BUILDING TRUST

PRODUCT DATA SHEET

SikaSeal®-320

Heat curing seam sealant for high temperature powder coat applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Polyvinyl Chloride
Color (CQP001-1)		White
Density		Max 1.6 kg/l
Application temperature	ambient	5 – 30 °C
Non-sag properties		Good
Curing conditions	standard	20 minutes at 145 °C
Shore A hardness (CQP023-1 / ISO 48-4)		59
Tensile strength (ASTM D412)		2.2 MPa
Elongation at break (ASTM D412)		175%
Lap Shear Strength (ASTM D-3163)		1.8 MPa
Shelf life		6 months [B]

CQP = Corporate Quality Procedure

[A] substrate temperature

[B] 23 °C (73 °F) / 50 % r. h.

DESCRIPTION

SikaSeal®-320 is a 1-component, cold-applied heat-curing sealant based on polyvinyl chloride. It is a flexible sealant especially designed for sealing metals prior to a powder-coating process.

PRODUCT BENEFITS

- Capable of withstanding baking / curing temperatures up to 145 °C
- Superior compatiblity with many powder coats and powder coating processes
- Bonds well to wide variety of substrates
- Very good application and tooling characteristics

AREAS OF APPLICATION

SikaSeal®-320 is suitable for seam sealing of passanger vehicle, truck bodies, cabs, and other manufacturing units and cures in the subsequent powder coat baking process. It is suitable for use with e- coated metals as well as treated aluminum and steel. It provides an excellent finish with a variety of powder coat chemistries.

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

SikaSeal®-320 is cured by heat. The cure rate depends on temperature and time of exposure. The most suitable heat sources are convection ovens. The recommended bake / cure temperature is at 145 °C in 20 minutes.
It is highly recommended to perform tests with original parts to ensure proper curing and function of the bonded part under original conditions.

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. Adhesion must be verified by tests on original substrates.

Application

SikaSeal®-320 can be processed between 5 °C and 30 °C with manual, pneumatic or electric driven piston guns as well as pump equipment.
For advice on selecting and setting up a suitable pump system, contact the Technical Service Department of Sika Industry.

Tooling and finishing

If needed, it is best to dry tool the sealant after application without the use of any chemical tooling or finishing agents.
If a chemical tooling or finishing agents is used, it must be tested for suitability and compatibility prior to use.

Removal

Uncured SikaSeal®-320 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.

Overpainting

SikaSeal®-320 is suitable for powder coating paint processes and is compatible with very light colors. For best results, the time between powder coat application and curing must be as short as possible.
All paints have to be tested by carrying preliminary trials under manufacturing conditions.

STORAGE CONDITIONS

SikaSeal®-320 has to be kept between 5 °C and 25 °C in a dry place. Do not expose it to direct sunlight.
If SikaSeal®-320 is stored at higher temperatures the shelf life will be reduced.

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

Cartridge	300 ml
Unipack	600 ml
Pail	23 liter
Drum	195 liter

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.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products.

LEGAL DISCLAIMER

PT. Sika Indonesia
Head Office and Manufacturing
Jl. Raya Cibinong-Bekasi Km.20
Limusnunggal-Cileungsi
Bogor 16820-Indonesia
Tel. +62 21 8230025, Fax +62 21 8230026