

## Sikaflex<sup>®</sup>-529

Multifunctional sprayable sealant for reproducing original factory finish in car body repair

### Technical Product Data

Chemical base	1-component polyurethane-hybrid
Colour (CQP <sup>1)</sup> 001-1)	Yellow ochre
Cure mechanism	Moisture-curing
Density (uncured) (CQP006-4)	1,28 kg/l approx.
Non-sag properties	thixotropic
Application temperature	15°C - 35°C
Tack free time <sup>2)</sup> (CQP019-1)	15 min. - 20 min.
Curing speed (CQP049-1)	(see diagram)
Shore A-hardness (CQP023-1 / ISO 868)	45 approx.
Tensile strength (CQP036-1 / ISO 37)	1 N/mm <sup>2</sup> approx.
Elongation at break (CQP036-1 / ISO 37)	120% approx.
Tear propagation resistance (CQP045-1 / ISO 34)	2 N/mm approx
Glass transition temperature (CQP509-1 / ISO 4663)	-60°C approx.
Service temperature (CQP513-1)	permanent -40°C to +90°C
Short term	4 hours 120°C 1 hour 130°C
Shelf life (storage below 25°C) (CQP016-1)	Nine (9) months

<sup>1)</sup> CQP = Corporate Sika Quality Procedures

<sup>2)</sup> 23°C / 50% r.h.

### Description

Sikaflex-529 is a multifunctional sprayable 1-component polyurethane hybrid sealant for car body assemblies. Sikaflex-529 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

### Product Benefits

- 1-component hybrid-formulation technology
- Reproduces original factory finish, can be applied by spray or brush, suitable for textured seams – for all makes of car
- Seals seams without overspray
- Bonds well to a wide range of substrates, no priming necessary
- Clean application with Sika Jetflow-Gun
- Can be overpainted immediately and for up to 72 hours after application
- Fast drying
- Excellent non-sag characteristics
- Good acoustic and mechanical damping properties
- High electrical resistance
- Low odour formulation

### Areas of Application

Sikaflex-529 is designed for use as an elastic sealant for flush seams and lap joints in vehicle body assemblies. Suitable substrates include metals, as well as primed and finish-lacquered (2-component) paint systems.



### Cure Mechanism

Sikaflex-529 cures by reaction with atmospheric humidity. At low temperatures the water content of the air is lower and the curing reaction proceeds at a slower rate.

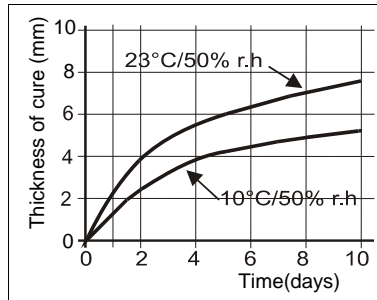


Diagram 1: Curing speed for Sikaflex®-529

### Chemical Resistance

Sikaflex-529 is resistant to fresh water, seawater, limewater and sewage effluent as well as dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils; vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

### Method of Application

#### Surface preparation

Surfaces must be clean, dry and free from all traces of grease, oil and dust. Where appropriate, the adhesion of the sealant can be improved by treating the substrate with Sika Activator.

Advice on specific applications is available from Sika's Technical Service Department.

#### Application

Sikaflex-529 is applied with the Sika® Jetflow-Gun. Operating air pressure: minimum 5 bar. This equipment should be operated in strict accordance with the manufacturer's instructions. See also our leaflet containing instructions for use of the Sika Jetflow-Gun.

Do not apply at temperatures below 15°C or above 35°C. The optimum temperature for substrate

and sealant is between 15°C and 25°C.

#### Tooling and finishing

Sikaflex-529 can be tooled and finished with a brush or spatula within ten minutes of application.

#### Removal

Uncured Sikaflex-529 can be removed from tools and equipment with Sika Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents!

#### Overpainting

Sikaflex-529 can be overpainted immediately after application with 2-component lacquers and 1-component paint systems based on a non-oxidative drying mechanism.

The paint must be tested for compatibility by carrying out preliminary trials. It should be understood that the hardness and film thickness of the paint may impair the elasticity of the sealant and lead to cracking of the paint film.

### Further Information

Copies of the following publications are available on request:

- Safety Data Sheet
- Sika Primer Chart
- General guidelines for bonding and sealing with Sikaflex products.
- Sika Jetflow Gun Brochure

### Packaging Information

Sausage	300 ml
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### Important

For information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

### Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:

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