

## PRODUCT DATA SHEET

# SikaDamp®-711

Heat fusible sandwich foil of bitumen and bitumen foam covered with PP-foil layer

## TYPICAL PRODUCT DATA

<b>Chemical base</b>		Polymer modified bitumen, mineral filler, iron oxide, microspheres
<b>Color (CQP001-1)</b>	bitumen foam	Black
	bitumen heavy foil	Black
<b>Density</b>	bitumen foam	0.3 g/cm <sup>3</sup>
	bitumen heavy foil	2.4 g/cm <sup>3</sup>
<b>Top layer thickness (DIN ISO 1849-1/2)</b>		55 µm
<b>Total thickness (DIN ISO 1849-1/2)</b>	total thickness	3.5 mm
	bitumen foam	1.3 mm
	bitumen heavy foil	2.2 mm
<b>Area weight (CQP008-4)</b>		5.6 g/cm <sup>3</sup>
<b>Application temperature</b>	for 30 seconds	120 °C
<b>Loss factor (ISO 6721-3)</b>		see diagram 1
<b>Flammability (DIN 75200)</b>		100 mm/min
<b>Shelf life</b>		4 months

CQP = Corporate Quality Procedure

**DESCRIPTION**

SikaDamp®-711 is a high-quality bitumen based sandwich foil. It combines sound deadening and sound damping properties on steel substrates with a very good energy saving potential for best possible energy efficiency.

The bitumen foil is filled with mineral material, iron-oxide and polymers. The bitumen foam is without mineral material. SikaDamp®-711 is covered with a PP-foil and equipped with a polyamid hot melt adhesive film.

The odor of SikaDamp®-711 is negligible in household appliances in operation up to 80 °C. At higher temperatures, a slight bitumen odor may be perceptible temporarily.

**PRODUCT BENEFITS**

- Sandwich-layout for energy saving and sound deadening benefits
- Sound damping
- Bitumen-sandwich foil covered with PP-foil
- Heat fusible
- Sound deadener
- Customized die-cut parts or sheets

**AREAS OF APPLICATION**

SikaDamp®-711 was developed for high end dishwashers where a combination of sound damping and energy efficiency is relevant. It can as well be used in other industrial fields, where heavy-layer damping in combination with energy decoupling is required.

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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SikaDamp®-711

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## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil, water and dust.

### Application

During application, the hot melt adhesive must reach 120 °C for a period of at least 30 seconds.

It is common practice in the industry to heat the bitumen material from the bitumen side in order to soften the bitumen material first and to achieve a full surface contact of the mat before the hot melt adhesive is activated. For information regarding typical loss factors, see diagram 1. The layer structure is shown in figure 1.

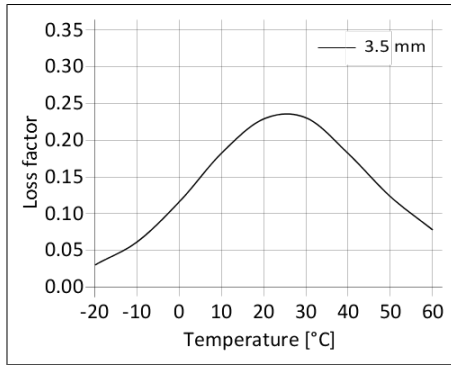


Diagram 1: Loss factor SikaDamp®-711 at 200 Hz

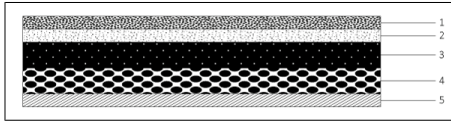


Figure 1: 1) PP-foil, 2) Bitumen based PSA, 3) Bitumen heavy foil, 4) Bitumen foam, 5) Hot melt film

## STORAGE CONDITIONS

SikaDamp®-711 has to be stored dry and protected from UV light. The storage temperature is between 0 °C and 35 °C. Consider, that at temperature below 15 °C the bitumen starts to get brittle and can break. Therefore, if products are sourced from a cold storage it must be handled with care.

Ensure that the product has reached the defined application temperature before it is applied. This might be realized by storing the parts for 24 to 48 hours prior application at the assembly line.

Note: Storage outside of standard conditions can affect the shelf life.

## 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:

- Voluntary Safety Information Sheet

## PACKAGING INFORMATION

Sika is delivering the finished and die-cut products on returnable steel pallets, whereas the parts are placed in the correct position for further processing.

As alternative wooden one-way packaging, multiuse grid boxes and card boxes would be available.

## 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

This product contains no substances which are intended to be released from the article under normal or reasonably foreseeable conditions of use. A safety data sheet is therefore not needed to bring the product to the market, to transport or to use it. For safe use follow the instructions given in the Voluntary Safety Information Sheet.

## DISCLAIMER

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