

PRODUCT DATA SHEET

SikaSeal®-710 LS2

Anti-flutter sealant with optimized bond-line read-through resistance

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Rubber
Color (CQP001-1)	Grey
Solid content (CQP576-1)	90 %
Density	1.35 kg/l
Application temperature	20 — 40 °C
Viscosity η^* (DIN 54458)	flowability A1 at 45 °C 300 Pa.s ^E
	pumpability A4 at 45 °C 150 Pa.s ^F
Levelling behavior G' (DIN 54458)	A2 at 45 °C 15.000 Pa ^E
Curing conditions	standard 180 °C 20 minutes ^A
	minimum 160 °C 15 minutes ^A
Tensile lap-shear strength (CQP046-9 / ISO 4587)	0.1 MPa ^D
Shelf life	6 months ^C

CQP = Corporate Quality Procedure

^C stored at temperature between 5 °C and 25 °C^F dynamic state, deformation 10%^A object temperature^D 2 mm bond line thickness^B depending on sample size and bake conditions^E static state, deformation 0.05%
Volumetric expansion
20 minutes at 180 °C | 40 – 60 %^B
DESCRIPTION

SikaSeal®-710 LS2 is a universal, PVC-free adhesive used in OEM body shops for both, spot-weld mastic and anti-flutter applications. It shows excellent adhesion to standard OEM substrates including aluminium and protects metal substrates from corrosion during environmental ageing.

SikaSeal®-710 LS2 does not contaminate OEM phosphate or electro-deposition baths. It can be used in weld-through applications without any degradation of the weld strength.

PRODUCT BENEFITS

- Good bond-line read-through resistance on very thin substrates
- Good corrosion resistance
- PVC free
- Universal application
- Can be robotically applied
- Cold pumpable and applicable
- Reducing energy demand

AREAS OF APPLICATION

Uncured SikaSeal®-710 LS2 has excellent adhesion to oily, cold-rolled, galvanized, galvanized steels and aluminium, which, combined with its good wash out resistance, allows its application at any point during the body shop assembly. After exposure to standard automotive bake conditions, SikaSeal®-710 LS2 exhibits excellent adhesion to standard steel and aluminium substrates. Adhesion is maintained after subjection to the various accelerated aging and weathering test conditions used in the automotive industry.

CURE MECHANISM

SikaSeal®-710 LS2 is cured by heat. The cure and expansion rate depends on temperature and time of exposure. The most common heat sources are convection ovens. The maximum temperature must not exceed 210 °C for 10 minutes.

METHOD OF APPLICATION

SikaSeal®-710 LS2 is typically applied as dots or in bead form with a diameter of 3 to 9 mm. The follower plate and the hoses do not necessarily have to be heated. It is recommended to heat the last hose, the dosing unit and the application nozzle to 30 °C +/- 10 °C to favor constant application properties. During longer breaks (e.g. overnight or week-ends) suitable standby temperatures and switch-off times must be taken into account. The time between application and curing must be as short as possible, since moisture uptake could negatively affect the performance of the process material. SikaSeal®-710 LS2 can be processed with hand-, pneumatic- or electric driven piston guns as well as dispensing equipment. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

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	0.4 kg
Pail	24 kg
Drum	260 kg

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.

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