



adhesives & sealants

## Sabatack® MS Polymer

Elastic adhesives and sealants

- No hazard warnings required
- Process reliability
- Certified



a strong bond



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## SABA

The name SABA has stood for high-quality products for bonding, sealing and coating for more than 80 years. We are a Dutch manufacturer that unites Research & Development with manufacturing and marketing, all under a single roof.

Our tightly organised international network supports us, helping us to rapidly recognise our customers' requirements and allowing them to influence new product development.

## What is Sabatack®?

The Sabatack® range consists of one and two-component, moisture-curing, elastic adhesives and sealants. These are used for production and repair in the metalworking and plastics industries.

Sabatack® has an MS Polymer base and as a result demonstrates many advantages over other products commonly found on the market. Sabatack® adheres superbly to metals and plastics, is UV-stable, does not blister and can be overpainted wet-on-wet. Without forgetting that Sabatack® does not contain solvents or isocyanates.

## Laboratory and production

Our laboratory is where our high-tech products are invented and then developed. Tests on adhesion, strength and compatibility are carried out regularly. This can also be done on request from the customer. Our production department is certified to a high standard of quality and is involved in the manufacture of all SABA products.

## Service

Service is a key component of our market approach. Our Application Team provides on-site support for our customers in the form of training courses, processing hints and demonstrations of the latest application techniques.

Visit our website  
[www.saba-adhesives.com](http://www.saba-adhesives.com)



## Sabatack® products for a broad range of applications

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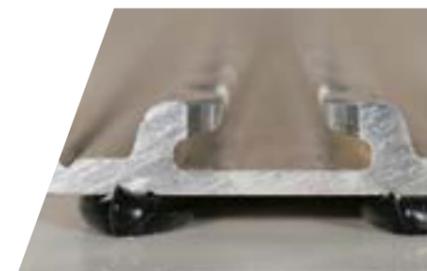
Sealing roof and floor profiles



Bonding profiles with panels



Bonding profiles with panels



Bonding retaining strips



Bonding retaining strips



Bonding lashing tracks and door profiles

### Sabatack® 720

### Sabatack® 750

### Sabatack® 750 XL

### Sabatack® 780

### Sabatack® 785 XL

### Sabatack® 790

#### Sealing & bonding

##### Principal application

Sealing seams, overlaps and joins

##### Secondary application

Bonding with easy application

##### Characteristics

Medium viscosity and soft elasticity



#### Bonding & sealing

##### Principal application

Bonding with easy application and high tensile strength

##### Secondary application

Sealing seams, overlaps and joins

##### Characteristics

Medium viscosity and high modulus of elasticity



#### Bonding & sealing, extended skin time

##### Principal application

Bonding with high wet strength (stability) and high tensile strength

##### Secondary application

Sealing seams, overlaps and joins

##### Characteristics

Medium viscosity and high modulus of elasticity, extended skin time



#### Stable bonding & sealing

##### Principal application

Bonding with high wet strength (stability) and high tensile strength

##### Secondary application

Sealing seams, overlaps and joins

##### Characteristics

High viscosity and high modulus of elasticity



#### Highly stable bonding & sealing, extended skin time

##### Principal application

Bonding with very high wet strength (stability) and high tensile strength

##### Secondary application

Sealing seams, overlaps and joins

##### Characteristics

Very high viscosity and high modulus of elasticity, extended skin time



#### Rapid bonding & sealing

##### Principal application

Bonding with rapid hardening, high wet strength (stability) and very high tensile strength

##### Secondary application

Sealing seams, overlaps and joins

##### Characteristics

High viscosity and extremely high modulus of elasticity



##### Data

Tensile strength	2,8 N/mm <sup>2</sup>
Hardness Shore A	50
Elasticity	140%

##### Data

Tensile strength	3,6 N/mm <sup>2</sup>
Hardness Shore A	55
Elasticity	240%

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Tensile strength	3,6 N/mm <sup>2</sup>
Hardness Shore A	55
Elasticity	240%

##### Data

Tensile strength	3,7 N/mm <sup>2</sup>
Hardness Shore A	65
Elasticity	280%

##### Data

Tensile strength	3,8 N/mm <sup>2</sup>
Hardness Shore A	64
Elasticity	180%



# Sabatack® products for special applications

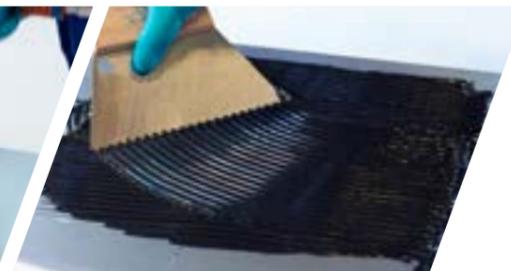
# Sabatack® products for special applications



Series bonding



Flat sealing



Flat bonding



Bonding door seals



Bonding train doors



Bonding cabins

## Sabatack® Fast

## Sabatack® 710

## Sabatack® 715

## Sabatack® 750 FS

## Sabatack® 760 XXL

## Sabatack® 760 XL<sup>HT</sup>

### Super fast bonding

#### Application

Bonding with rapid hardening, handling already after 2 hours

Ideal for series production, cycles can be cut from 10 hours (one-component system) to 2 hours

#### Characteristics

Two components, medium viscosity and high modulus of elasticity

#### Data

Tensile strength	2,8 N/mm <sup>2</sup>
Hardness Shore A	50
Elasticity	140%



### Spray-on sealant

#### Application

Large or small scale sealing or coating with structured sealant surface. Can be used as stone chip protection or noise damping

#### Characteristics

Spray or brush on

#### Data

Tensile strength	1,6 N/mm <sup>2</sup>
Hardness Shore A	60
Elasticity	135%



### Liquid sealant and adhesive

#### Principal application

Large-scale elastic bonding

#### Secondary application

Wide or overlapping seals

#### Characteristics

Can be spread or poured

#### Data

Tensile strength	2,0 N/mm <sup>2</sup>
Hardness Shore A	35
Elasticity	250%



### Fire-resistant in accordance with EN 45545-2

#### Principal application

Sealing inside and out, where the fire protection standard EN 45545-2 is stipulated

#### Secondary application

Bonding with easy application

#### Characteristics

Medium viscosity and high modulus of elasticity

#### Data

Tensile strength	3,1 N/mm <sup>2</sup>
Hardness Shore A	60
Elasticity	170%



### Window adhesive, longer open time

#### Principal application

Bonding windows with high wet strength (stability) and longer open time

#### Secondary application

Sealing windows

#### Characteristics

Very high viscosity and high modulus of elasticity, extended skin time

#### Data

Tensile strength	3,7 N/mm <sup>2</sup>
Hardness Shore A	60
Elasticity	280%



### Window adhesive, very high wet strength

#### Principal application

Bonding windows with very high wet strength (stability)

#### Secondary application

Sealing windows

#### Characteristics

Very high viscosity and high modulus of elasticity

#### Data

Tensile strength	3,7 N/mm <sup>2</sup>
Hardness Shore A	60
Elasticity	280%





## Advantages Sabatack®

## Technical data

WHEN BONDING	
Adheres to many substrates with no primer required	→ Cuts time and costs
Adheres to various substrates	→ Process reliability
Rapid hardness for handling	→ Cuts time and costs
High green strength	→ Cuts time and costs
High end strength	→ Secure structures
Bonding and sealing in a single process step	→ Cuts time and costs

WHEN SEALING	
UV-stable	→ No colour changes, no cracks
No blistering	→ Faultless appearance and sealed
Resistant to ageing and weathering	→ No colour changes, no cracks
Can be painted over wet-on-wet	→ Cuts time and costs
Rapid skin formation	→ Rapid handling, clean seams
Excellent paint tolerance	→ Low paint cracking
Excellent paint tolerance	→ Low paint cracking
High temperature-resistance	→ -40 °C to +120 °C, remains elastic to -40 °C

FOR THE WORKER	
No solvents or silicones*	→ Odourless, no hazard labels required
No isocyanates	→ Kind to workers and the environment
Barely sticks to the skin	→ Clean hands, simple cleaning
As adhesive and sealant	→ Low risk of confusion in production
Medium to high viscosity	→ Application can be chosen individually

\* All Sabatack® products are solvent-free. Sabatack® 710 and 790 are exceptions. Both contain small quantities of non-hazardous solvents.

Sabatack®	Hardness Shore A	Skin time	Open time	Viscosity	Wet strength	Cure rate	Tensile strength	Shear strength	Elongation at break	Temperature-resistance
710	60	15 min.	-	low	-	3 mm/24 hrs	1.6 N/mm <sup>2</sup>	-	135%	-40 °C to +100 °C
715	35	15 min.	60 min.	low	very low	2 mm/24 hrs	2.0 N/mm <sup>2</sup>	-	250%	-30 °C to +80 °C
720	50	12 min.	14 min.	medium	low	3 mm/24 hrs	2.8 N/mm <sup>2</sup>	1.6 N/mm <sup>2</sup>	140%	-40 °C to +100 °C
750	55	10 min.	12 min.	medium	low	3 mm/24 hrs	3.6 N/mm <sup>2</sup>	1.7 N/mm <sup>2</sup>	240%	-40 °C to +120 °C
750 FS	60	10 min.	15 min.	medium	low	3 mm/24 hrs	3.1 N/mm <sup>2</sup>	1.6 N/mm <sup>2</sup>	170%	-40 °C to +120 °C
750 XL	55	15 min.	30 min.	medium	medium	3 mm/24 hrs	3.6 N/mm <sup>2</sup>	1.7 N/mm <sup>2</sup>	240%	-40 °C to +120 °C
760 XXL	60	20 min.	30 min.	very high	very high	3 mm/24 hrs	3.7 N/mm <sup>2</sup>	1.9 N/mm <sup>2</sup>	280%	-40 °C to +120 °C
760 XL <sup>HT</sup>	60	15 min.	20 min.	very high	very high	3 mm/24 hrs	3.7 N/mm <sup>2</sup>	1.9 N/mm <sup>2</sup>	280%	-40 °C to +120 °C
780	55	8 min.	10 min.	high	high	4 mm/24 hrs	3.6 N/mm <sup>2</sup>	1.8 N/mm <sup>2</sup>	240%	-40 °C to +120 °C
785 XL	65	20 min.	25 min.	very high	very high	3 mm/24 hrs	3.7 N/mm <sup>2</sup>	1.9 N/mm <sup>2</sup>	280%	-40 °C to +120 °C
790	64	8 min.	10 min.	high	high	4 mm/24 hrs	3.8 N/mm <sup>2</sup>	2.3 N/mm <sup>2</sup>	180%	-40 °C to +120 °C
Fast	55	-	20 min.	medium	low	Handling already after 2 hours	3.2 N/mm <sup>2</sup>	1.7 N/mm <sup>2</sup>	200%	-40 °C to +120 °C



## Certificates and test reports

## Why elastic bonding and sealing?

Elastic bonding offers numerous advantages by comparison with mechanical jointing techniques, both during production and in the end product.



### Germanischer Lloyd

Certificate from the shipping classification company Germanischer Lloyd regarding suitability as adhesive and sealant for maritime use. Important for ship and yacht building, for example.

**The following have been certified:**  
 Sabatack® 750  
 Sabatack® 750 XL  
 Sabatack® 780



### FMVSS 212

Our window adhesives have been tested to FMVSS 212. FMVSS 212 is the most important crash-test certification for the automotive sector.

**The following has been tested:**  
 Sabatack® 760 series



### ISEGA

Declaration of suitability for use as adhesive and sealant in the food sector. Important for example for the production of refrigerated vehicles, food and drink sales vans and all types of food transport vehicles.

**The following have been certified:**  
 Sabatack® 720  
 Sabatack® 750  
 Sabatack® 750 XL  
 Sabatack® 780  
 Sabatack® Fast



### WHEELMARK

Products with Wheelmark certification fulfil strict fire and safety requirements. Quality requirements in the manufacturer's production process and the content of hazardous substances in the product are also taken into account.

**The following have been certified:**  
 Sabatack® 720  
 Sabatack® 750  
 Sabatack® 750 XL  
 Sabatack® 760 series  
 Sabatack® 780  
 Sabatack® 790  
 Sabatack® Fast



### EN 45545-2

To ensure the safety of all passengers in rail transport vehicles, all the materials used must conform to the European standard EN 45545-2 with respect to fire behaviour and the release of toxic substances.

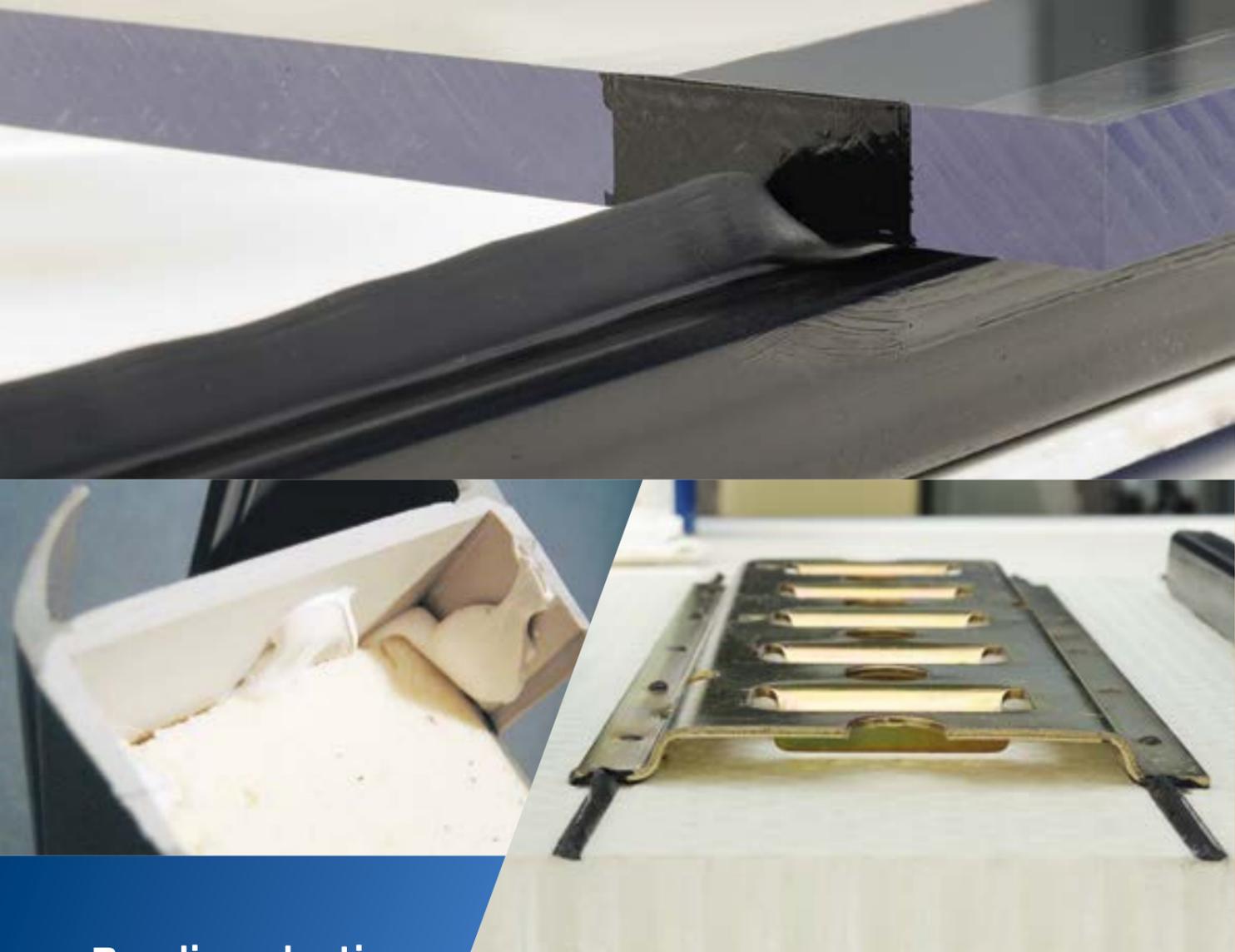
**The following has been tested:**  
 Sabatack® 750 FS

#### ADVANTAGES WITH THE END PRODUCT

Smooth surfaces without screw or rivet heads	→	Modern appearance, trendsetting
Noise and vibration damping Floor impact damping	→	Improved acoustics
More even distribution of forces, shock resistant, corrosion-free	→	Increased service life
Smooth surfaces without screw or rivet heads	→	Lower fuel costs, weight reduction

#### ADVANTAGES IN DEVELOPMENT AND PRODUCTION

Sealing and bonding in a single process step	→	Great freedom of design
Evens out tolerances, minimal pre-treatment	→	Reduction of the number of processing steps
Cold working with no warping, no damage to jointed parts	→	Great freedom of design
No noise or emissions, no high energy consumption	→	Easy application
Wide range of materials can be bonded	→	Makes material selection easier
Sealing and bonding in a single process step	→	Reduction of the number of processing steps
Cold working with no warping, no damage to jointed parts	→	Reduction of the number of processing steps



## Bonding plastics

Vehicles are increasingly becoming lighter and more beautiful. This means that plastics with significant rigidity values depending on type are increasingly being used in vehicle construction.

### PP, GRP

SABA has developed its own primer system (SABA Primer 4518) for polypropylene (PP). PP can thus be superbly bonded using Sabatack®, something that until recently would have been unthinkable. SABA is in possession of a certificate that confirms a high-strength bond for a lashing track on a MonoPan® panel (PP) with more than 6 kN tensile load per bonded lashing point. Glass-fibre reinforced polyester (GRP) also presents no difficulty for Sabatack®. No special primer is normally needed here to obtain good adhesion.

### TYPICAL MARKETS



## Bonding plastics

### PMMA, PA, PC

Available coloured or transparent. Caravan windows or blue emergency vehicle lights are made of PMMA (acrylic glass) or PC (polycarbonate). Normally a very demanding job for an adhesive, as the possibility of poor compatibility and poor adhesion has to be considered.

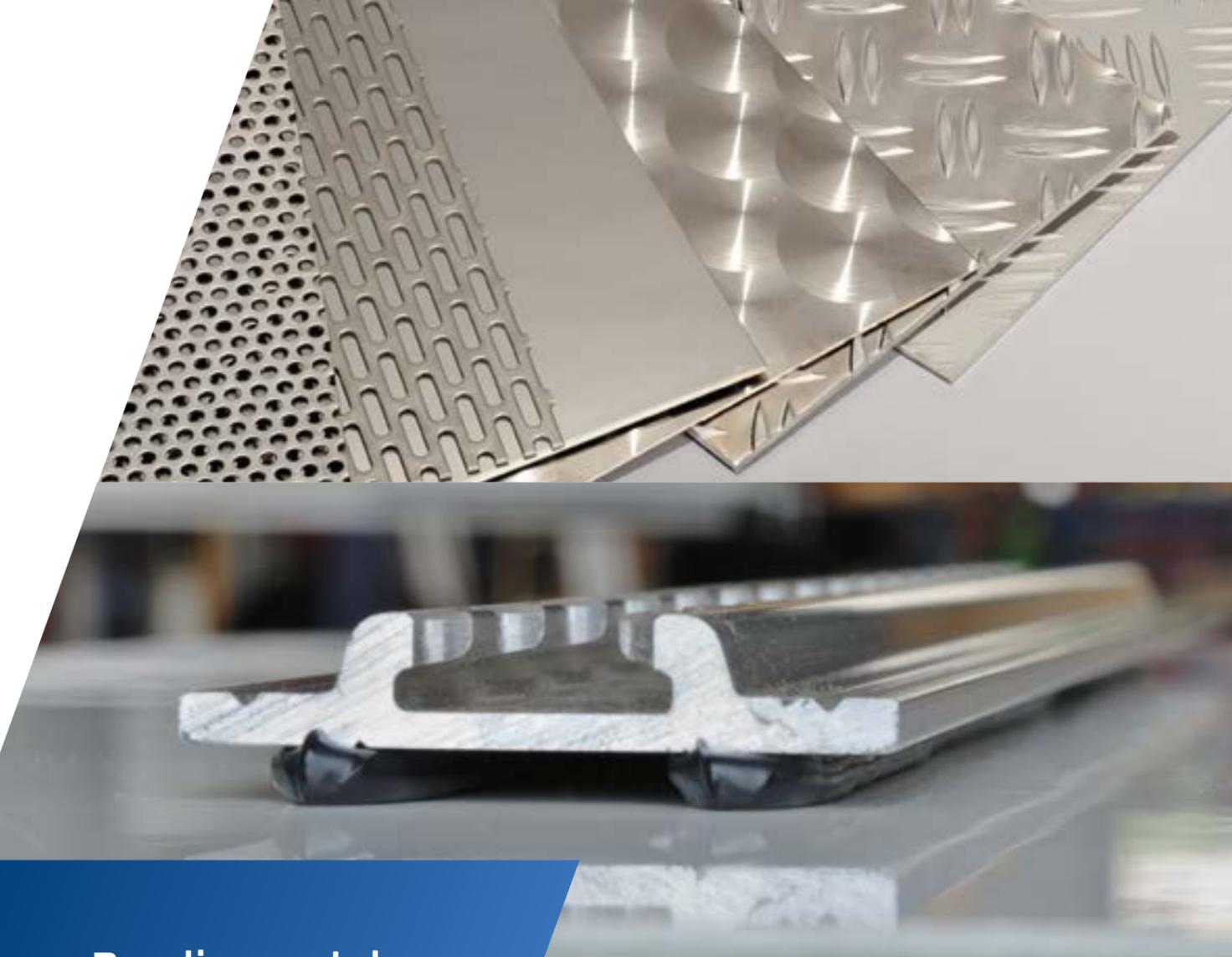
By contrast, Sabatack® bonds suitably pre-treated PMMA, PA and PC securely, durably and without tension cracks. Sabatack® has made SABA the market leader in PMMA bonding.

### ABS, PVC

ABS is often used in ambulances and caravans for the interior upholstery. PVC is found as a deck system in shipping. In vehicle construction as door seals and floor coverings.

Both these materials can be bonded securely using Sabatack®, with the particular advantage that the SABA products do not attack sensitive surfaces.





## Bonding metals

Bonding a wide variety of metal substrates is commonplace in vehicle construction.

Many bonds are used between treated and untreated steel, stainless steel and aluminium structures.

### TYPICAL MARKETS



Ambulances

Caravans

Vehicle and body construction

Buses

Rail transport vehicles

Air ducts and air-conditioning



## Bonding metals

### Aluminium untreated and anodised

Aluminium in various grades is indispensable for lightweight structures in vehicle construction.

This material is used for construction in both its untreated and finished forms.

Depending on the subsequent use and the loads, untreated aluminium will have to be pre-treated before bonding. Anodised material can generally be bonded using Sabatack® without any special pre-treatment.

### Stainless steel

Used in vehicle construction because of its high resistance and stability. Here in particular, Sabatack® exhibits superb bonding characteristics by comparison with other adhesives and sealants.

Even for critical bonding applications with highly polished stainless steel, Sabatack® bonds reliably and durably.

### Steel - untreated, galvanised, coated

Load-bearing elements in vehicle construction are normally made of steel. This is another area where Sabatack® provides process reliability, as very good bonding results can also be achieved after straightforward pre-cleaning. The type of paint must be taken into consideration with coated substrates. Good adhesion can often be obtained on powder coatings only after pre-treatment.





## Bonding and sealing of windows

With advancing technical development in the transport industry, the window is increasingly used as a structural component, which, in the bonded condition contributes to the overall stiffness of the body as much as it contributes to the improvement of driving comfort through vibration damping.

With window bonding, the Sabatack® 760 series offers noise reduction, torsion stiffness and freedom of design. Our products have been adapted to suit the most varied applications. Please ask for detailed documentation.

### UV stability, ageing and weathering resistance

The Sabatack® 760 series is UV-stable. This means that outside seals in particular retain their colour and do not crack. Resulting in good appearance and reliable sealing.

### Tested quality

Most of our window adhesives of the Sabatack® 760 series are crash tested to FMVSS 212.

### No blistering, high temperature-resistance

The Sabatack® 760 series guarantees blister-free curing, irrespective of external conditions. The blistering seen in the market with other sealants and adhesives that lead to reworking, leaks and poor appearance is completely excluded with Sabatack®.

In addition, the Sabatack® 760 series with its long-term resistance to temperatures from -40 to +120 °C is fully up to most climatic demands.

### Secure bonding

Our window adhesives are suitable for the most varied application requirements. They have high to very high green strengths and can be superbly prepared with a very short flash-off time. We also offer various reaction times for world-wide use.

### Glass and plastics

Plastic windows of polycarbonate and PMMA can also be securely bonded and sealed with Sabatack®. In this regard, see also pages 10 and 11.

## Bonding and sealing of windows



### TYPICAL MARKETS





## Sealing and painting Sealing inside & out

### Sealing and painting

An important point for the paint sprayer in production and repair work is whether the sealant and bonding agent can be overpainted and whether it is compatible with the coating. Sabatack® has shown outstanding results for many years in this field too.

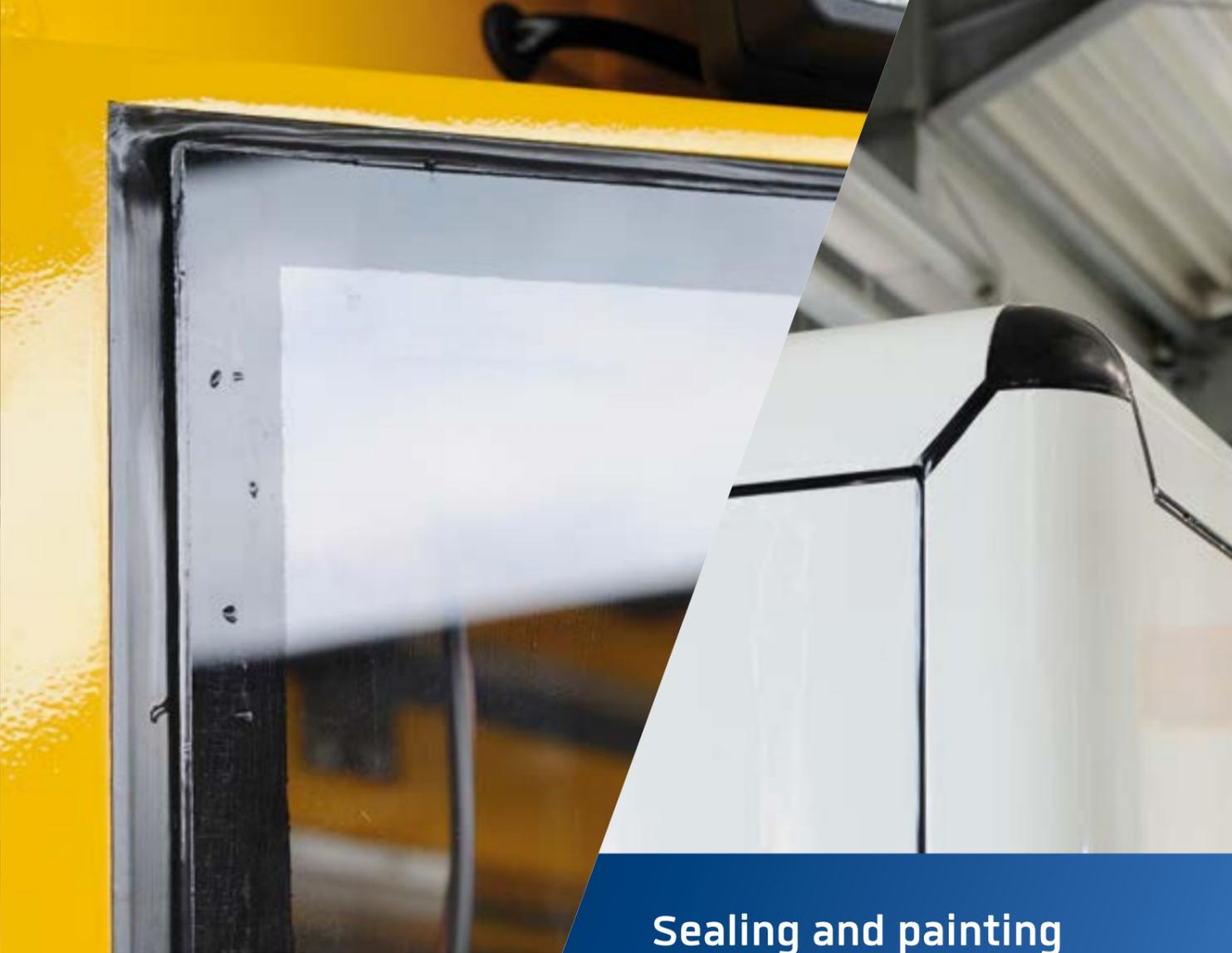
### Sealing inside & out

A sealed seam has to withstand numerous stresses. Both inside and out, the sealant must provide long-term protection against moisture and still look as good as possible. Sabatack® offers the highest level of quality for precisely these all-round properties.

### Can be painted over wet-on-wet, no blistering

Sabatack® can be painted over immediately after application, continues to harden through and does not blister.

This early painting leads to optimal paint adhesion to the sealed seam. As a whole, a perfect overall result is achieved with respect to appearance, imperviousness and paint compatibility.



## Sealing and painting Sealing inside & out

### UV stability, ageing and weathering resistance

Sabatack® is UV-stable. This means that outside seals in particular retain their colour and do not crack. Resulting in good appearance and reliable sealing.

### Clean hands, rapid skin formation

The chemical composition of Sabatack® is such that it sticks significantly less to human skin than other sealants and adhesives. Residues left after sealing and bonding work can be removed simply and quickly. The worker benefits from the rapid skin formation, as the risk of subsequent contamination of the sealed seam while it is still fresh is considerably minimised.

### No blistering, high temperature-resistance

The Sabatack® guarantees blister-free curing, irrespective of external conditions. The formation of blisters often seen in the market with other sealants and adhesives that lead to rework, leaks and poor appearance is completely excluded with Sabatack®. In addition, Sabatack® with its long-term resistance to temperatures from -40 to +120 °C is fully up to most climatic demands.



### TYPICAL MARKETS





## Sabatack®

- ✓ No hazard labels
- ✓ No isocyanates
- ✓ No solvents



## Environmental and health consciousness

Quality, working conditions and in particular environmental protection are integral aspects of SABA's business policy. SABA works continuously on improving its performance in these areas. SABA is certified in accordance with ISO 9001 and 14001 and is seeking future certification under ISO 26000 (Corporate Social Responsibility).

### Production and development

When new products are developed, risks and improvements related to HSE (health, safety and the environment) throughout the entire lifecycle are considered. By choosing the right packaging materials, SABA reduces the environmental impact as far as possible.

We constantly continue to develop our products with the aim of minimising environmental impact. The Sabatack® product range is a particularly good example of this. Environmental considerations go still deeper at SABA, as the waste products created in the production process are recycled internally and externally as far as possible.



### No hazard labels on packaging / no warnings

There are no warnings or hazard labels on Sabatack®, as a result of its safe composition. This a key positive factor for all production environments, alongside the product advantages listed on page 6.

### No isocyanates

Sabatack® contains no isocyanates. Isocyanates are used as catalysts in a large number of common sealants and adhesives. Isocyanates are hazardous to health and the environment.

Products containing isocyanates have to be processed using breathing protection and special protective clothing.

Here too Sabatack® is once again setting new standards for protecting workers and the environment.

### No solvents

Sabatack® does not contain solvents, which means that the product range is extremely safe for workers and kind to the environment overall. The products are virtually odourless.





## Pre-treatment recommendation

Long-term experience forms the basis for our pre-treatment recommendations. Observing them is essential, given the wide variety of metals, plastics and coatings on the market.

We also offer project-specific documented adhesion testing, including customer-specific recommendations on pre-treatments. Standard climatic or variable climatic conditions can be simulated during the adhesion tests.

### Standard climatic conditions

The test piece is tested after being stored in a dry room. The results are applicable to adhesive bonds that will not be subjected to moisture and/or strongly varying temperatures, and that only have to handle light mechanical loads.

### Variable climatic conditions

The test piece is tested after being stored in a moist environment under variable climatic conditions (-20 °C to +70 °C). The results are applicable to bonds that will be subjected to moisture and/or strongly varying temperatures, and that have to handle high mechanical loads.



## Tools for application

The SABA Application Team provides on-site support for our customers in the form of training courses, processing hints and demonstrations of the latest application techniques. The practical issues for the customer are prepared beforehand and discussed directly with the workers during production.

### Pumping equipment for bulk packages

For larger production runs, we work with the relevant manufacturers to provide customer-specific solutions for processing bulk packages. All Sabatack® products are also available in 20 litre tubs or 200 litre drums.

### Manually operated gun, 310 ml

Sturdily built, professional manually-operated gun for cartridges up to 310 ml. Also suitable for handling extremely viscous adhesives and sealants, without great force being exerted.

### Compressed air caulk gun, 310 ml

Professional compressed air caulk gun for cartridges of up to 310 ml. Robust, lightweight and powerful ejection. Adjustable pressure.

### Compressed air caulk gun, 600 ml

Professional compressed air caulk gun for tubes up to 600 ml. Robust, lightweight and powerful ejection. Adjustable pressure.

### Compressed air caulk gun, 490 ml

Professional compressed air caulk gun for 490 ml dual cartridges 10:1. Good weight distribution, adjustable pressure.



**SABA**  
adhesives & sealants



Rail transport vehicles



Buses



Marine



Construction machines



Caravans



Ambulances and vans



Food and drink vans



Car trailers



Delivery, courier and mail vans and trunks



Cabins and money transporters



Superstructures and coating



Fire service vehicles



Refrigerated vehicles



Containers, shelters, tanks and silos



Solar and wind power



Air ducts and air-conditioning



Cleanroom technology and dividing walls



Doors and window construction

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Our recommendations and directions for use are based on the current state of knowledge and technology. Clients and users should evaluate our products by themselves in line with their own use and requirements. We accept no liability in the event that our products are used in a way contrary to our recommendations and/or directions for use. Our general terms and conditions apply to all requests, directions for use, quotations, orders and contracts. These general terms and conditions have been filed with at the Chamber of Commerce in Arnhem under the number 09065419 and are published on our website [www.saba-adhesives.com](http://www.saba-adhesives.com). On request, we will send you a free copy of these terms and conditions. The general terms and conditions limit the liability of SABA Dinxperlo BV and stipulate that Dutch law shall apply under Dutch jurisdiction. For any disputes arising from, or related to, the requests, directions for use, quotations, orders or contracts of SABA Dinxperlo BV, the relevant court at the headquarters of SABA Dinxperlo BV is the exclusive place of jurisdiction.