

PRODUCT DATA SHEET

Sikaflex®-402 Connection

Low-modulus joint sealant for concrete and masonry facades



DESCRIPTION

Sikaflex®-402 Connection is a 1-part, moisture-curing, silane-terminated polymer sealant. It is used for durably sealing movement and connection joints in concrete and masonry facades.

USES

The Product is used for sealing and weatherproofing joints in the building envelope where reliability and durability is required.

The Product is used for the following application areas:

- Interior or exterior joint sealing
- Around window and door frames
- Around facade elements
- Around precast elements
- Around retaining and partition walls
- Balconies and parapets

FEATURES

- Easy to extrude and tool
- High movement capability: $\pm 25\%$ (ISO 9047)
- Good adhesion to many construction materials
- Very good resistance to weathering
- Phthalate free formulation

PRODUCT INFORMATION

Composition	Silane-terminated polymer	
Packaging	300 ml cartridges	12 cartridges per box
	600 ml cylindrical foil pack	20 foil packs per box
Colour	Please contact customer service for information about which colors are available in Denmark.	

SUSTAINABILITY

- EPD
- VOC emission GEV-Emicode EC1PLUS
- Complies with DGNB 2020 2.0.0 and 2023 1.0.0 Quality level 4 (indicator 11, 12 and 13)
- Complies with all quality levels DGNB 2025 1.0.0 (indicator 11 and 13)
- The product is registered in the database for construction products that can be included in Nordic Ecolabelled construction both indoors and outdoors.
- The product is declared in the Nordic Ecolabelling Supply Chain Declaration Portal
- The product complies with EU Taxonomy - Annex C (DNSH 5.1)
- The product complies with VOC EU Taxonomy DNSH 5.2

CERTIFICATES AND TEST REPORTS

- CE marking and declaration of performance based on EN 15651-1:2012 Sealants for non-structural use in joints in buildings and pedestrian walkways — Part 1: Sealants for facade elements

Shelf life	12 months from date of production	
Storage conditions	The Product must be stored in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5 °C and +30 °C. Always refer to packaging. Refer to the current Safety Data Sheet for information on safe handling and storage.	
Density	(1.25 ± 0.1) kg/l	(ISO 1183-1)
Product declaration	EN 15651-1:2012 ISO 11600:2002	F EXT-INT CC 25 LM Class F 25 LM

TECHNICAL INFORMATION

Shore A hardness	Cured 28 days at +23 °C and 50 % R.H.	16	(EN ISO 868)
Secant tensile modulus	Cured 28 days at +23 °C and 50% R.H. Measured at 100% elongation at +23 °C	0.4 N/mm ²	(ISO 8339)
	Cured 28 days at +23 °C and 50% R.H. Measured at 100% elongation at -20°C	0.5 N/mm ²	
Elastic recovery	Cured 28 days at +23 °C and 50 % R.H. Measured at 100 % elongation for 24 hours	70 %	(EN ISO 7389)
Tear propagation resistance	Cured 7 days at +23 °C and 50 % R.H.	4.0 N/mm	(ISO 34-2)
Movement capability	± 25 %		(ISO 9047)
Resistance to weathering	8 out of 10		(ISO 19862)
Service temperature	Maximum	+70 °C	
	Minimum	-40 °C	
Joint design	For movement joints, the width must be at least 8 mm and should not exceed 40 mm. For non-movement joints such as connection joints in interior areas, the joint width can be less than 8 mm. The joint dimensions must be designed to suit the movement capability of the sealant. In all cases joints must be at least 8 mm deep or have a width to depth ratio of 2 : 1 whichever is greater. For more information about joint design and calculations refer to the Sika document Design guideline: Dimensioning of construction joints or contact Sika Technical Services.		
Elongation at break	Cured 7 days at +23 °C and 50 % R.H. Measured at 100 % elongation at -20 °C	500 %	(ISO 37)

APPLICATION INFORMATION

Sag flow	20 mm profile tested at +50 °C	0 mm	(EN ISO 7390)
Material temperature	Maximum	+40 °C	
	Minimum	+5 °C	

Ambient air temperature	Maximum	+40 °C	
	Minimum	+5 °C	
Substrate temperature	Maximum	+40 °C	
	Minimum	+5 °C	
Beware of condensation. Substrate temperature during application must be at least +3 °C above dew point.			
Curing rate	At +23 °C and 50 % R.H.	2 mm / 24 h	(CQP049-2)
Skinning time	At +23 °C and 50 % R.H.	60 minutes	(CQP019-1)
Tooling time	At +23 °C and 50 % R.H.	50 minutes	(CQP019-2)

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.

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.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

IMPORTANT

Poor adhesion due to inadequate surface preparation
Primers are adhesion promoters.

1. Do not use primers for improving poorly prepared or poorly cleaned joint surfaces.

IMPORTANT

Poor adhesion due to incorrect priming procedure
Incorrectly defined or uncontrolled priming procedures may lead to a variation in Product performance.

1. Test adhesion on project-specific substrates and agree on procedures with all parties before full project application. For more information contact Sika Technical Services.

The substrate must be sound, clean, dry and free of contaminants such as dirt, oil, grease, cement laitance, sealant residues and poorly bonded coatings which could affect adhesion of the primer and sealant.

The substrate must be of sufficient strength to cope with the stresses induced by the sealant during movement.

1. Use techniques such as wire brushing, grinding, grit blasting or other suitable mechanical methods to remove all weak substrate material.
2. Repair all damaged joint edges with suitable Sika repair products.
3. Remove dust, loose and friable material from all surfaces before applying the sealant.

If tested or supported by experience, the Product can be used without primers or activators on many sub-

strates.

Use the following priming or pre-treatment procedures to ensure optimum adhesion and joint durability, or if the Product is used for high-performance applications such as joints on multi-storey buildings, highly stressed joints, or joints exposed to extreme weather.

NON-POROUS SUBSTRATES

Aluminium, anodised aluminium, stainless steel, galvanised steel or glazed tiles

1. Lightly roughen the surface with a fine abrasive pad.
2. Clean the surface.
3. Pretreat the surface with Sika® Aktivator-205 applied with a clean cloth.

Other metals, such as copper, brass and titanium-zinc

1. Lightly roughen the surface with a fine abrasive pad.
2. Clean the surface.
3. Pretreat the surface with Sika® Aktivator-205 applied with a clean cloth.
4. Wait until the flash-off time is over.
5. Prime the surface with Sika® Primer-3 N applied with a brush.

Powder-coated metals

1. Carry out preliminary trials to verify adhesion. For more information contact Sika Technical Services.

PVC substrates

1. Prime the surface with Sika® Primer-215 applied with a brush.

POROUS SUBSTRATES

Concrete, aerated concrete and cement based renders, mortars and bricks

1. Prime the surface with Sika® Primer-3 N or Sika® Primer-115 applied with a brush.

Concrete that is 2 to 3 days old, or matt wet (surface dry)

1. Prime the surface with Sika® Primer-115 applied with a brush.

APPLICATION

IMPORTANT

Strictly follow installation procedures

Strictly follow installation procedures as defined in Method Statements, application manuals and working instructions which must always be adjusted to the actual site conditions.

IMPORTANT

Staining on natural stone substrates due to plasticiser

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migration

Staining from plasticiser migration may occur when used on cast, reconstituted or natural stone such as granite, marble or limestone substrates.

1. Do not use on natural stone substrates

IMPORTANT

Degradation of sealant due to substrates leaching oil, plasticisers, or solvents

Bitumen, natural rubber or EPDM rubber can leach oils, plasticisers, or solvents that can degrade the sealant and cause the Product to become tacky.

1. Do not use the Product on building materials which leach oils, plasticisers, or solvents.

IMPORTANT

Degradation of sealant due to chemical attack

1. Do not use the Product to seal joints in and around swimming pools containing water treatment agents such as chlorine.

IMPORTANT

Insufficient curing due to exposure to alcohol

Exposure to alcohol during curing may interfere with the curing reaction and cause the Product to remain soft or become tacky.

1. Do not expose the Product to alcohol-containing products during the curing period.

IMPORTANT

Application in confined spaces

Atmospheric moisture is required for the Product to cure.

1. Do not apply the Product in enclosed spaces with limited exchange of air.

Delayed skin formation and curing time due to changing ambient conditions

Note: Changing ambient conditions can affect product performance. Skin formation and curing time can be significantly delayed by low humidity, low temperature and large joint dimensions.

1. (Optional): Apply masking tape where neat or exact joint lines are required.
2. After the required substrate preparation, insert a backing rod to the required depth.
3. Prime the joint surfaces as recommended in substrate preparation. Note Avoid excessive application of the primer.
4. Open the seal on the top of the cartridge or open the end of the foil pack.
5. Fit the nozzle and cut it to the desired bead size.
6. Insert the Product into the application gun.
7. Apply the Product into the joint. Note Avoid air entrapment. Make sure that the Product comes into full contact with the adhesion area of the joint.
8. IMPORTANT Do not use tooling products containing solvents. As soon as possible after application, tool

the Product firmly against the joint sides to ensure adequate adhesion and a smooth finish. Use a compatible tooling agent such as Sika® Tooling Agent N to smooth the joint surface.

9. (Optional): Remove the masking tape within the skin formation time of the Product.

OVERPAINTING THE SEALANT

IMPORTANT

Tacky paint due to plasticiser migration

Paints and sealants or adhesives may contain plasticizers and other substances that migrate and can cause the painted surface to become tacky.

IMPORTANT

Cracking paint due to joint movement

Rigid paint applied on top of a sealant or flexible adhesive may crack when used on joints subject to movement.

The Product can be overpainted with most conventional paint coating systems.

1. Allow the Product to fully cure before overpainting.
2. Before overpainting, carry out preliminary trials to test compatibility of the paint or coating system with the Product in accordance with ISO/TR 20436:2017 – Buildings and civil engineering works — Sealants — Paintability and paint compatibility of sealants.

Colour variation

Note: Colour variation may occur especially with white or other light colour shades. This effect is purely aesthetic and does not adversely influence the technical performance or durability of the Product.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

LEGAL NOTES

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are

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suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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