

PRODUCT DATA SHEET

SikaPower®-416 P1

Heat curing seam sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

| | | |
|------------------------------------------------------|-----------------------|-------------------------|
| Chemical base | Epoxy-Polyurethane | |
| Color (CQP001-1) | Black | |
| Solid content (CQP576-1) | 99% | |
| Density (uncured) | 1.3 kg/l | |
| Application temperature | 30 - 40°C | |
| Curing conditions | standard 180 °C | 30 minutes ^A |
| | minimum 160 °C | 15 minutes ^A |
| Shore A (CQP023-1) | 60 | |
| Tensile strength (CQP580-5, -6 / ISO 527) | at 2 mm/minute | 3.5 MPa |
| Elongation at break (CQP580-5, -6 / ISO 527) | at 2 mm/minute | 70% |
| Glass transition temperature, DMTA (DIN EN ISO 6721) | -50°C | |
| Shelf life | 4 months ^B | |

CQP = Corporate Quality Procedure

^A) substrate temperature^B) stored at temperature below 25°C**DESCRIPTION**

SikaPower®-416 P1 is a one-part, cold pumpable, warm-applied, heat curing sealant.

It is designed for sealing seams and joints in sheet metal assembly work in the body shop and is cured with heat, e.g. in the paint oven.

SikaPower®-416 P1 is wash-out resistant in typical applications; for critical areas wash-out resistance can be increased by adding a heat pre-curing step (e.g. IR).

PRODUCT BENEFITS

- Adheres well to oily substrates
- Wash-out resistant
- Suitable for sealing different metals
- Solvents and PVC free

AREAS OF APPLICATION

SikaPower®-416 P1 is suitable for seam sealing and sealing joints in metal assemblies. Adhesion on oily substrates (standard anti-corrosion treatment and deep drawing oils, up to 3 g/m²) is possible because of the oil uptake during the heat curing.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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CURE MECHANISM

SikaPower®-416 P1 is cured by heat. The cure rate depends on temperature and time of exposure. The most common heat sources are convection ovens. The maximum temperature must not exceed 200 °C for more than 10 minutes.

METHOD OF APPLICATION

Application

SikaPower®-416 P1 is typically applied in bead form.

The follower plate, pump and hoses do not necessarily have to be heated if the ambient temperature is 18 °C or higher. The last hose and dispenser are typically heated to 30 - 40 °C. Depending on the equipment, especially at low ambient temperatures, application tests are recommended.

During longer breaks (e.g. overnight or weekends) 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 cause formation of blisters during the heat curing process. The open time at 23 °C / 50 % relative humidity must not exceed 3 days before heat curing, provided a bead thickness of 1.5 mm or more. In case of thinner beads / higher temperature / higher humidity the maximum open time will decrease significantly and has to be tested prior to use. However, moisture uptake can be prevented by precuring the assemblies or car bodies for 15 minutes at 160 °C (substrate temperature).

For advice on selecting and setting up a suitable pump system and related process parameters, contact your Sika sales representative.

STORAGE CONDITIONS

SikaPower®-416 P1 has to be kept below 25 °C in a dry place. Do not expose it to direct sunlight. After opening, the packaging content has to be protected against humidity. If stored at higher temperatures, the shelf-life will be reduced.

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 | 25 kg |
| Drum | 245 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 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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