



PRODUCT DATA SHEET

SikaSeal®-710 AT

Expanding Automotive OEM body shop mastic sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Rubber
Colour (CQP001-1)	Greige
Density	1.35 kg/l
Application temperature	20 – 40 °C
Curing conditions	standard 180 °C ^A 15 minutes minimum 160 °C ^A 10 minutes maximum 200 °C ^A 20 minutes
Volumetric expansion	50 % ^B
Tensile lap-shear strength (CQP046-9 / ISO 4587)	0.3 MPa ^C
Shelf life	3 months ^D

CQP = Corporate Quality Procedure

^{A)} metal temperature

^{C)} 2 mm bond line thickness

^{B)} depends on specimen geometry and bake conditions

^{D)} storage below 25 °C

DESCRIPTION

SikaSeal®-710 AT is an expanding Automotive OEM body shop mastic sealant that is PVC-free and is designed for use in body shops for both spot-weld mastic and anti-flutter applications. It shows very good adhesion to standard Automotive OEM body shop substrates and has the ability to meet typical undercutting corrosion resistance requirements.

SikaSeal®-710 AT has been proven to be compatible with many different Automotive OEM phosphate or electro-deposition systems. It can be used in weld-through applications with minimal degradation of the weld strength.

PRODUCT BENEFITS

- Good bond-line read-through resistance on very thin substrates
- Good corrosion resistance
- PVC free
- Can be robotically applied
- Room temperature application, which reduces energy demand

AREAS OF APPLICATION

SikaSeal®-710 AT has good wash off resistance in the uncured state and good adhesion following curing via OEM electrodeposition baking when applied to typical body shop substrates, including those prepared with stamping oils. Typical substrate types include cold-rolled, galvanized, galvanized steels and some grades of aluminum. Cured SikaSeal®-710 AT has a very low modulus, which minimizes the chances of "read through" on Class A surface. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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Version 02.01 (09 - 2026), en_CA

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CURE MECHANISM

SikaSeal®-710 AT is cured by heat. The cure and expansion rate depends on temperature and time of exposure. The most common heat sources are convection ovens. Do not expose the SikaSeal®-710 AT to a metal temperature of 200 °C for more than 20 minutes.

METHOD OF APPLICATION

SikaSeal®-710 AT is applied as small dollops or in bead form with a recommended diameter of 3 to 10 mm.

Application

The follower plate and the hoses do not necessarily have to be heated. It is recommended to heat the last hose, the dosing unit and the application nozzle to 30 °C +/- 5 °C to favor constant application properties. During longer breaks (e.g. overnight or weekends) suitable standby temperatures and switch-off times must be taken into account.

The time between application and curing must be as short as possible, since moisture uptake could negatively affect the performance of the process material.

SikaSeal®-710 AT can be processed between 20 °C and 40 °C with pump equipment.

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

Removal

Uncured SikaSeal®-710 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 a suitable industrial hand cleaner and water.

Do not use solvents on skin.

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

PACKAGING INFORMATION

Pail	18.9 L
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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

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