

PRODUCT DATA SHEET

Sikasil® AS-796

Fast curing industrial assembly sealant & adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Sikasil® AS-796 (A)	Sikasil® AS-796 (B)
Chemical base	2-component Silicone	
Colour (CQP001-1)	Black	Opaque
mixed	Black	
Cure mechanism	Polycondensation	
Cure type	Neutral	
Density (uncured)	1.29 kg/l	1.02 kg/l
mixed calculated	1.26 kg/l	
Mixing ratio	A:B by volume 10:1	
	A:B by weight 13:1	
Viscosity (CQP029-6)	at 0.89 s ⁻¹ 1000 Pa·s	300 Pa·s
Consistency	Paste	
Application temperature	ambient	5 – 35 °C
Snap time (CQP554-1)	3.5 minutes ^A	
Tack free time (CQP019-3)	6.5 minutes ^A	
Shore A hardness (CQP023-1 / ISO 48-4)	40	
Tensile strength (CQP036-1 / ISO 527)	2.6 MPa	
100 % modulus (CQP036-1 / ISO 527)	0.9 MPa	
Elongation at break (CQP036-1 / ISO 527)	280 %	
Tear propagation resistance (CQP045-1 / ISO 34)	2.6 N/mm	
Service temperature (CQP513-1)	-40 °C – 150 °C	
Shelf life (CQP016-1)	12 months ^B	9 months ^B

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

B) stored below 25 °C

DESCRIPTION

Sikasil® AS-796 is a 2-component, non-corrosive, exceptionally fast-curing silicone sealant and adhesive designed for industrial processes.

PRODUCT BENEFITS

- Allows fast handling of bonded parts
- Very good adhesion to many substrates
- Good UV and weathering resistance
- Long-term durability
- Pumpable over long distances

AREAS OF APPLICATION

Sikasil® AS-796 is especially designed for fast and/or automated bonding of structural adhesive joints and for interior or exterior applications where a high mechanical performance under harsh conditions is required, like in appliances, solar or automotive. Common substrates are metals, particularly aluminum, glass, metal primers and paint coatings (2- part systems), ceramic materials and plastics. 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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CURE MECHANISM

Sikasil® AS-796 starts to cure immediately after mixing the 2-components. The speed of the reaction depends mainly on the temperature, i.e. the higher the temperature the faster the curing process. Heating above 50 °C could lead to bubble formation and is therefore not allowed. 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

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.

Application

The optimum temperature for substrate and product is between 15 °C and 25 °C. Before processing Sikasil® AS-796 both components have to be mixed homogeneously and air-bubble-free in the correct ratio as indicated with an accuracy of ±10 %. Most commercially available metering and mixing equipment are suitable. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry. Consider that the components are moisture-sensitive and must therefore only be exposed briefly to air.

Tooling and finishing

Tooling and finishing must be carried out within the snap time of the adhesive. When tooling freshly applied Sikasil® AS-796, press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents must be used.

Removal

Uncured Sikasil® AS-796 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Re-usable, usually metallic, static mixer can be cleaned with Sika® Mixer Cleaner. Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin.

Overpainting

Sikasil® AS-796 cannot be overpainted.

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
- General Guideline Bonding and Sealing with Sikasil® AS-Products

PACKAGING INFORMATION

Sikasil® AS-796 (A)

Drum	240 kg
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Sikasil® AS-796 (B)

Pail	18 kg
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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 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.

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