BUILDING TRUST

PRODUCT DATA SHEET

SikaSeal®-330

Heat curing seam sealant for high temperature powder coat applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Acrylic Plastisol
Color (CQP001-1)		White
Density		1.41 kg/l (11.8 lb/gal)
Application temperature	ambient	5 – 30 °C (41 – 86 °F)
Non-sag properties		Good
Curing conditions	standard	25 minutes at 200 °C (392 °F) [A]
Shore A hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (ASTM D412)		3 MPa (430 psi)
Elongation at break (ASTM D412)		250 %
Service temperature (CQP513-1)		-25 – 90 °C (-13 – 194 °F)
Shelf life		9 months [B]

CQP = Corporate Quality Procedure

[A] substrate temperature

[B] 23 °C (73 °F) / 50 % r. h.

DESCRIPTION

SikaSeal®-330 is a 1-component, cold-applied heat-curing sealant based on acrylic plastisols. It is a flexible sealant especially designed for sealing metals prior to a powder-coating process.

PRODUCT BENEFITS

- Capable of withstanding baking / curing temperatures up to 230 °C (446 °F)
- Superior compatiblity with many powder coats and powder coating processes
- Bonds well to wide variety of substrates
- Very good application and tooling characteristics

AREAS OF APPLICATION

SikaSeal®-330 is suitable for seam sealing of truck bodies, cabs, and other manufacturing units and cures in the subsequent powder coat baking process. It is suitable for use with e-coated metals as well as treated aluminum and steel. It provides a Class A finish with a variety of powder coat chemistries.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

SikaSeal®-330 is cured by heat. The cure rate depends on temperature and time of exposure. The most suitable heat sources are convection ovens. The minimum bake / cure temperature is 190 °C (374 °F) and the maximum must not exceed 230 °C (446 °F).
It is highly recommended to perform tests with original parts to ensure proper curing and function of the bonded part under original conditions.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust.
Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Adhesion must be verified by tests on original substrates.

Application

SikaSeal®-330 can be processed between 5 °C and 30 °C (41 °F and 86 °F) with manual, pneumatic or electric driven piston guns as well as pump equipment.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Tooling and finishing

If needed, it is best to dry tool the sealant after application without the use of any chemical tooling or finishing agents.
If a chemical tooling or finishing agents is used, it must be tested for suitability and compatibility prior to use.

Removal

Uncured SikaSeal®-330 can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Overpainting

SikaSeal®-330 is suitable for powder coating paint processes and is compatible with very light colors. For best results, the time between powder coat application and curing must be as short as possible.
All paints have to be tested by carrying preliminary trials under manufacturing conditions.

STORAGE CONDITIONS

SikaSeal®-330 has to be kept between 5 °C and 25 °C (41 °F and 77 °F) in a dry place. Do not expose it to direct sunlight.
If SikaSeal®-330 is stored at higher temperatures the shelf life will be reduced.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.
Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Pail	5 gal (US)
Drum	50 gal (US)

BASIS OF PRODUCT DATA

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

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates (“SIKA”), the user must always read and follow the warnings and instructions on the product’s most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA’s Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.
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 Product Data Sheet if used as directed within the product’s shelf life. User determines suitability of product for intended use and assumes all risks. User’s and/or buyer’s sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at https://usa.sika.com/en/group/SikaCorp/termsandconditions.html or by calling +1 800-933-7452.

Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
U.S.A.
Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com