

## PRODUCT DATA SHEET

# Sikaflex®-510 AM50

Isocyanate free, low modulus sealant

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Chemical base	Silane Terminated Polymer
Color (CQP001-1)	White, black, limestone, off-white, salt box, tan, stone, aluminum gray, redwood tan, medium bronze, special bronze, marshfield
Cure mechanism	Moisture-curing
Density (uncured)	1.5 kg/l
Non-sag properties	Very good
Application temperature	Ambient 5 – 40 °C (41 – 104 °F)
Skin time (CQP019-1)	60 minutes <sup>A</sup>
Curing speed (CQP049-1)	See Diagram 1
Shore A hardness (CQP023-1 / ISO 48-4)	20
Tensile strength (ASTM D412)	0.9 MPa (130 psi)
Elongation at break (ASTM D412)	700 %
Tear propagation resistance (CQP045-1 / ISO 34)	4.8 N/mm (25 pli)
Service temperature (CQP513-1)	-40 – 77 °C (-40 – 170 °F)
Shelf life	12 months <sup>B</sup>

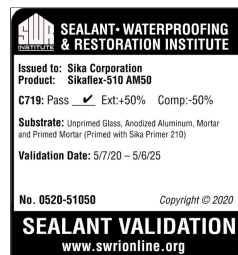
CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C (73 °F) / 50 % r.h.

<sup>B)</sup> Stored below 25 °C (77 °F)

**DESCRIPTION**

Sikaflex®-510 AM50 is a 1-component, high movement Silane Terminated Polymer (STP) sealant that cures on exposure to atmospheric humidity. It is well suited for applications that require both paintability and adhesion to non-porous substrates.


**PRODUCT BENEFITS**

- Meets the requirements of ASTM C-920 for Type S, Grade NS, Class 50, Use A, M, G
- Non-staining in acc. with ASTM C1248
- Meets the requirements of AAMA 808.3
- Good UV and weathering resistance
- Designed for adhesion to porous and non-porous substrates
- Isocyanate free
- Overpaintable with most paints

**AREAS OF APPLICATION**

Sikaflex®-510 AM50 can be used for joints or gaps connecting dissimilar substrates such as vinyl to concrete or aluminum to EIFS. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-510 AM50 on materials prone to stress cracking. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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Sikaflex®-510 AM50

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## CURE MECHANISM

Sikaflex®-510 AM50 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see Diagram 1).

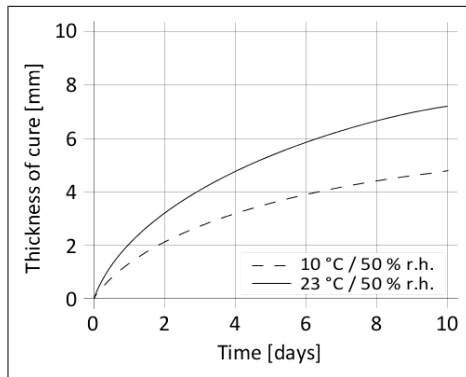


Diagram 1: Curing speed of Sikaflex®-510 AM50

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

### Application

Sikaflex®-510 AM50 can be processed between 5 °C and 40 °C (41 °F and 104 °F), climate and product, but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and process material is between 15 °C and 25 °C (59 °F and 77 °F).

Sikaflex®-510 AM50 can be processed with manual, pneumatic or electric driven piston guns.

### Tooling and finishing

Tooling and finishing must be carried out within the skin time of the product. It is recommended using Sika® Slick. Other finishing agents must be tested for suitability and compatibility prior the use.

## Removal

Uncured Sikaflex®-510 AM50 may 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 hand wipes or a suitable industrial hand cleaner and water. Do not use solvents on skin.

## Overpainting

Sikaflex®-510 AM50 can be best painted within the skin formation time. If painting process takes place after the sealant has built a skin, adhesion could be improved by treating the joint surface with Sika® Aktivator-100 or Sika® Aktivator-205 prior to paint process. If the paint requires a baking process (> 80 °C (176 °F)), best performance is achieved by allowing the sealant to fully cure first. All paints have to be tested by carrying preliminary trials under manufacturing conditions.

The elasticity of paints is usually lower than that of sealants. This could lead to cracking of the paint in the joint area.

## Application Limits

- Maximum depth of sealant must not exceed 13 mm (1/2 in.); minimum depth is 6 mm (1/4 in.).
- Not intended for immersion, structural glazing applications, or horizontal vehicular traffic.
- Do not apply to damp or wet substrates.
- Allow treated wood to age six months before application.

## 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
- Sika Pre-treatment Chart
- For Silane Terminated Polymers
- General Guideline
- Bonding and Sealing with 1-component Sikaflex®

## PACKAGING INFORMATION

Cartridge	295 ml
Unipack	600 ml

## 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](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto: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.

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