflex®-68 TF on natural stone.
- Do not use Sikaflex®-68 TF in areas which are exposed to strong oxidising acids (e.g. nitric acid) and bases.
- Do not use Sikaflex®-68 TF as a glass sealer, on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might bleed oils, plasticizers or solvents that could attack the sealant.

BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

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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