BUILDING TRUST

PRODUCT DATA SHEET

SikaSeal®-331

Heat curing seam sealant for e-coat and high temperature powder coat applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Acrylic Plastisol
Color (CQP001-1)		White
Solid content (CQP576-1)	minimum	95 %
Density		1.42 kg/l
Application temperature	ambient	5 – 35 °C
Non-sag properties		Good
Curing conditions		30 minutes at 200 °C
Tensile strength (ASTM D412)		2.5 MPa
Elongation at break (ASTM D412)		250 %
Service temperature (CQP513-1)		-25 – 90 °C
Shelf life		9 months [A]

CQP = Corporate Quality Procedure

[A] 23 °C / 50 % r. h.

DESCRIPTION

SikaSeal®-331 is a 1-component, cold-applied heat-curing sealant based on acrylic plastisols. It is a flexible sealant especially designed for sealing metals prior to a powder-coating process and e-coating process.

PRODUCT BENEFITS

- Capable of withstanding baking / curing temperatures up to 230 °C
- Superior compatiblity with many powder coats and powder coating processes
- Bonds well to wide variety of substrates without plasticizer migration
- Outstanding performance of non-sagging properties
- Very good application and tooling characteristics

AREAS OF APPLICATION

SikaSeal®-331 is suitable for seam sealing of truck bodies, cabs, and other manufacturing units and cures in the subsequent powder coat baking process. It is suitable for use with e-coated metals. It provides an outstanding finish with a variety of powder coat chemistries.

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

SikaSeal®-331 is cured by heat. The cure rate depends on temperature and time of exposure. The most suitable heat sources are convection ovens. The minimum cure temperature is 180 °C at 30 minutes and the maximum heating temperature must not exceed 230 °C.
It is highly recommended to perform tests with original parts to ensure proper curing and function of the bonded part under original conditions.

METHOD OF APPLICATION

Application

SikaSeal®-331 is applied as dots or in bead form with a recommended diameter of 1 to 6 mm.
The time between application and curing must be as short as possible, since moisture uptake could negatively affect the performance of the process material.
SikaSeal®-331 can be processed between 5 °C and 35 °C with manual, pneumatic or electric driven piston guns as well as pump equipment.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Tooling and finishing

Do not use any chemical tooling or finishing agents.

Removal

Uncured SikaSeal®-331 can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin.

Overpainting

SikaSeal®-331 is suitable for powder coating paint processes and is compatible with light colors. For best results, the time between powder coat application and curing must be as short as possible.
All paints have to be tested by carrying preliminary trials under manufacturing conditions.

STORAGE CONDITIONS

SikaSeal®-331 has to be kept between 5 °C and 25 °C in a dry place. Do not expose it to direct sunlight or other heat sources.
If SikaSeal®-331 is 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 Sheet

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Pail	18 L
Drum	180 L

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.

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