BUILDING TRUST

PRODUCT DATA SHEET

SikaSeal®-710 LS

Expanding Automotive OEM body shop mastic sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Rubber
Color (CQP001-1)		Greige
Density		1.35 kg/l
Application temperature		20 – 40 °C
Curing conditions	standard 180 °C [A]	15 minutes
	minimum 160 °C [A]	10 minutes
	maximum 200 °C [A]	20 minutes
Volumetric expansion		50 % [B]
Tensile lap-shear strength (CQP046-9 / ISO 4587)		0.3 MPa [C]
Shelf life		6 months [D]

CQP = Corporate Quality Procedure

A) metal temperature
B) depends on specimen geometry and bake conditions
C) 2 mm bond line thickness
D) storage below 25 °C

DESCRIPTION

SikaSeal®-710 LS is an expanding Automotive OEM body shop mastic sealant that is PVC-free and is designed for use in body shops for both spot-weld mastic and anti-flutter applications. It shows very good adhesion to standard Automotive OEM body shop substrates and has the ability to meet typical undercutting corrosion resistance requirements.
SikaSeal®-710 LS has been proven to be compatible with many different Automotive OEM phosphate or electro-deposition systems. It can be used in weld-through applications with minimal degradation of the weld strength.

PRODUCT BENEFITS

- Good bond-line read-through resistance on very thin substrates
- Good corrosion resistance
- PVC free
- Can be robotically applied
- Room temperature application, which reduces energy demand

AREAS OF APPLICATION

SikaSeal®-710 LS has good wash off resistance in the uncured state and good adhesion following curing via OEM electrodeposition baking when applied to typical body shop substrates, including those prepared with stampling oils. Typical substrate types include cold-rolled, galvanized, galvannealed steels and some grades of aluminum. Cured SikaSeal®-710 LS has a very low modulus, which minimizes the chances of "read through" on Class A surface.
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®-710 LS is cured by heat. The cure and expansion rate depends on temperature and time of exposure. The most common heat sources are convection ovens.
Do not expose the SikaSeal®-710 LS to a metal temperature of 200 °C for more than 20 minutes.

METHOD OF APPLICATION

SikaSeal®-710 LS is applied as small dollops or in bead form with a recommended diameter of 3 to 10 mm.

Application

The follower plate and the hoses do not necessarily have to be heated. It is recommended to heat the last hose, the dosing unit and the application nozzle to 30 °C +/- 5 °C to favor constant application properties. During longer breaks (e.g. overnight or weekends) suitable standby temperatures and switch-off times must be taken into account.
The time between application and curing must be as short as possible, since moisture uptake could negatively affect the performance of the process material.
SikaSeal®-710 LS can be processed between 20 °C and 40 °C with pump equipment. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured SikaSeal®-710 AT 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.

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

Drum	51 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.
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