

## PRODUCT DATA SHEET

# SikaDamp<sup>®</sup>-660

Self-adhesive constrained layer system for vibration damping

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

<b>Chemical base</b>		Butyl rubber
<b>Color (CQP001-1)</b>	mastic layer	Black
	aluminum top layer	Silver
<b>Density (CQP006-4)</b>	mastic layer	1.6 g/cm <sup>3</sup>
<b>Top layer thickness (DIN ISO 1849-1/2)</b>		0.15 mm
<b>Total thickness (DIN ISO 1849-1/2)</b>		1.3 – 4.0 mm
<b>Area weight (CQP008-4)</b>	thickness 1.6 mm	2.8 kg/m <sup>2</sup>
<b>Loss factor (ISO 6721-3)</b>	thickness 1.6 mm	0.22 <sup>A</sup>
<b>Flammability (DIN 75200)</b>		0 mm/min
<b>Shelf life</b>	body or paint shop application	4 months <sup>B</sup>
	final assembly application	7 months <sup>B</sup>

CQP = Corporate Quality Procedure

A) at 20 °C

B) Storage below 35 °C / 50 % r. h.

**DESCRIPTION**

SikaDamp<sup>®</sup>-660 consists of a non-curing, self-adhesive butyl-based mass and an aluminum constraining layer used for the reduction of structure borne vibrations. This product can be die cut into customized shapes and sizes specific for each application, different layer thicknesses are available upon request. SikaDamp<sup>®</sup>-660 is a high grade formulation with mineral fillers that offers superior damping performance over traditional damping products.

**PRODUCT BENEFITS**

- Excellent damping properties
- Can be applied throughout the body production process
- Damping properties are unaltered by standard bake temperature
- Application on flat or slightly curved surfaces possible
- Customized part design, die cut parts or sheets
- Automatic and manual application possible

**AREAS OF APPLICATION**

SikaDamp<sup>®</sup>-660 can be applied at any area during automotive assembly process. It is compatible with automotive treatment baths and finish processes. Product shall be applied on metal, aluminium or composite substrates. It is suitable for pure or electro coated surfaces in the body or paintshop as well as on painted surfaces in trim shop. This product is suitable for flat, slightly curved surfaces also in vertical and inverted areas.

## ADHESION AND DURABILITY

SikaDamp®-660 has demonstrated superior adhesion to cold rolled, galvanized and galvaneal steel as well as electro coatet surfaces, base-coat

and clear coat body panels. SikaDamp®-660 maintains its acoustic and adhesive properties after subjection to the various bake schedules and accelerated aging and weathering test conditions used in the automotive industry.

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

## METHOD OF APPLICATION

### Surface preparation:

No special preparation required other than the surfaces must be clean, dry and free from grease, oil, water and dust.

### Application:

Ensure proper and full surface adhesion. If cold applied, the application pressure is crucial and directly linked to the adhesion properties. The parts have to be pressed on the substrate over the entire surface to ensure adequate contact pressure using a pressure roller consisting of soft foam rubber. The shape and width of the pressure roller should be adjusted to the geometry of the part and the surface to achieve best

adhesion. Application may only be processed on material and substrate temperatures between 20 °C and 35 °C. Ideal application temperature is between 25°C and 30°C. The usage of a vacuum assist tool to facilitate application is possible.

## STORAGE CONDITIONS

Material have to be kept dry at temperatures between 18 °C and 35 °C and at a relative humidity of maximum 50 %. Storage outside of these conditions reduces 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. Copies of the following publications are available on request:

- Voluntary Safety Information
- Application Manual for SikaDamp Application

## PACKAGING INFORMATION

Cut-to-shape die-cut parts or sheets.

## 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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