



PRODUCT DATA SHEET

Sikasil® AS-785

Fast-curing silicone adhesive and sealant for structural assembly

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Sikasil® AS-785 (A)	Sikasil® AS-785 (B)
Chemical base	2-component silicone	
Colour (CQP001-1)	White	Black
	mixed Black	
Cure mechanism	Polycondensation	
Cure type	Alkoxy	
Density (uncured)	1.38 kg/L	1.06 kg/L
	1.35 kg/L	
Mixing ratio	A:B by volume	10:1
	A:B by weight	13:1
Viscosity (CQP029-6)	at 0.89 s ⁻¹	1700 Pa·s
		400 Pa·s
Consistency	Paste	
Application temperature	ambient	5 °C – 40 °C
Snap time (CQP554-1)	12 minutes ^{A, B}	
Tack free time (CQP019-3)	40 minutes ^A	
Shore A hardness (CQP023-1 / ISO 48-4)	50	
Tensile strength (CQP036-1 / ISO 527)	2 MPa	
100 % modulus (CQP036-1 / ISO 527)	1.2 MPa	
Elongation at break (CQP036-1 / ISO 527)	250 %	
Service temperature (CQP513-1)	-40 °C – 150 °C	
Shelf life	15 months ^C	9 months ^C

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.

^{B)} The snap time can increase add. 6 min. with component B at the end of shelf life

^{C)} storage below 25 °C

DESCRIPTION

Sikasil® AS-785 a fast-curing, two-component, silicone-based structural adhesive and sealant designed for industrial uses. Sikasil® AS-785 is corrosion-resistant and offers a very broad adhesion range, along with an outstanding long-term durability in harsh environment conditions.

PRODUCT BENEFITS

- Good adhesion and mechanical performance under harsh environment conditions
- Adhesion to a wide variety of substrates
- Performance retention over a wide temperature range
- Long-term durability

AREAS OF APPLICATION

Sikasil® AS-785 is especially designed for fast and/or automated bonding of structural adhesive joints. Especially for interior or exterior applications where a high mechanical performance under harsh conditions are required, like in appliances, solar and automotive.

Common substrates are metals, particularly aluminum, glass, metal primers and paint coatings (2-part systems), ceramic materials and plastics.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

PRODUCT DATA SHEET

Sikasil® AS-785

Version 06.02 (05 - 2026), en_CA

012703100850001000

CURE MECHANISM

Sikasil® AS-785 starts to cure immediately after mixing the two components. The speed of the reaction depends mainly on the temperature, which means that the higher the temperature, the faster the curing process. Heating above 50 °C could lead to bubble formation and is therefore not allowed. The mixer open time, or the time the material can remain in the mixer without flushing or extrusion of product, is significantly shorter than the snap time indicated above.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and any other contaminant that may prevent proper bonding. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond.

Note: Joints must be properly dimensioned.

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 equipment are suitable. For advice on selecting and setting up a suitable pump system, contact Sika Canada Technical Service – Industry.

Important: The B-component is moisture-sensitive and must therefore only be exposed briefly to air.

Tooling and finishing

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 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

Sikasil® AS-785 cannot be overpainted

FURTHER INFORMATION

The information herein is offered for general guidance only. Contact Sika Canada Technical Service – Industry for advice on specific applications.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Sikasil® AS-785 (A)

Drum	260 kg
------	--------

Sikasil® AS-785 (B)

Pail	20 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.

HEALTH AND SAFETY INFORMATION

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

DISCLAIMER

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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

PRODUCT DATA SHEET

Sikasil® AS-785

Version 06.02 (05 - 2026), en_CA
012703100850001000

Sika Canada Inc.

Head Office
601, avenue Delmar
Pointe-Claire, Quebec
H9R 4A9
1-800-933-SIKA
www.sika.ca

