BUILDING TRUST

PRODUCT DATA SHEET

SikaPower®-320

Heat curing powder-coating sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Epoxy-Polyurethane
Colour (CQP001-1)		Grey
Density (uncured)		1.5 kg/l
Application temperature		20 – 40 °C
Curing conditions	30 minutes	180 °C
Shore A (CQP023-1)		65 [A]
Tensile strength (CQP580-5, -6 / ISO 527)		4 MPa [A]
Elongation at break (CQP580-5, -6 / ISO 527)		150 % [A]
Shelf life		6 months

CQP = Corporate Quality Procedure

[A] 23 °C / 50 % r.h.

DESCRIPTION

SikaPower®-320 is a one-component, cold-applied, heat-curing sealant based on epoxy resin and polyurethane.
It is developed for sealing applications directly before powder or stove enamel coating and cures with the paint in the oven.

PRODUCT BENEFITS

- Heat-curing one-component sealant
- Compatible with powder-coat baking oven conditions up to 220 °C
- Good and easy applicability
- Very good gap-bridging capabilities
- Adheres well to oily substrates
- Does not contain solvents or PVC

AREAS OF APPLICATION

SikaPower®-320 is suitable for sealing applications of various types of metals and can be used in combination with spot welding, riveting, clinching and other mechanical joining processes.
SikaPower®-320 can be applied on oily substrates and can absorb superficial oil (up to 3 g/m²) during the heat curing process.
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

SikaPower®-320 is cured by heat. The cure-rate depends on the temperature and the exposure time. The most common heat sources are convection ovens.
The temperature window for curing is between 160 °C and 220 °C (substrate temperature). The maximum exposure time at 220 °C is 30 minutes and must be observed.
The temperature and the duration of exposure to heat influence the final properties of the product. Therefore, preliminary tests with original parts under real curing conditions must be carried out to ensure proper curing and function of the sealant.

METHOD OF APPLICATION

Application

SikaPower®-320 can be processed with pneumatic or electric driven piston dispenser as well as pump equipment.
To reduce extrusion force, the product viscosity can be reduced by heating the unipacks up to 40 °C prior to the application.
After application, the maximum exposure time is 7 days at 23 °C / 50 % r.h. If the product is not heat-cured within the maximum exposure time, blisters may form in the paint.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Overpainting

SikaPower®-320 is suitable for powder-coating painting processes and is even compatible with very light colors. The Product is non-conductive and does not feature e-coating paintability.
Wash-out resistance before curing is limited to low-pressure washing.
Preliminary tests for process and paint compatibility are required.

STORAGE CONDITIONS

SikaPower®-320 has to be kept between 5 °C and 25 °C in a dry place.
After opening of the packaging, the content has to be protected against humidity.
If SikaPower®-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

Unipack	400 ml
Pail	23 l

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 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.

SIKA LIMITED
Watchmead
Welwyn Garden City
Hertfordshire, AL7 1BQ
Tel: 01707 394444
Web: www.sika.co.uk
Twitter: @SikaLimited