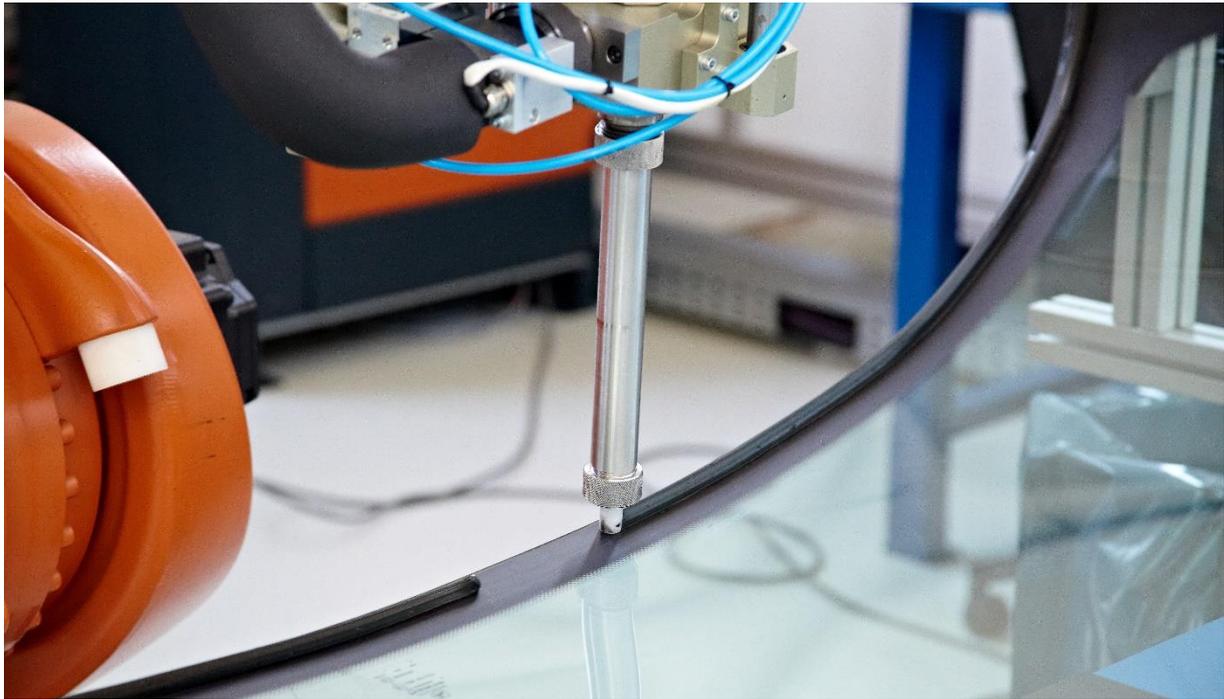


NEW RELEASE

SikaForce®-825 L04 FOR ASSEMBLY LINE APPLICATIONS



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EXECUTIVE SUMMARY

For many years, SikaForce® adhesives have proved their excellence across numerous projects and applications where flexible or (semi-) structural joints with high demands on long-term robustness and weathering resistance are given. In the automotive industry these requirements are associated with short cycle times and a wide range of different materials. With SikaForce® adhesives, a highly industrialized and automatized level performance in joining assembly parts such as spoilers, liftgates, roofs and decorative components can be achieved.

Our newly released SikaForce®-825 L04 adhesive further complements the strong SikaForce® portfolio. SikaForce®-825 L04 is a fast and flexible adhesive offering new advantages to customers requiring fast strength build up, long open times and/or solutions for critical substrates difficult to bond and prone to stress cracking.

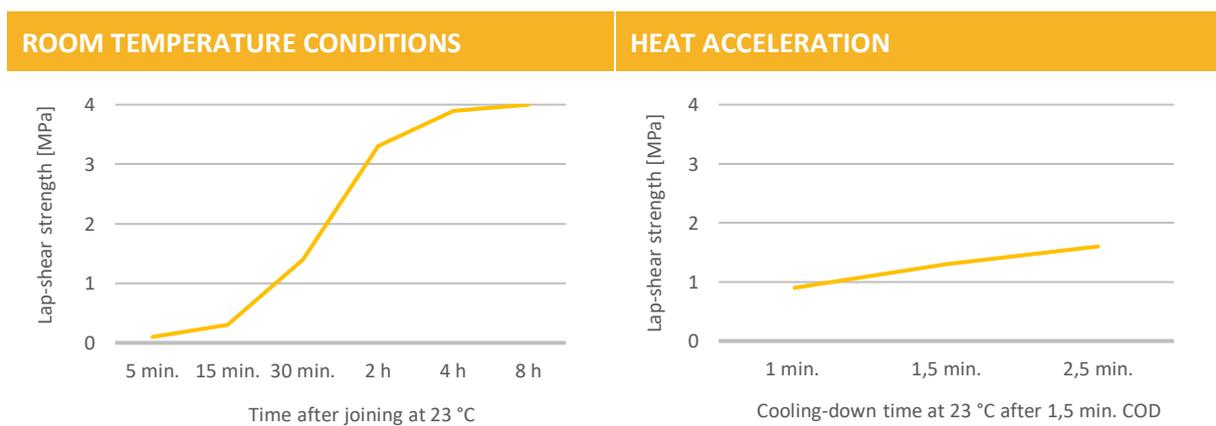
ADVANTAGES AT A GLANCE

- Process simplification due to adjusted flow behavior and the correct balance of open time and strength build-up
- Faster processes can be achieved with heat acceleration – **Curing-On-Demand (COD)**
- Superior sagging behavior allows for high applicable bead thicknesses and a remarkable tolerance compensation
- No plasticizer in the formulation minimizes risks for **Environmental Stress Cracking (ESC)**

KEY DATA

PROPERTIES	TYPICAL VALUES
Mixing ratio (by volume)	2 : 1
Tensile strength	8 MPa
Elongation at break	450 %
E-Modulus (0,5 – 5 %)	5 MPa
Tensile lap-shear strength	4 MPa
Open time at (23 °C / 50 % r. h.)	3 min.

STRENGTH BUILD-UP PERFORMANCE



Handling-strength reached within 15 min. at 23 °C ambient conditions

With heat input, handling-strength can be reached within 3 min.

NEWS FROM THE MARKET

A new Ford SUV program in the US included an iconic roof design combined with innovative materials and lightweight structures. In fulfillment of the main requirements such as short cycle times, good tolerance compensation, and ESC risk minimization on sensitive bonding partners, only SikaForce®-825 L04 delivered the right performance. The result of a strong global network in all regions and close cooperation between all parties and experts allowed Sika again to support customers in writing success stories.

OUTLOOK

Further new SikaForce®-8XX products in our pipeline – stay tuned!



Gerrit Lang

Product Manager
Assembly Line Adhesives
Supporting spoiler, liftgate
and glass bonding solutions



Florian Altenwegner

Product Manager
Assembly Line Adhesives
Supporting roof and
headlight bonding solutions

For more details on Sika solutions for Automotive contact us or visit our website

www.sika-automotive.com

LEGAL 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 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 products 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.