

Sikaflex®-529

Multifunctional sprayable sealant for reproducing original factory finish

Technical Product Data

Chemical base	1-C Silane Terminated Polymer	
Colour (CQP ¹ 001-1)	Yellow ochre	
Cure mechanism	Humidity-curing	
Density (uncured) (CQP 006-4)	1.28 kg/l	
Consistency	light paste	
Application temperature	15 - 35 °C (60 - 95 °F)	
Tack-free time ² (CQP 019-1)	20 min. approx.	
Curing speed (CQP 049-1)	see diagram 1	
Shore A hardness (CQP 023-1 / ISO 868)	45 approx.	
Tensile strength (CQP 036-1 / ISO 37)	1 N/mm ² approx.	
Elongation at break (CQP 036-1 / ISO 37)	120% approx.	
Tear propagation resistance (CQP 045-1 / ISO 34)	2 N/mm approx.	
Glass transition temperature (CQP 509-1 / ISO 4663)	-60 °C (-75 °F)	
Service temperature (CQP 513-1)	permanent	-40 - 90 °C (-40 - 195 °F)
Short term	4 hours	120 °C (250 °F)
	1 hour	130 °C (265 °F)
Shelf life (storage below 25 °C) (CQP 016-1)	unipack	12 months
	drum	12 months

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23 °C (73 °F) / 50% r.h.

Description

Sikaflex®-529 is a multifunctional sprayable 1-c polyurethane hybrid sealant for car body assemblies. Sikaflex®-529 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- 1-C Silane Terminated Polymer
- Reproduces original factory finish
- Application by spray or brush
- Suitable for textured seams
- Seal seams without overspray
- Bonds well to a wide range of substrates, no priming necessary
- Clean application with Sika® Jetflow-Gun
- Can be overpainted immediately and up to 72 hours after application
- Fast drying
- Excellent non-sag characteristics
- Good acoustic and mechanical damping properties
- High electrical resistance
- Low odour formulation

Areas of Application

Sikaflex®-529 is designed for use as an elastic sealant for flush seams and lap joints in vehicle body assemblies. Suitable substrates include metals, both primed and finish-lacquered (2-c paint systems). This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Cure Mechanism

Sikaflex[®]-529 cures by reaction with atmospheric humidity. At low temperatures the water content of the air is lower and the curing reaction proceeds at a slower rate.

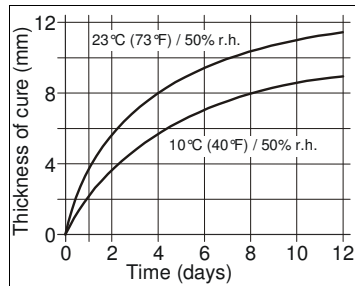


Diagram 1: Curing speed for Sikaflex[®]-529

Chemical Resistance

Sikaflex[®]-529 is resistant to fresh water, seawater, limewater and sewage effluent as well as dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils; vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Where appropriate, the adhesion of the sealant can be improved by treating the substrate with Sika[®]-Cleaner 205.

Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

Sikaflex[®]-529 is applied with the Sika[®] Jetflow-Gun. Operating air pressure: minimum 5 bar. This equipment should be operated in strict accordance with the manufacturer's instructions. See also the leaflet containing instructions for use of the Sika[®] Jetflow-Gun.

Do not apply at temperatures below 15°C or above 35°C. The optimum temperature for substrate and sealant is between 15°C and 25°C.

For advice on selecting and setting up a suitable pump system please contact the System Engineering Department of Sika Industry.

Tooling and finishing

Sikaflex[®]-529 can be tooled and finished with a brush or spatula within 10 minutes after application.

Removal

Uncured Sikaflex[®]-529 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 should be washed immediately using Sika[®] Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Overpainting

Sikaflex[®]-529 can be overpainted within the skin formation time. 2 component epoxy paints are usually suitable. Other paints must be tested for compatibility by carrying out preliminary trials under manufacturing conditions. The elasticity of paints is lower than of polyurethanes. This could lead to cracking of the paint film in the joint area.

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Pre-treatment Chart
- General Guidelines - Bonding and Sealing with Sikaflex[®]

Packaging Information

Unipack	300 / 600 ml
Drum	195 l

Value Bases

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

Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.



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