BUILDING TRUST

PRODUCT DATA SHEET

SikaSeal®-712

Anti-flutter sealant with optimized bond-line read-through and corrosion resistance

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Rubber
Color (CQP001-1)		Dark grey
Solid content (CQP576-1)		90 %
Density		1.35 kg/l
Application temperature		20 — 40 °C
Viscosity η* (DIN 54458)	flowability A1 at 45 °C pumpability A4 at 45 °C	350 Pa.s [E] 150 Pa·s [F]
Levelling behavior G' (DIN 54458)	A2 at 45 °C	19 000 Pa [E]
Curing conditions	standard 180 °C minimum 160 °C	20 minutes [A] 15 minutes [A]
Volumetric expansion	20 minutes at 180 °C	40 — 60 % [B]
Tensile lap-shear strength (CQP046-9, CQP580-6 / ISO 4587)		0.1 MPa [D]
Shelf life		6 months [C]

CQP = Corporate Quality Procedure
[A] object temperature
[B] depending on sample size and bake conditions
[C] stored at temperatures between 5 °C and 25 °C
[D] 2 mm bond line thickness
[E] static state, deformation 0.05%
[F] dynamic state, deformation 10%

DESCRIPTION

SikaSeal®-712 is a one-part, rubber based, cold pumpable, heat curing anti-flutter adhesive and sealant.
It is designed for sheet metal assembly work in the body shop and is cured with heat, e.g. in the automotive paint shop oven.

PRODUCT BENEFITS

- Good corrosion and wash-off resistance
- Cold pumpable, reducing energy demand
- Medium volume expansion over a broad temperature range
- Good bond-line read-through resistance including thin substrates
- Adheres well to oily substrates
- Can be spot-welded
- Suitable to join different metals
- Distortion-free joining
- PVC free

AREAS OF APPLICATION

SikaSeal®-712 is suitable for anti-flutter and sealing applications on different types of metal and specific plastic materials. It is designed for use in combination with spot-welding, riveting clinching and other mechanical fastening techniques, and in some cases as a partial replacement for them. The bonding of oily substrates (standard anti-corrosion treatment and deep drawing oils, approx. 3 g/m²) is possible because of the oil uptake during the heat curing.
This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

SikaSeal®-712 is cured by heat. The cure- and expansionrate depends on temperature and time of exposure. The most common heat sources are convection ovens. The maximum temperature must not exceed 210 °C for 10 minutes.

METHOD OF APPLICATION

SikaSeal®-712 is typically applied as dots or in bead form with a diameter of 3 to 9 mm.

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 +/- 10 °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. For further advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

The time between application and curing must be as short as possible, since moisture uptake could negatively affect the performance of the process material.

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	260 kg

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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