



TBP Converting, Inc.
Sikaflex 715 Product Data Sheet

Sikaflex[®]-715

Semi Self-Leveling Roof Membrane Sealer

Technical Product Data (typical values)

Chemical base	1C Silane-Terminated Polymer
Color	White
Cure mechanism	Moisture curing
Density (uncured)*	12.7 lb/gal
VOC (EPA method 24)	< 0.5%
Non-sag properties	Semi self-leveling
Application temperature	40° – 110°F(4-43°C)
Tack free time*	20 – 40 min.
Curing rate*	3/16"/24 hrs
Shrinkage	Low
Shore A-hardness (ASTM D 2240)	10
Tensile strength (ASTM D 412)	100 psi
Elongation at break (ASTM D 412)	460 %
Movement accommodation factor	+/- 25%
Service temperature	40° – 190°F (4-88°C)
Shelf life (storage below 80°F (27°C))	9 months

*Above testing performed at 23 °C and 50 % R.H.

Industry

Description

Sikaflex[®]-715 is a one-component silane terminated polymer (STP) sealant with excellent adhesion and UV resistance. Sikaflex[®]-715 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the Responsible Care Program.

Product Benefits

- Very good adhesion to EPDM
- Semi self-leveling
- Excellent dispensing characteristics
- Primerless adhesion to difficult substrates
- Isocyanate free
- Low VOC content
- Excellent UV resistance

Areas of Application

Sikaflex[®]-715 is suitable for sealing a wide variety of RV roofing components including, EPDM; metals such as anodized and bare aluminum; phosphated, chromated and zinc plated steel; metal primers; 2-part coatings; ceramics and plastics. Seek plastic manufacturer's advice before using on plastics that are prone to stress cracking.

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



Cure Mechanism

Sikaflex®-715 is a silane-terminated polymer which cures on exposure to atmospheric moisture. The chemical reaction is set in motion as soon as the adhesive is extruded or the cartridge is opened. Initially paste like in consistency, Sikaflex®-715 cures to form a high grade elastomer.

Chemical Resistance

Good resistance to water, various dilute acids and alkalis, vegetable oil, mineral oil, salt solutions, and kerosene. Not resistant to organic solvents, gasoline, paint thinner, strong acids and strong alkalis. Strictly follow solvent manufacturer's instructions for use and warnings. Joint design may affect long-term durability. The above information is offered for general guidance only. Advice on specific applications will be given on request. Sika RV Roof Guidelines are available by contacting the Technical Service Department of Sika Industry at 888-832-7452.

Method of Application

Surface preparation

All surfaces must be pre-cleaned with a special Sika® surface cleaner and allowed to dry for at least two minutes. For repair of existing roof sealant systems, refer to Sika RV Roof Repair Guidelines. Surfaces should be clean, dry, free of oil and grease, and of sound quality. Preliminary test for optimal adhesion should be performed. Advice on specific applications is available from the Technical Service Department of Sika Industry at 888-832-7452.

Application

Recommended application temperatures: 40°F (4°C) to 110°F (43°C). For temperatures below 40°F (4°C) it is recommended to condition substrates to approximately 70°F (21°C) until just prior to use. Make sure joint is frost-free. Cut tip to joint size. Puncture airtight seal. Install with hand or

power operated gun. For advice on selecting and setting up a suitable pump system, please contact the System Engineering Department of Sika Industry at 888-832-7452.

Tooling and finishing

Product is semi self-leveling and should not require tooling, however if necessary to facilitate tooling, wet pointing tool or finger with soap solution for best results.

Removal

Uncured Sikaflex®-715 may be removed from tools and equipment with commercially available citrus cleaner solutions or presoaked towelettes. Use care when using solvents on certain roof membranes as the membrane warranty may be voided. Once cured, product may only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin!

Overpainting

Sikaflex®-715 is not suitable for overpainting.

Limitations

Do not apply over existing roof sealants. Avoid contact with alcohols and alcohol containing substances, as it may inhibit cure. Since system is moisture-cured, permit sufficient exposure to air. Do not apply over silicones or in the presence of curing silicones or curing urethanes. For best results, use opened cartridges the same day.

WARNING: IRRITANT. Contains Silyl-terminated polyether (CAS: Mixture). May cause eye/skin/respiratory irritation. May be harmful if swallowed. **Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions.**

Handling, storage and cleanup

Avoid direct contact. Wear personal protective equipment (chemical

resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.

Clean Up

Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable environmental regulations.

HMIS

Health	2
Flammability	1
Reactivity	0
Personal Protection	C

First Aid

Eyes - Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin** - Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation** - Remove to fresh air. **Ingestion** - Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further Information

Copies of the following publications are available at www.sikaindustry.com

- Material Safety Data Sheets
- Product Data Sheets

In case of emergency call:

Chemtrec:800-424-9300
International: 703-527-3887



Sikaflex®-715 2 / 3

KEEP OUT OF REACH OF CHILDREN
NOT FOR INTERNAL CONSUMPTION
FOR INDUSTRIAL USE ONLY
KEEP CONTAINER TIGHTLY CLOSED

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

Packaging Information

Cartridge	300 ml
Drum	50 gal

Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Limited Material Warranty

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL**

PROPERTY RIGHTS HELD BY OTHERS.

Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikacorp.com or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at www.sikaindustry.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material

Safety Data Sheet prior to product use.

