

## PRODUCT DATA SHEET

# Sikagard<sup>®</sup>-6682

Water-based sound-deadening underbody coating

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

<b>Chemical base</b>		Water-based acrylic dispersion
<b>Color (CQP001-1)</b>		Dark grey
<b>CURE MECHANISM</b>		Water evaporation
<b>Solid content (CQP002-1)</b>		75 %
<b>Viscosity</b>	Rheolab QC CC 27 rotational at 1 s <sup>-1</sup>	175 Pa·s <sup>A</sup>
<b>Application temperature</b>		5 – 35 °C
<b>Film thickness</b>	for stone-chip protection for sound deadening	500 – 1000 µm see diagram 1
<b>Drying time</b>	1 mm wet layer 2 mm wet layer	8 hours <sup>A</sup> 24 hours <sup>A</sup>
<b>Loss factor (ISO 6721-3)</b>		see diagram 1
<b>Stone-chip resistance (ISO 20567-1, Method B)</b>	1 mm dry film	80 cycles
<b>Service temperature</b>		-45 – 120 °C
<b>Shelf life</b>		9 months

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r. h.

**DESCRIPTION**

Sikagard<sup>®</sup>-6682 is a water-based sprayable sound-deadening and anti-chip coating, based on an acrylic dispersion.

It is used in commercial vehicle manufacturing to dampen structure-borne noise.

The Product provides as well stone chip protection to vulnerable parts, enhancing therefore the primary corrosion-protection performance of pre-applied coatings.

**PRODUCT BENEFITS**

- High resistance to abrasion
- Very good sound-deadening performance
- Low water take-up
- Thick-layer spray application without dripping or sagging
- Solvent- and halogen-free

**AREAS OF APPLICATION**

Sikagard<sup>®</sup>-6682 is used for the reduction of structure-borne noise in commercial vehicles. It also provides stone-chip protection for vulnerable parts of the vehicle such as sills, wings, wheel arches and other parts.

It exhibits good adhesion on many coatings and primers used in the transportation industry.

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

Sikagard®-6682 hardens by evaporation of water and physical film formation.

## CHEMICAL RESISTANCE

Sikagard®-6682 is generally resistant to fresh water, seawater, oils, diluted acids and bases. The above information is offered for general guidance only. Advice on specific applications will be given on request.

## METHOD OF APPLICATION

### Surface Preparation

Sikagard®-6682 is not to be used as corrosion protection, therefore it is mandatory that metal substrates carry an adequate corrosion protection, such as coating, galvanization, etc. Surfaces must be clean, dry and free of rust, dust and grease.

### Application

Sikagard®-6682 can be applied to small areas with a spatula. For larger areas airless spraying equipment is recommended. Usually double-action stainless steel pump systems are used.

For airless spraying application, different nozzle types are available on the market. The choice of the nozzle depends from the desired coverage and finishing and must be determined by application tests.

A coverage of 500 µm to 1000 µm dry thickness is in general sufficient for underbody stone-chip protection applications. In case of critical areas higher thicknesses may be applied.

For sound-deadening applications the thickness of the coating depends from the desired damping result. The dependence of the composite loss factor from the thickness of Sikagard®-6682 is visible in the following graph (on 1 mm steel bar).

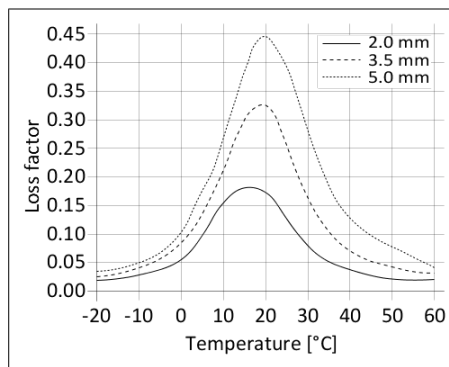


Diagram 1: Composite loss factor (ISO 6721-3)

Applied coating must be sufficiently dried before exposure to freezing or wet conditions. The exact waiting time must be determined by project related tests. The dry time can be decreased significantly with a proper ventilation.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

### Removal

Fresh Sikagard®-6682 can be removed from tools and equipment with water. Once dried, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H cleaning towels or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

### STORAGE CONDITIONS

Sikagard®-6682 has to be kept between 5 °C and 30 °C during storage.

The lowest allowed temperature during transportation is 5 °C.

### 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

Pail	30 kg
Drum	250 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.

## PRODUCT DATA SHEET

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