BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-527 AT

Isocyanate free sealant with reduced substrate preparation

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Silane Terminated Polymer
Colour (CQP001-1)		White, black
Cure mechanism		Moisture-curing
Density (uncured)	(depending on colour)	1.4 kg/l
Non-sag properties		Good
Application temperature	ambient	5 – 40 °C
Skin time (CQP019-1)		40 minutes [A]
Curing speed (CQP049-1)		(see diagram)
Shrinkage (CQP014-1)		3 %
Shore A hardness (CQP023-1 / ISO 48-4)		40
Tensile strength (CQP036-1 / ISO 527)		1.5 MPa
Elongation at break (CQP036-1 / ISO 527)		400 %
Tear propagation resistance (CQP045-1 / ISO 34)		6 N/mm
Service temperature (CQP513-1)		-50 – 80 °C
	4 hours	120 °C
	1 hour	160 °C
Shelf life	cartridge	15 months [B]

CQP = Corporate Quality Procedure

[A] 23 °C / 50 % r. h.

[B] storage below 25 °C

DESCRIPTION

Sikaflex®-527 AT is a 1-component Silan Terminated Polymer (STP) sealant that cures with exposure to atmospheric humidity. It is made for multipurpose elastic joints for both the interior and exterior of the vehicle body. Sikaflex®-527 AT adheres well to most materials commonly used in body shops.

PRODUCT BENEFITS

- Fast curing
- Excellent working properties
- Over paintable with water-based paint systems
- Good adhesion to a wide variety of substrates without primer
- Ageing and weathering resistant
- Low odour
- Non-corrosive
- Solvent and isocyanate-free
- Silicone and PVC-free

AREAS OF APPLICATION

Sikaflex®-527 AT is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound dampening measures in collision repair and vehicle body construction. It adheres well to most the materials commonly used in body shops, e.g. metal primers and paint coatings, metals, painted plastics and plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-527 AT on materials prone to stress cracking.

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

CURE MECHANISM

Sikaflex®-527 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).

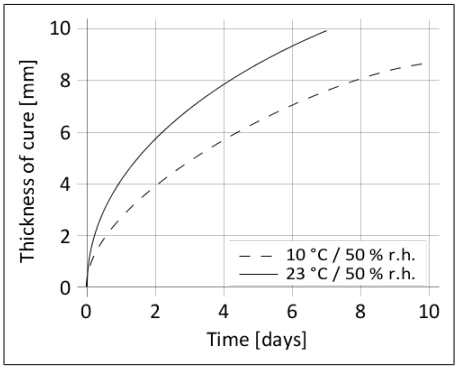

Diagram 1: Curing speed Sikaflex®-527 AT

CHEMICAL RESISTANCE

Sikaflex®-527 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, dust and contaminants.
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®-527 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®-527 AT can be processed with hand, pneumatic or electric driven piston guns.

Tooling and finishing

Tooling and finishing must be carried out within the skin time of the sealant. It is recommended to use Sika® Tooling Agent N. Other finishing agents must be tested for suitability and compatibility prior to use.

Removal

Uncured Sikaflex®-527 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 Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Overpainting

Sikaflex®-527 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 sealants, which 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	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

The information, and, in particular, the recommendations relating to the application and enduse 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.