Industry

Sikasil® AS-785

Fast curing industrial assembly sealant / adhesive

Technical Product Data

Properties		Component A Sikasil® AS-785 A	Component B Sikasil® AS-785 B
Chemical base		2 component silicone	
Colour (CQP[1] 001-1)		White	Black, Translucent
Colour mixed		Black, Grey, White	
Cure mechanism		Polycondensation	
Cure type		Alkoxy	
Density (CQP 006-4)		1.4 kg/l approx.	1.05 kg/l approx.
Density mixed		1.37 kg/l approx.	
Mixing ratio	A:B by volume A:B by weight	10:1 13:1	
Viscosity at 0.89 s^{-1} (CQP 029-6)		1'200 Pa·s approx.	400 Pa·s approx.
Consistency		Paste	
Application temperature		5 - 40°C	
Snap time[2,3] (CQP 554-1)		12 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 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.	
Thermal resistance (CQP 513-1) Short term	4 hours 1 hour	190°C approx. 200°C approx.	
Service temperature		-40 - 150°C approx.	
Shelf life (storage below 25°C) (CQP 016-1)		15 months	9 months

[1] CQP = Corporate Quality Procedure [2] 23°C / 50% r.h. [3] The Snap time can increase up to 20 min with a component B at the end of shelf life

Description

Sikasil® AS-785 is a two-part, non-corrosive, fast-curing silicone sealant and adhesive, especially designed for automated industrial processes.
Sikasil® AS-785 is manufactured in accordance with ISO 9001/14001 quality assurance system and the 'Responsible Care' program.

Product Benefits

- Excellent adhesion to a wide variety of substrates
- Very good mechanical properties
- Outstanding adhesion and mechanical performance under harsh environment conditions
- Remains flexible over a wide temperature range
- Long-term durability
- Low volatility
- Meets EOTA ETAG 002
- UL® certified: UL94 V-1, QOQW2 (-40° C – 105° C)

Areas of Application

Sikasil® AS-785 is especially designed for automated bonding of structural adhesive joints. It is further suitable for high demanding industrial bonding and sealing applications like in the Solar and White Goods business.
The product is suitable for professional experienced users only. Tests with actual substrates and conditions have to 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. To increase the curing speed Sikasil® AS-785 can be heated up to 50°C (> 50°C risk of bubble formation). Since the curing process does not require moisture the products may also be used in 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 further information contact the Technical Department of Sika Industry.

Application Limits

For specific information regarding compatibility between various Sikasil® products contact the Technical Department of Sika Industry. Sikasil® AS adhesives and sealants are compatible with Sika® Spacer Tape HD. Prior use all materials in contact with Sikasil® AS-785 need to be approved by Sika. Where two or more different reactive process materials 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. A written approval of the corresponding project details by the Technical Department of Sika Industry is recommended. The suitability of Sikasil® AS-785 for a specific application including compatibility and adhesion must be tested in advance on original substrates and under actual conditions.
The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

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 Department of Sika Industry.

Application
Before applying Sikasil® AS-785 both components have to be mixed homogeneously and air-free in the correct ratio as indicated (accuracy ±10%). Most commercially available metering and mixing equipment are suitable. Contact the System Engineering of Sika Industry for specific advice.
The Sikasil® AS-785 B-component is moisture sensitive, therefore the exposure to air has to be reduced to an absolute minimum.
For further information contact the Technical Department of Sika Industry.
Joints must be properly dimensioned. Basis for calculation of the necessary joint dimensions are the technical values of the adhesive and the adjacent materials, the exposure of the elements, their construction and size as well as external loads. For more information contact the Technical Department of Sika Industry.

Tooling and finishing
If necessary, tooling and finishing must be carried out within the snap time of the adhesive. No tooling agents must be used.

Removal
Uncured Sikasil® AS-785 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent.
To clean mixer and metering equipment use Sika® Mixer Cleaner.
Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleaner and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:
- Safety Data Sheet
- General Guideline “Bonding and Sealing with Sikasil® AS Adhesives”
- Additional Product Information

Packaging Information

Pail (comp. A)	26 kg
Drum (comp. A)	260 kg
Pail (comp. B)	20 kg

Value Bases

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.

Legal Notes

Further information available at:
www.sika.co.uk

Sika Limited
Industry
Watchmead
Welwyn Garden City
Herts, AL7 1BQ
Tel. +44 (0)1707 394444