

PRODUCT DATA SHEET

Sikaflex®-529 AT

ISOCYANATE FREE SPRAYABLE SEALANT FOR VEHICLE BODIES

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Silane Terminated Polymer
Color (CQP001-1)	Black, ochre
Cure mechanism	Moisture-curing
Density (uncured)	depending on color 1.3 kg/l
Application temperature	ambient 5 – 40 °C
Skin time (CQP019-1)	20 minutes ^A
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	3 %
Shore A hardness (CQP023-1 / ISO 48-4)	30
Tensile strength (CQP036-1 / ISO 527)	1 MPa
Elongation at break (CQP036-1 / ISO 527)	200 %
Tear propagation resistance (CQP045-1 / ISO 34)	2 N/mm
Service temperature (CQP513-1)	-40 – 80 °C
	4 hours 120 °C
	1 hour 140 °C
Shelf life	cartridge 15 months ^B
	unipack 12 months ^B

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) storage below 25 °C

DESCRIPTION

Sikaflex®-529 AT is a sprayable 1-component Silane Terminated Polymer (STP) sealant that cures on exposure to atmospheric humidity. It is used for seam sealing of factory provided original structures (surface areas and beads) for vehicle body assemblies. It adheres well to all the materials commonly used in body shops, e.g. metal primers and paint coatings, metals, painted plastics and plastics. Where applied, it improves the resistance against stone chip and other attacks to the car body.

PRODUCT BENEFITS

- Easy to reproduces original structures
- Excellent working properties with little over-spray
- Good adhesion to a wide variety of substrates
- Spray and bead application
- Very good non-sag properties
- Over paintable with water based paint systems
- Low odor
- Good acoustic and damping properties
- Solvent and isocyanate-free
- Silicone and PVC-free

AREAS OF APPLICATION

Sikaflex®-529 AT is designed for use as a sprayable elastic sealant for seam sealing, lap joints and stone chip protection in collision repair and vehicle body construction. Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-529 AT on materials prone to stress cracking. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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Version 05.01 (04 - 2023), en_DK
012201205293001000

CURE MECHANISM

Sikaflex®-529 AT 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).

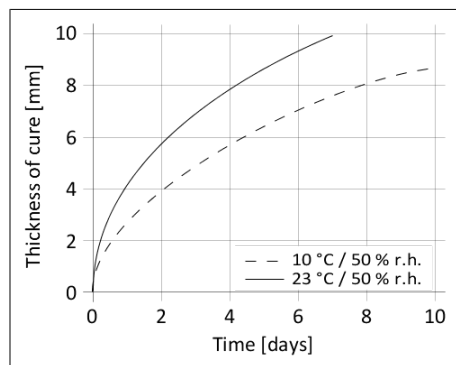


Diagram 1: Curing speed Sikaflex®-529 AT

CHEMICAL RESISTANCE

Sikaflex®-529 AT is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface preparation

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

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®-529 AT can be processed between 5 °C and 40 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C.

Sikaflex®-529 AT can be processed with manual, pneumatic or electric driven piston guns. For spray application it is recommended to use the Sika® Spray Gun (cartridge) or the Jetflow Gun (unipack).

Tooling and finishing

Sikaflex®-529 AT can be tooled and finished, for example, with a paint brush or spatula. Tooling and finishing must be carried out within the skin time of the sealant. It is recommended using Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior the use.

Removal

Uncured Sikaflex®-529 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 hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin!

Overpainting

Sikaflex®-529 AT 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), 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.

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
- Silane Terminated Polymer
- General Guidelines
- Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	290 ml
Unipack	300 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.

HEALTH AND SAFETY INFORMATION

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

DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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Sika Danmark A/S
Hirsemarken 5
3520 Farum
Tlf. +45 48 18 85 85
www.sika.dk

