

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

1. PRODUCT AND COMPANY IDENTIFICATION

Product name : Sikaflex®-321 HCN

Recommended use of the chemical and restrictions on use

Product use : Adhesive

Manufacturer or supplier's details

Company : Sika Korea Ltd.
724, Anseongmatchum-daero
Miyang-myeon
Anseong-si
Gyeonggi-do
Korea

Telephone : +82-31-8056-7777

Emergency telephone number : +82-31-8056-7777

E-mail address : ehs@kr.sika.com

Telefax : +82-31-8056-7788

2. HAZARDS IDENTIFICATION

GHS Classification

Flammable liquids : Category 4

Acute toxicity (Inhalation) : Category 3

Skin corrosion/irritation : Category 2

Serious eye damage/eye irritation : Category 1

Skin sensitisation : Category 1

Carcinogenicity : Category 2

Specific target organ toxicity - single exposure : Category 2

Specific target organ toxicity - repeated exposure : Category 2

Specific target organ toxicity - repeated exposure (Inhalation) : Category 2 (Lungs)

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
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Long-term (chronic) aquatic hazard : Category 2

GHS label elements

Hazard pictograms :



Signal word : Danger

Hazard statements : H227 Combustible liquid.
H315 Causes skin irritation.
H317 May cause an allergic skin reaction.
H318 Causes serious eye damage.
H331 Toxic if inhaled.
H351 Suspected of causing cancer.
H371 May cause damage to organs.
H373 May cause damage to organs through prolonged or repeated exposure.
H373 May cause damage to organs (Lungs) through prolonged or repeated exposure if inhaled.
H411 Toxic to aquatic life with long lasting effects.

Precautionary statements :

Prevention:

P201 Obtain special instructions before use.
P202 Do not handle until all safety precautions have been read and understood.
P210 Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking.
P260 Do not breathe mist or vapours.
P264 Wash skin thoroughly after handling.
P270 Do not eat, drink or smoke when using this product.
P271 Use only outdoors or in a well-ventilated area.
P272 Contaminated work clothing should not be allowed out of the workplace.
P273 Avoid release to the environment.
P280 Wear protective gloves/ protective clothing/ eye protection/ face protection.

Response:

P302 + P352 IF ON SKIN: Wash with plenty of water.
P304 + P340 + P311 IF INHALED: Remove person to fresh air and keep comfortable for breathing. Call a POISON CENTER/ doctor.
P305 + P351 + P338 + P310 IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a POISON CENTER/ doctor.
P308 + P311 IF exposed or concerned: Call a POISON CENTER/ doctor.
P308 + P313 IF exposed or concerned: Get medical advice/

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
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SDS Number (Internal):
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attention.

P321 Specific treatment (see supplemental first aid instructions on this label).

P333 + P313 If skin irritation or rash occurs: Get medical advice/ attention.

P362 + P364 Take off contaminated clothing and wash it before reuse.

P370 + P378 In case of fire: Use dry sand, dry chemical or alcohol-resistant foam to extinguish.

P391 Collect spillage.

Storage:

P403 + P233 Store in a well-ventilated place. Keep container tightly closed.

P405 Store locked up.

Disposal:

P501 Dispose of contents/ container according to waste-related laws

Other hazards which do not result in classification

No data available

3. COMPOSITION/INFORMATION ON INGREDIENTS

Substance / Mixture : Mixture

Components

Chemical name	Common Name	CAS-No.	Concentration (% w/w)
Distillates (petroleum), hydro- treated light	Distillates (petroleum), hydro- treated light	64742-47-8	>= 1 - < 5
calcium oxide	calcium oxide	1305-78-8	>= 1 - < 3
aluminium sulphate	aluminium sulphate	10043-01-3	>= 2.5 - < 3
xylene	xylene	1330-20-7	>= 1 - < 5
1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich	1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich	68515-49-1	>= 1 - < 2.5
ethylbenzene	ethylbenzene	100-41-4	>= 0.1 - < 1
Stoddard solvent	Stoddard solvent	8052-41-3	>= 0.25 - < 1
4,4'-methylenediphenyl diisocyanate	4,4'-methylenediphenyl diiso-	101-68-8	>= 0.1 - < 1

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
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SDS Number (Internal):
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4,4'-diaminodiphenylmethane	cyanate 4,4'-diaminodiphenylmethane	101-77-9	0.025 - < 0.1
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4. FIRST AID MEASURES

- General advice : Move out of dangerous area.
Consult a physician.
Show this safety data sheet to the doctor in attendance.
- In case of eye contact : Small amounts splashed into eyes can cause irreversible tissue damage and blindness.
In the case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
Continue rinsing eyes during transport to hospital.
Remove contact lenses.
Keep eye wide open while rinsing.
- In case of skin contact : Take off contaminated clothing and shoes immediately.
Wash off with soap and plenty of water.
If symptoms persist, call a physician.
- If inhaled : Move to fresh air.
Consult a physician after significant exposure.
- If swallowed : Clean mouth with water and drink afterwards plenty of water.
Do not give milk or alcoholic beverages.
Never give anything by mouth to an unconscious person.
- Most important symptoms and effects, both acute and delayed : Excessive lachrymation
See Section 11 for more detailed information on health effects and symptoms.
irritant effects
carcinogenic effects
Causes skin irritation.
May cause an allergic skin reaction.
Causes serious eye damage.
Toxic if inhaled.
Suspected of causing cancer.
May cause damage to organs.
May cause damage to organs through prolonged or repeated exposure.
- Notes to physician : Treat symptomatically.

5. FIREFIGHTING MEASURES

Suitable and unsuitable extinguishing media

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version 4.0	Revision Date: 26.06.2025	SDS Number (Internal): 000000610631	Date of last issue: 22.08.2023 Date of first issue: 22.12.2015
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Suitable extinguishing media : Carbon dioxide (CO₂)

Unsuitable extinguishing media : Water

Hazardous combustion products : No hazardous combustion products are known

Specific extinguishing methods : Standard procedure for chemical fires.

Special protective equipment for firefighters : In the event of fire, wear self-contained breathing apparatus.

6. ACCIDENTAL RELEASE MEASURES

Personal precautions, protective equipment and emergency procedures : Use personal protective equipment.
Deny access to unprotected persons.

Environmental precautions : Do not flush into surface water or sanitary sewer system.
If the product contaminates rivers and lakes or drains inform respective authorities.

Methods and materials for containment and cleaning up : Soak up with inert absorbent material (e.g. sand, silica gel, acid binder, universal binder, sawdust).
Keep in suitable, closed containers for disposal.

7. HANDLING AND STORAGE

Advice on protection against fire and explosion : Normal measures for preventive fire protection.

Advice on safe handling : Avoid exceeding the given occupational exposure limits (see section 8).
Do not get in eyes, on skin, or on clothing.
For personal protection see section 8.
Smoking, eating and drinking should be prohibited in the application area.
Follow standard hygiene measures when handling chemical products

Conditions for safe storage : Prevent unauthorized access.
Store in original container.
Keep in a well-ventilated place.
Observe label precautions.
Store in accordance with local regulations.

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
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8. EXPOSURE CONTROLS/PERSONAL PROTECTION

Components with workplace control parameters

Components	CAS-No.	Value type (Form of exposure)	Control parameters / Permissible concentration	Basis
Distillates (petroleum), hydro-treated light	64742-47-8	TWA	200 mg/m ³ (total hydrocarbon vapor)	ACGIH
calcium oxide	1305-78-8	TWA	2 mg/m ³	KR OEL
		TWA	2 mg/m ³	ACGIH
xylene	1330-20-7	TWA	100 ppm	KR OEL
		STEL	150 ppm	KR OEL
		TWA	20 ppm	ACGIH
ethylbenzene	100-41-4	TWA	100 ppm	KR OEL
		Further information: Limited evidence of carcinogenicity in humans or animals, which is not sufficiently convincing to place the substance in Category 1		
		STEL	125 ppm	KR OEL
		TWA	20 ppm	ACGIH
Stoddard solvent	8052-41-3	TWA	100 ppm	KR OEL
		Further information: Sufficient evidence of carcinogenicity in test animals or limited evidence of carcinogenicity in both animal and human testing., Substances which should be regarded as if they induce heritable mutations in the germ cells of humans		
		TWA	100 ppm	ACGIH
		TWA	0.005 ppm	KR OEL
4,4'-methylenediphenyl diisocyanate	101-68-8	TWA	0.005 ppm	KR OEL
		Further information: Limited evidence of carcinogenicity in humans or animals, which is not sufficiently convincing to place the substance in Category 1		
		TWA	0.005 ppm	KR PEL
		TWA	0.005 ppm	ACGIH
4,4'-diaminodiphenylmethane	101-77-9	TWA	0.1 ppm	KR OEL
		Further information: Sufficient evidence of carcinogenicity in test animals or limited evidence of carcinogenicity in both animal and human testing., Substances which cause concern for humans owing to the possibility that they may induce heritable mutations in the germ cells of humans, Substances designated by 'Skin' may be absorbed into the bloodstream through the skin, mucous membrane and eye and contribute to the overall effect. (Skin notation does not apply to the skin irritant)		
		TWA	0.1 ppm	ACGIH

Other ingredients, which are listed in section 3 but not listed in this section, do not have established occupational exposure limit values.

Biological occupational exposure limits

Components	CAS-No.	Control parameters	Biological specimen	Sampling time	Permissible concentration	Basis
xylene	1330-20-7	Methylhip-	Urine	End of	1.5 g/g creat-	ACGIH

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
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		puric acids		shift (As soon as possible after exposure ceases)	inine	BEI
ethylbenzene	100-41-4	Sum of mandelic acid and phenyl glyoxylic acid	Urine	End of shift (As soon as possible after exposure ceases)	0.15 mg/g creatinine	ACGIH BEI

Personal protective equipment. Among the following personal protective equipment, the PPEs which require safety certification need to be certified by KOSHA.

- Respiratory protection : Use respiratory protection unless adequate local exhaust ventilation is provided or exposure assessment demonstrates that exposures are within recommended exposure guidelines. The filter class for the respirator must be suitable for the maximum expected contaminant concentration (gas/vapour/aerosol/particulates) that may arise when handling the product. If this concentration is exceeded, self-contained breathing apparatus must be used.
- Eye protection : Safety eyewear complying with an approved standard should be used when a risk assessment indicates this is necessary.
- Hand protection : Chemical-resistant, impervious gloves complying with an approved standard should be worn at all times when handling chemical products if a risk assessment indicates this is necessary.
- Skin and body protection : Choose body protection in relation to its type, to the concentration and amount of dangerous substances, and to the specific work-place.
- Hygiene measures : Handle in accordance with good industrial hygiene and safety practice.
When using do not eat or drink.
When using do not smoke.
Wash hands before breaks and at the end of workday.

9. PHYSICAL AND CHEMICAL PROPERTIES

- Appearance : paste
- Colour : grey, white
- Odour : characteristic
- Odour Threshold : No data available

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
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Date of last issue: 22.08.2023
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pH : No data available

Melting point/ range / Freezing point : No data available

Boiling point/boiling range : No data available

Flash point : 62 °C (144 °F)
(Method: closed cup)

Evaporation rate : No data available

Flammability (solid, gas) : No data available

Upper/lower flammability or explosive limits

Upper explosion limit / Upper flammability limit : No data available

Lower explosion limit / Lower flammability limit : No data available

Vapour pressure : 0.01 hPa

Solubility(ies)

Water solubility : No data available

Solubility in other solvents : No data available

Density : 1.22 g/cm³ (20 °C)

Partition coefficient: n-octanol/water : No data available

Auto-ignition temperature : No data available

Decomposition temperature : No data available

Viscosity

Viscosity, dynamic : No data available

Viscosity, kinematic : Not applicable

Explosive properties : No data available

Oxidizing properties : No data available

10. STABILITY AND REACTIVITY

Chemical stability and possibility of hazardous reactions : Reactivity:
No dangerous reaction known under conditions of normal use.
Chemical stability:
The product is chemically stable.

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

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26.06.2025

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Date of first issue: 22.12.2015

Possibility of hazardous reactions:
No hazards to be specially mentioned.

Conditions to avoid : No data available
Incompatible materials : No data available
Hazardous decomposition products : No hazardous decomposition products are known.

11. TOXICOLOGICAL INFORMATION

Information on likely routes of exposure : No data available

Health hazard information

Acute toxicity

Toxic if inhaled.

Components:

xylene:

Acute oral toxicity : LD50 Oral (Rat): 3,523 mg/kg

ethylbenzene:

Acute oral toxicity : LD50 Oral (Rat): 3,500 mg/kg

Acute dermal toxicity : LD50 Dermal (Rabbit): 5,510 mg/kg

4,4'-methylenediphenyl diisocyanate:

Acute oral toxicity : LD50 Oral (Rat): > 5,000 mg/kg
Method: OECD Test Guideline 401

Acute inhalation toxicity : LC50: 1.5 mg/l
Exposure time: 4 h
Test atmosphere: dust/mist
Method: Expert judgement

Skin corrosion/irritation

Causes skin irritation.

Serious eye damage/eye irritation

Causes serious eye damage.

Respiratory or skin sensitisation

Respiratory sensitisation

No data available

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

Skin sensitisation

May cause an allergic skin reaction.

Carcinogenicity

Suspected of causing cancer.

Components:

Distillates (petroleum), hydro- treated light:

No data available

calcium oxide:

No data available

aluminium sulphate:

No data available

xylene:

No data available

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

No data available

ethylbenzene:

Suspected of causing cancer.

Stoddard solvent:

No data available

4,4'-methylenediphenyl diisocyanate:

Suspected of causing cancer.

4,4'-diaminodiphenylmethane:

May cause cancer.

Germ cell mutagenicity

No data available

Components:

Distillates (petroleum), hydro- treated light:

No data available

calcium oxide:

No data available

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
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aluminium sulphate:

No data available

xylene:

No data available

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

No data available

ethylbenzene:

No data available

Stoddard solvent:

No data available

4,4'-methylenediphenyl diisocyanate:

No data available

Genotoxicity in vivo : Species: Bacteria
Method: OECD Test Guideline 471
Result: negative

Method: TA98

Method: TA100

Method: TA1535

Method: TA1537

4,4'-diaminodiphenylmethane:

Suspected of causing genetic defects.

Reproductive toxicity

No data available

Components:

Distillates (petroleum), hydro- treated light:

No data available

calcium oxide:

No data available

aluminium sulphate:

No data available

SAFETY DATA SHEET

Sikaflex®-321 HCN



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4.0

Revision Date:
26.06.2025

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000000610631

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xylene:

No data available

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

Suspected of damaging fertility or the unborn child.

ethylbenzene:

No data available

Stoddard solvent:

No data available

4,4'-methylenediphenyl diisocyanate:

No data available

4,4'-diaminodiphenylmethane:

No data available

STOT - single exposure

May cause damage to organs.

STOT - repeated exposure

May cause damage to organs through prolonged or repeated exposure.

May cause damage to organs (Lungs) through prolonged or repeated exposure if inhaled.

Repeated dose toxicity

No data available

Aspiration toxicity

No data available

Experience with human exposure

No data available

Toxicology, Metabolism, Distribution

No data available

Neurological effects

No data available

Further information

No data available

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

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000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

12. ECOLOGICAL INFORMATION

Ecotoxicity

Components:

xylene:

Toxicity to fish (Chronic toxicity) : NOEC (Oncorhynchus mykiss (rainbow trout)): > 1.3 mg/l
Exposure time: 56 d

Toxicity to daphnia and other aquatic invertebrates (Chronic toxicity) : NOEC (Daphnia (water flea)): 1.17 mg/l
Exposure time: 7 d

Persistence and degradability

No data available

Bioaccumulative potential

No data available

Mobility in soil

No data available

Other adverse effects

Product:

Additional ecological information : There is no data available for this product.

13. DISPOSAL CONSIDERATIONS

Disposal methods

Waste from residues : Send to a licensed waste management company.

Do not contaminate ponds, waterways or ditches with chemical or used container.

Contaminated packaging : Empty remaining contents.
Dispose of as unused product.

Do not re-use empty containers.
Do not burn, or use a cutting torch on, the empty drum.

Disposal precautions

Dispose of contents and container according to wastes control act.

14. TRANSPORT INFORMATION

International Regulations

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

UNRTDG

Not regulated as a dangerous good

UN number : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
Environmentally hazardous : no

IATA-DGR

Not regulated as a dangerous good

UN/ID No. : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
Packing instruction (cargo aircraft) : Not applicable
Packing instruction (passenger aircraft) : Not applicable

IMDG-Code

Not regulated as a dangerous good

UN number : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
EmS Code : Not applicable
Marine pollutant : no

Transport in bulk according to Annex II of MARPOL 73/78 and the IBC Code

Not applicable for product as supplied.

National Regulations

Refer to section 15 for specific national regulation.

Special precautions for user

Not applicable

15. REGULATORY INFORMATION

National regulatory information

Regulation under the Occupational Safety and Health Act

Harmful Substances Prohibited from Manufacturing

Not applicable

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

Harmful Substances Required Permission for Manufacture

Not applicable

Harmful Agents to be kept below Occupational Exposure Limits

Chemical name	CAS-No.
Titanium dioxide	13463-67-7
Calcium oxide	1305-78-8
Xylene (all isomers)	1330-20-7
Ethyl benzene	100-41-4
Stoddard solvent	8052-41-3
Methylene bisphenyl isocyanate	101-68-8
4,4'-Methylene dianiline	101-77-9

Harmful Agents Required to be kept below Permission Levels

Chemical name	CAS-No.
Methylene bis(phenyl isocyanate)	101-68-8

Hazardous substances requiring management

Chemical name	CAS-No.	Threshold limits (%)
Titanium dioxide	13463-67-7	>= 1 %

Special Management Materials

Chemical name	CAS-No.	Threshold limits (%)
Stoddard solvent	8052-41-3	>= 0.1 %

Controlled Substances Subject to Environment Monitoring

Chemical name	CAS-No.	Threshold limits (%)
Titanium dioxide	13463-67-7	>= 1 %
Xylene	1330-20-7	>= 1 %

Controlled Substances Subject to Health Examination

Chemical name	CAS-No.	Threshold limits (%)
Xylene	1330-20-7	>= 1 %

Hazardous Substances Subject to Process Safety Management (PSM) Reporting Obligation

Not applicable

K-OSHA Hazardous Substances (Occupational Safety and Health Regulations, Table 1)

Category
Flammable liquid
Corrosive substances
Acute toxic substances (inhalation)

K-OSHA Hazardous Substances (Occupational Safety and Health Regulations, Table 9)

Category	Manufacturing or handling quantity
Flammable liquid	1000 litre
Corrosive substances	300 kilogram
Acute toxic substances (inhalation)	5 kilogram

Regulation under the Chemicals Control Act

Toxic Chemicals

Not applicable

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

Restricted Chemicals

Not applicable

Prohibited Chemicals

Not applicable

Toxic Release Inventory

Chemical name	CAS-No.	Group	Threshold limits (%)
Xylene (o-,m-,p- isomer mixture)	1330-20-7	Group II	>= 1 %
Ethylbenzene	100-41-4	Group II	>= 0.1 %

Accident Precaution Chemicals

Not applicable

Dangerous Substances Safety Management Act

Not Applicable to Dangerous Materials

International Chemical Weapons Convention (CWC) : Not applicable

Schedules of Toxic Chemicals and Precursors

라. Wastes Control Act

Industrial general wastes

Follow article 13 of the act to dispose the product waste

마. Other requirements in domestic and other countries

The components of this product are reported in the following inventories:

ENCS : Not in compliance with the inventory

ISHL : Not in compliance with the inventory

KECI : Not in compliance with the inventory

16. OTHER INFORMATION

Issuing date : 22.12.2015

Revision number and date

Number of Revision : 4.0

Revision Date : 26.06.2025

Date format : yyyy/mm/dd

SAFETY DATA SHEET

Sikaflex®-321 HCN



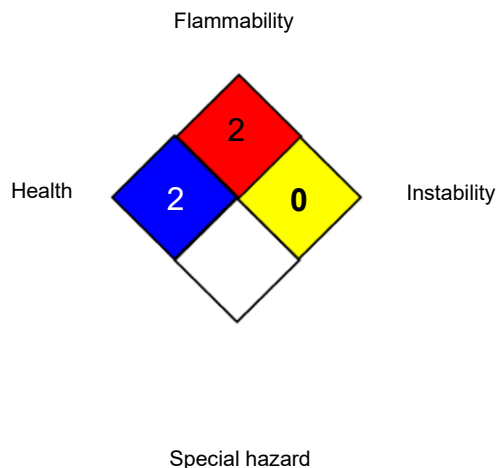
Version
4.0

Revision Date:
26.06.2025

SDS Number (Internal):
000000610631

Date of last issue: 22.08.2023
Date of first issue: 22.12.2015

NFPA:



Full text of other abbreviations

ACGIH	:	USA. ACGIH Threshold Limit Values (TLV)
ACGIH BEI	:	ACGIH - Biological Exposure Indices (BEI)
KR OEL	:	Harmful Agents to be kept below Occupational Exposure Limits
KR PEL	:	Harmful Agents Required to be kept below Permission Levels
ACGIH / TWA	:	8-hour, time-weighted average
KR OEL / TWA	:	Time Weighted Average
KR OEL / STEL	:	Short Term Exposure Limit
KR PEL / TWA	:	TWA
ADR	:	European Agreement concerning the International Carriage of Dangerous Goods by Road
CAS	:	Chemical Abstracts Service
DNEL	:	Derived no-effect level
EC50	:	Half maximal effective concentration
GHS	:	Globally Harmonized System
IATA	:	International Air Transport Association
IMDG	:	International Maritime Code for Dangerous Goods
LD50	:	Median lethal dose (the amount of a material, given all at once, which causes the death of 50% (one half) of a group of test animals)
LC50	:	Median lethal concentration (concentrations of the chemical in air that kills 50% of the test animals during the observation period)
MARPOL	:	International Convention for the Prevention of Pollution from Ships, 1973 as modified by the Protocol of 1978
OEL	:	Occupational Exposure Limit
PBT	:	Persistent, bioaccumulative and toxic
PNEC	:	Predicted no effect concentration
REACH	:	Regulation (EC) No 1907/2006 of the European Parliament and of the Council of 18 December 2006 concerning the Reg-

SAFETY DATA SHEET

Sikaflex®-321 HCN



Version
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SVHC
vPvB

istration, Evaluation, Authorisation and Restriction of Chemicals (REACH), establishing a European Chemicals Agency
: Substances of Very High Concern
: Very persistent and very bioaccumulative

The information contained in this Safety Data Sheet corresponds to our level of knowledge at the time of publication. All warranties are excluded. Our most current General Sales Conditions shall apply. Please consult the product data sheet prior to any use and processing.

KR / EN