

Sikasil® AS-785**Fast-Curing Industrial Assembly Sealant and Adhesive****Technical Data**

| | Component A | Component B |
|--|------------------------------|-------------------|
| Chemical Base | 2C Silicone | |
| Colour (CQP ¹ 001-1) | White | Black/Translucent |
| Colour mixed | Black/Grey/White | |
| Cure Mechanism | Polycondensation | |
| Cure Type | Neutral | |
| Density (CQP 006-04) | 1.44 kg/L approx | 1.07 kg/L approx |
| Mixed | 1.42 kg/L approx | |
| Mixing Ratio | A:B by volume | 10:1 |
| | A:B by weight | 13:1 |
| Viscosity at 0.89 s ⁻¹ (CQP 029-6) | 1200 Pa's approx | 400 Pa's approx |
| Consistency | Paste | |
| Application Temperature | 5°C to 40°C | |
| Snap Time ² (CQP 554-1) | 10 min approx | |
| Tack-Free Time ² (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 ² approx | |
| Elongation at Break (CQP 036-1/ISO 37) | 250% approx | |
| 100% Modulus (CQP 036-1/ISO 37) | 1.2 N/mm ² approx | |
| Movement accommodation capability (ASTM C 719) | +/-25% | |
| Thermal Resistance (CQP 513-1) | 180°C approx | |
| Short-Term | 4 hours | 190°C approx |
| | 1 hour | 200°C approx |
| Service Temperature | -40 to 150°C approx | |
| Shelf Life (Storage below 25°C) (CQP 016-1) | 12 months | 9 months |
| ¹ CQP = Corporate Quality Procedure ² 23°C and 50% Relative Humidity | | |
| ³ For further values, see Calculation Value Sheet | | |

Description

Sikasil® AS-785 is a two-part, non-corrosive, fast-curing silicone sealant and adhesive, designed for industrial processes. Sikasil® AS-785 is manufactured in accordance with ISO 9001 Quality Assurance System.

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 highly demanding industrial assembly and sealing applications. This product is suitable for professional experienced users only. Tests with actual substrates and conditions must 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 product may also be used in totally confined spaces. The mixer Open Time (i.e. the time the material can remain in the mixer without flushing or extrusion of product) is significantly shorter than the Snap Time indicated above. For more information, contact the Technical Services 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 conjunction 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 Services 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 upon request. |
| 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 Services Department of Sika Industry. |
| Mixing | This is a two-component product that requires thorough mixing for proper performance; mix both components in the correct ratio (to an accuracy of +/- 10%) to obtain a homogeneous and air-bubble-free mixture. Most commercially available metering and mixing equipment is suitable. Please contact Technical Services for specific advice. Note: While Component A is stable in air, Component B is moisture sensitive and must be exposed to air only very briefly. |
| Application | Joints must be properly dimensioned as changes will not be possible after assembly. The technical values of the adhesive and adjacent materials, the exposure of the building elements, their construction and size, as well as external loads must form the basis for calculating the necessary joint dimensions. For more information, contact Sika's Technical Services Department. |
| Tooling and Finishing | Tooling and finishing must be carried out within the Snap Time of the adhesive. Do not, however, use tooling agents! |
| Removal | Uncured sealant may be removed from tools and equipment with Sika® Remover-208 or other suitable solvent. The static mixer of the metering and mixing equipment can be cleaned with Sikasil® Mixer Cleaner or other suitable cleaner. Hands and exposed skin should be washed immediately using Sika® Hand Cleaner towels or other suitable industrial hand cleaner and water. Do not use solvents! |
| Over-Painting | Sikasil® AS-785 is an elastic adhesive and cannot be over-painted. |
| Further Information | Copy of the following publication is available upon request: <i>Material Safety Data Sheet</i> . |
| Packaging | Component A: 260 kg Drums; Component B: 20 kg Pails |
| Value Bases | All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence. |
| Health and Safety Information | For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. Product Data Sheets and Material Safety Data Sheets are available on our website at: www.sika.ca or via your local Technical Sales Representative. |

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, within their shelf life. 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under www.sika.ca.

Sika Canada Inc.
601 Delmar Avenue
Pointe-Claire, QC H9R 4A9
Tel.: 514-697-2610
Fax: 514-697-3910

1-800-689-SIKA
www.sika.ca

An ISO 9001 certified company
Pointe-Claire : ISO 14001 certified EMS

