

# Sikasil® AS-785

## Fast curing industrial assembly sealant & adhesive

### Technical Product Data

Properties	Component A Sikasil® AS-785 A	Component B Sikasil® AS-785 B
Chemical base	2-C silicone	
Colour (CQP <sup>1</sup> 001-1)	White	Black, Translucent
Colour mixed	Black, Gray, White	
Cure mechanism	Polycondensation	
Cure type	Neutral	
Density (CQP 006-4)	1.44 kg/l approx.	1.07 kg/l approx.
Density mixed	1.42 kg/l approx.	
Mixing ratio	A:B by volume A:B by weight	10:1 13:1
Viscosity at 0.89 s <sup>-1</sup> (CQP 029-6)	1'200 Pa·s approx.	400 Pa·s approx.
Consistency	Paste	
Application temperature	5 - 40°C (40 - 105°F)	
Snap time <sup>2</sup> (CQP 554-1)	10 min approx.	
Tack-free time <sup>2</sup> (CQP 019-1)	40 min approx.	
Shore A-hardness (CQP 023-1 / ISO 868)	45 approx.	
Tensile strength (CQP 036-1 / ISO 37)	2.3 N/mm <sup>2</sup> approx.	
Elongation at break (CQP 036-1 / ISO 37)	250% approx.	
100% modulus (CQP 036-1 / ISO 37)	1.2 N/mm <sup>2</sup> approx.	
Movement accommodation capability (ASTM C 719)	±25%	
Thermal resistance (CQP 513-1)	180°C (355°F) approx. 190°C (375°F) approx. 200°C (392°F) approx.	
Short term	4 h 1 h	
Service temperature	-40 - 150°C approx. (-40 - 300°F)	
Shelf life (storage below 25°C) (CQP 016-1)	12 months	

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23°C (73°F) / 50% r.h.

<sup>3)</sup> For further values: see Calculation Value Sheet

### Description

Sikasil® AS-785 is a two-part, non-corrosive, fast-curing silicone sealant & adhesive, designed for industrial processes

Sikasil® AS-785 is manufactured in accordance with ISO 9001 quality assurance system and the responsible care program.

### Product Benefits

- Excellent adhesion to many substrates
- Low volatility
- Outstanding UV and weathering resistance
- Remains flexible over a wide temperature range
- Long-term durability
- No moisture required for curing

### Areas of Application

Sikasil® AS-785 can be used for high demanding industrial assembly and sealing applications. The product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



### Cure Mechanism

Sikasil® AS-785 starts to cure immediately after mixing the two components.

The speed of the reaction depends mainly on the temperature, i.e. the higher the temperature the faster the curing process. Heating above 50°C is not advisable as it may lead to bubble formation.

Since the curing process does not require moisture the products may also be used in totally confined spaces.

The mixer open time, i. e. the time the material can remain in the static mixer without flushing or extrusion of product is significantly shorter than the snap time indicated above. For more information please contact the Technical Service Department of Sika Industry.

### Application Limits

All Sikasil® engineering silicone sealants and adhesives are compatible with each other. Sikasil® AS sealants and adhesives are compatible with Sika® Spacer Tape HD. All other sealants and gaskets have to be approved by Sika before using them in combination with Sikasil® AS-785. Where two or more different reactive sealants are used, allow the first to cure completely before applying the next.

Sikasil® engineering sealants and adhesives may only be used in industrial assembly applications by experienced professionals and after a detailed examination and written approval of the corresponding project details by the Technical Service Department of Sika Industry.

The suitability of Sikasil® AS-785 for a specific application including compatibility and adhesion must be tested in advance.

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 oil, grease and dust.

Advice on specific applications and surface pretreatment methods is available from the Technical Service Department of Sika Industry.

#### Application

Before processing Sikasil® AS-785 both components have to be mixed homogeneously and air-bubble-free in the correct ratio as indicated with an accuracy of  $\pm 10\%$ . Most commercially available metering and mixing equipments are suitable. Please contact the System Engineering of Sika Industry for specific advice.

While the A-part of Sikasil® AS-785 is stable in air, the B-part is moisture-sensitive and must only be exposed briefly to air.

Joints must be properly dimensioned as changes are no longer possible after construction. Basis for calculation of the necessary joint dimensions are the technical values of the adhesive and the adjacent materials, the exposure of the building elements, their construction and size as well as external loads. For more information please contact the Technical Service Department of Sika Industry.

#### Tooling and finishing

If necessary, tooling and finishing must be carried out within the snap time of the adhesive. No tooling agents must be used.

#### Removal

Uncured Sikasil® AS-785 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. The static mixer of the metering and mixing equipment can be cleaned with Sikasil® Mixer Cleaner.

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

Sikasil® AS-785 is an elastic adhesive and cannot be overpainted.

### Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Different "Application Guidelines"
- Product Information Sheet Solar

### Packaging Information

Drum (comp. A)	260 kg
Pail (comp. B)	20 kg

### Value Bases

All technical data stated in this document 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.

Further information available at:  
[www.sika.ch](http://www.sika.ch)  
[www.sika.com](http://www.sika.com)

Sika Schweiz AG  
Business Unit Industry  
Tüffenwies 16  
CH-8048 Zurich  
Switzerland  
Tel. +41 58 436 40 40  
Fax +41 58 436 55 30

