

PRODUCT DATA SHEET

SikaDamp®-635

Self-adhesive, constrained layer system for vibration damping

TYPICAL PRODUCT DATA

Chemical base		PIB rubber
Color (CQP001-1)	mastic layer aluminum top layer	Black Silver
Density (CQP006-4)	mastic layer	1.65 g/cm ³
Top layer thickness (DIN ISO 1849-1/2)		0.15 mm
Total thickness (DIN ISO 1849-1/2)		1.3 – 4.0 mm
Area weight (CQP008-4)	thickness 1.6 mm	2.8 kg/m ²
Loss factor (ISO 6721-3)	thickness 1.6 mm	0.22 ^A
Flammability (DIN 75200)		0 mm/min
Shelf life (CQP016-1)	body or paint shop application final assembly application	4 months ^B 7 months ^B

CQP = Corporate Quality Procedure

^A) at 30 °C^B) below 35 °C / 50 % r. h.

DESCRIPTION

SikaDamp®-635 is a non-curing, self-adhesive butyl-based mass used for reduction of structure borne vibration.

Processed with an aluminum constraining layer, SikaDamp®-635 is usually cut to shape by die-cut into customized parts.

SikaDamp®-635 is a high grade formulation with mineral fillers that offers superior damping performance over traditional dampers.

PRODUCT BENEFITS

- Superior damping properties
- Application during body production process
- Damping properties are unaltered by bake or operating temperature
- Application on flat or slightly curved surfaces possible
- Customized die-cut parts
- Automatic and manual application possible

AREAS OF APPLICATION

SikaDamp®-635 is applied at any area during automotive assembly process. It is compatible with standard automotive treatment baths and finishing processes.

It shall be applied on metal, aluminium or composite substrates, it is suitable for pure or electro coated surfaces in the body or paint-shop as well as on painted surfaces in trim shop. SikaDamp®-635 is suitable for flat, slightly curved surfaces also in vertical and inverted areas.

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

ADHESION AND DURABILITY

SikaDamp®-635 has demonstrated superior adhesion to cold rolled steel and galvanized steel as well as electro-coated surfaces, base-coat and clear coat body panels. SikaDamp®-635 maintains its acoustic and adhesive properties after subjection to the various bake schedules and accelerated aging and weathering test conditions widely used in the automotive industry.

METHOD OF APPLICATION

Surface preparation

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

Application

Ensure proper and full surface adhesion over the entire geometry of the part.

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.

If cold applied the application pressure is crucial and directly linked to the adhesion properties.

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.

STORAGE CONDITIONS

Material have to 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 Industry.

Copies of the following publications are available on request:

- Voluntary Safety Information Sheet
- 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

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

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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Sika Hungária Kft.
2051 Biatorbágy
Rozália Park 5-7.
Tel: +36 1 371 2020
Fax: +36 1 371 2022
info@hu.sika.com
<https://hun.sika.com>

