



adhesives & sealants

Sabatack® adhesives & sealants
for the bus industry

- Specialized supplier
- Process optimisation
- Application & technical support



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 86 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 1-component and boosted, humidity-curing, elastic adhesives and sealants. These are used for production and repair in the metalworking and plastics processing 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.

SABA: bonding process optimisation

The SABA concept goes beyond the best sealant or adhesive. The goal is process optimisation and strengthening the competitive positions of its customers.

A support team of EAS adhesive specialists and EAE engineers is active throughout the EU for this purpose. They work on the deployment of production-increasing application equipment and structural improvements in customer production processes. SABA also stands for process security: all bonding processes are clearly documented, tested and verified. A great deal of knowledge has already been gained, although there is always the possibility of specific testing in accordance with the required standards at SABA's own testing facilities at the head office in the Netherlands.

In the coming years, SABA will continue to invest in compliance with the latest bus regulations, such as requirements on the (structural) safety of buses and specific requirements, e.g. flammability testing of adhesives used in buses and reduction of VOCs. SABA maintains a close working relationship between OEMs and bus and coach builders in the core competency of elastic bonding and future bonding techniques.

All with one goal: share our knowledge with our partners in the bus industry, to increase output in order to be more efficient with clear and simple processes to achieve the highest quality.

The right product for every application



ROOF



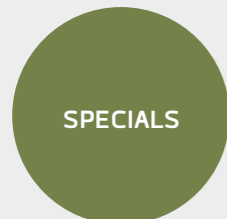
INTERIOR



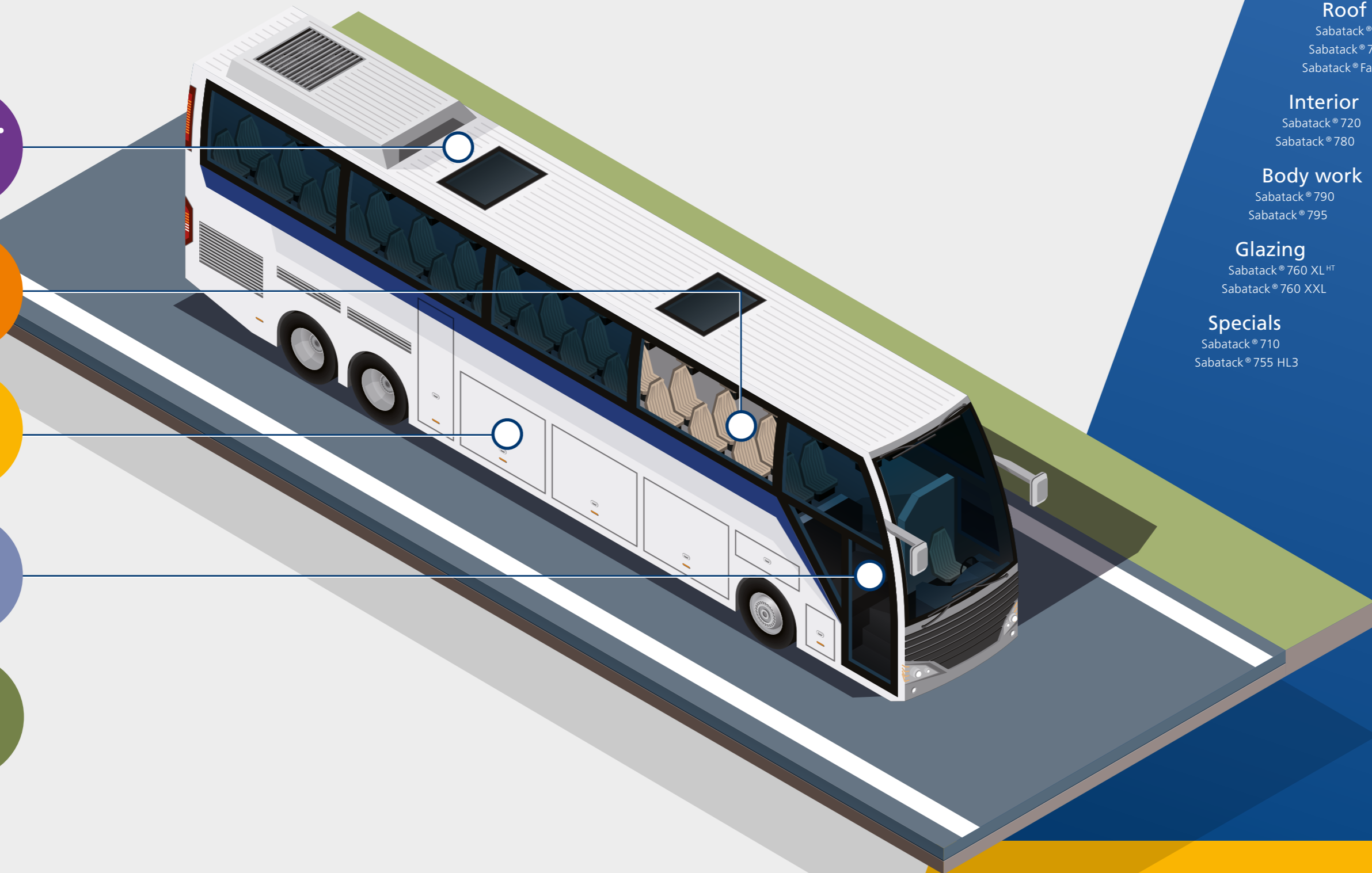
BODY WORK



GLAZING



SPECIALS



Roof

Sabatack® 720
Sabatack® 750 (XL)
Sabatack® Fast

Interior

Sabatack® 720
Sabatack® 780

Body work

Sabatack® 790
Sabatack® 795

Glazing

Sabatack® 760 XL^{HT}
Sabatack® 760 XXL

Specials

Sabatack® 710
Sabatack® 755 HL3

Advantages of elastic bonding in the bus industry:

- increased service life
- modern appearance, trendsetting
- opportunity to use lighter materials, weight reduction



ROOF



INTERIOR



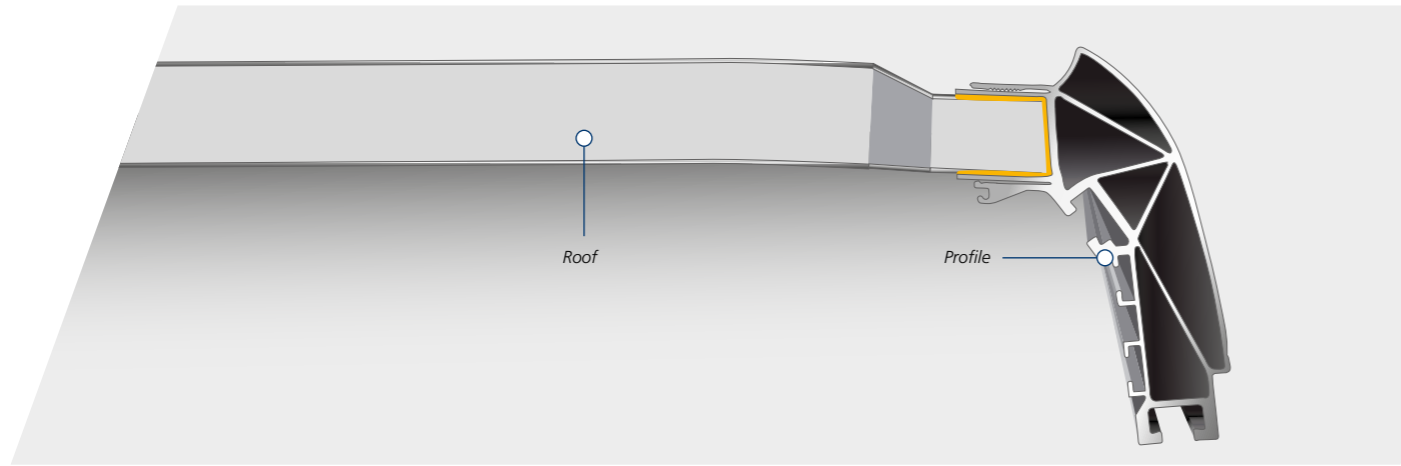
BODY WORK



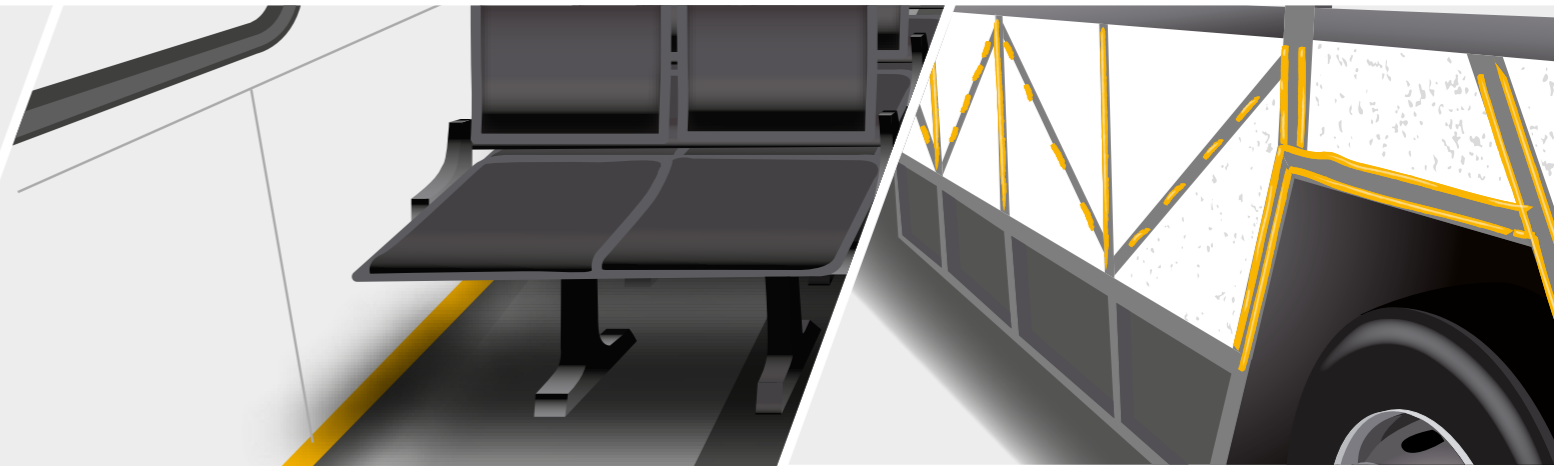
GLAZING



SPECIALS



Bonding roof and side panels



Sealing interior parts

Bonding side panels

Sabatack® 720

All-round sealing & simple bonding

Principal application

Sealing seams, overlaps and joints

Secondary application

Simple bonding applications

Characteristics

Medium viscosity and modulus of elasticity

Sabatack® 750 (XL)

All-round bonding & sealing, XL = extended open time

Principal application

Constructive bonding with high tensile strength

Secondary application

Sealing seams, overlaps and joints

Characteristics

Medium viscosity and modulus of elasticity, extended open time

Sabatack® Fast

Super fast controlled bonding

Application

Constructive bonding with controlled and fast curing, handling already possible after 2 hours

Ideal for series production, cycles can be cut from 10 hours (1-component system) to 2 hours

Characteristics

2-components, medium viscosity and modulus of elasticity



Data

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



Data

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



Data

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

Sabatack® 720

All-round sealing & simple bonding

Principal application

Sealing seams, overlaps and joints

Secondary application

Simple bonding applications

Characteristics

Medium viscosity and modulus of elasticity

Data

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



Sabatack® 780

All-round high tack bonding & sealing

Principal application

Constructive bonding with high green strength (stability) and high tensile strength

Secondary application

Sealing (vertical) seams, overlaps and joints

Characteristics

High viscosity and medium modulus of elasticity

Data

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



Sabatack® 790

Strong high tack bonding & sealing

Principal application

Constructive bonding with high green strength (stability) and very high tensile strength

Secondary application

Sealing seams, overlaps and joints

Characteristics

High viscosity and modulus of elasticity

Data

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



Sabatack® 795

Fast, strong and super high tack bonding & sealing

Principal application

Constructive bonding with high green strength (stability), fast curing and very high tensile strength

Secondary application

Sealing seams, overlaps and joints

Characteristics

High viscosity and modulus of elasticity

Data

Tensile strength	3,8 N/mm ²
Hardness Shore A	65
Elasticity	180%





ROOF



INTERIOR



BODY WORK



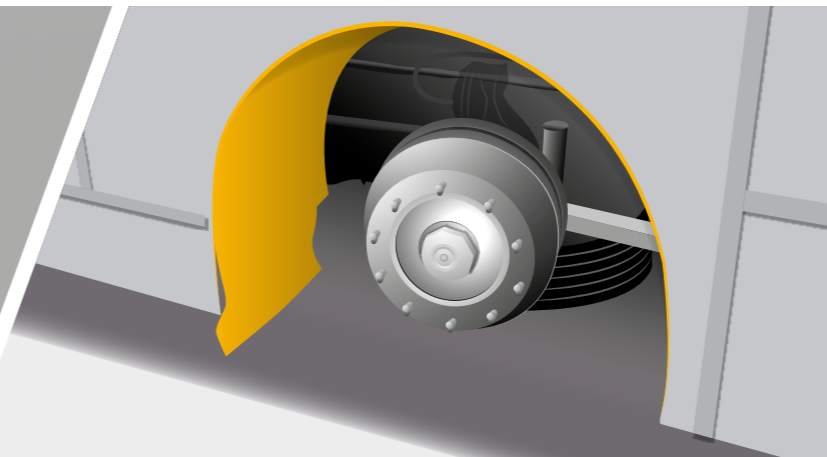
GLAZING



SPECIALS



Bonding and sealing windows



Sealing/coating of wheel arches



Fire-resistant bonding and sealing

EN 45545-2,
R22 + R23
HAZARD
LEVEL 1, 2 + 3

Sabatack® 760 XL^{HT}

Sabatack® 760 XXL

Sabatack® 710

Sabatack® 755 HL3

Super high tack window bonding & sealing

Principal application

Bonding windows with super high green strength (stability)

Secondary application

Sealing windows

Characteristics

Very high viscosity and medium modulus of elasticity



High tack window bonding & sealing

Principal application

Bonding windows with high green strength (stability)

Secondary application

Sealing windows

Characteristics

Very high viscosity and medium modulus of elasticity, extended open time



Sprayable sealing or coating

Application

Full-surface sealing or coating with structured surface

Characteristics

Low viscosity and modulus of elasticity, spray or brush on



Bonding and sealing in accordance with EN 45545-2, R22 + R23, Hazard Level 1, 2 + 3

Principal application

Fireproof constructive bonding with high tensile strength

Secondary application

Fireproof sealing seams, overlaps and joints

Characteristics

Medium viscosity and modulus of elasticity



Data

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

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

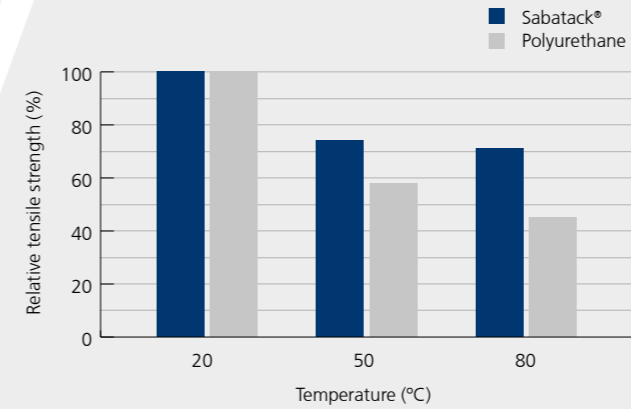
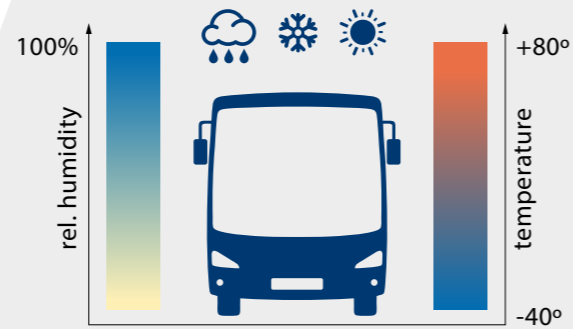
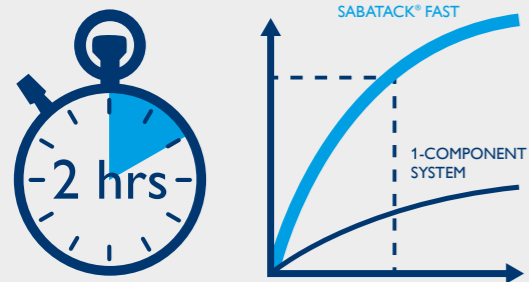
Data

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

Data

Tensile strength	3,0 N/mm ²
Hardness Shore A	60
Elasticity	180%

Advantages Sabatack® MS Polymer adhesives & sealants



Q-lab, Arizona

Innovative booster technology

Speed is one of the most important pillars of the SABA innovation program. SABA's Research & Development team continually investigates ways to improve the production process of customers through fast adhesive systems. One example of this is Sabatack® Fast. This fast-curing adhesive considerably reduces throughput time, from an average of 10 hours (for a 1-component system) to approximately two hours.

'Custom' testing

During their service life, buses drive all over the world and are exposed to all sorts of climatological influences. High temperatures in the desert of Oman or freezing cold in Scandinavia, exposure to high energy UV radiation (sunlight), salts during winter, humidity, water, ice, etc. In addition to the exposure to the climate, there are also mechanical loads. These could include vibrations or fatigue effects due to poor road conditions or continual stopping/starting.

SABA offers many possibilities to conduct accelerated ageing tests. Extreme conditions are simulated here, such as heat, humidity, oxygen, sunlight and vibrations, and long term effects of certain stress levels can be determined in a short space of time. Our Research & Development team uses standardized ageing methods in accordance with standards including DIN and ASTM, which are accepted world-wide. If required, we also work in close collaboration with external testing institutes or universities for specific tests.

Temperature resistance

Sabatack® products have a low glass transfer temperature (approximately -60 °C). This means that these products retain their flexibility even at extremely low temperatures.

Sabatack® also performs extremely well at high temperature in comparison with regular products in the market, such as polyurethanes. The diagram shows the tensile strength (Fmax) and the temperature in °C. It illustrates the fact that with products based on polyurethane technology, the tensile strength diminishes sharply as the temperature rises higher.

UV resistance

The Sabatack® series undergoes extensive UV testing and comparison in SABA's own laboratory (QUV) according to ASTM G154 and is tested externally in Arizona (USA) according to ASTM G7-13. The Q-Lab in Arizona is one of the biggest test facilities in the world for desert exposure. Arizona is an internationally recognized benchmark location for outdoor weathering, due to the year-round high sunlight intensity and high temperatures. The contract test services are ISO 17025 accredited.

In summer, the air temperature in Arizona can reach 46 °C. A black test sample can reach more than 71 °C. It is this combination of high UV levels and extremely high temperatures that makes Arizona the ideal location for testing. The Sabatack® range shows strongly improved resistance (less cracking, less chalking, discoloration and minimum dirt absorption) in comparison with other regular products in the market.



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.

No isocyanates

Sabatack® contains no isocyanates. Isocyanates are used 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.



Tools for application



Manually operated gun, 310 ml



Compressed air caulking gun, 310 ml



Compressed air caulking gun, 600 ml



Compressed air caulking gun, 490 ml

SABA Application Services 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.

Product information



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 caulking gun, 310 ml

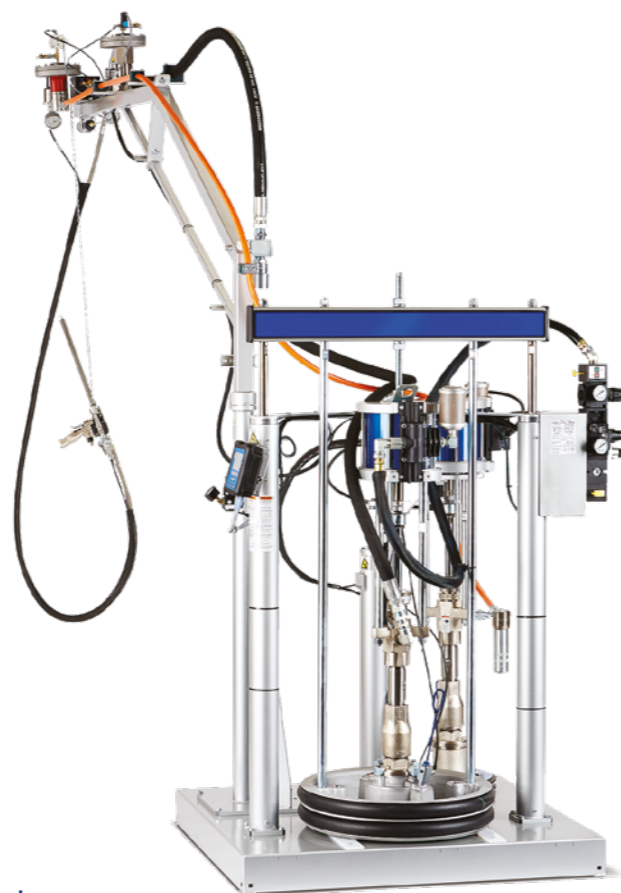
Professional compressed air caulking gun for cartridges of up to 310 ml. Robust, lightweight and powerful ejection. Adjustable pressure.

Compressed air caulking gun, 600 ml

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

Compressed air caulking gun, 490 ml

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



SABA stands for process security

Online pre-treatment tool available



The Sabatack® series is known for its excellent adhesion to many different substrates. An important product advantage, for this saves time in our customers' production processes. However, in case of certain substrates, pre-treatment with a cleaner, primer and/or activator is necessary for a good bond. SABA offers various system solutions for this, including for MonoPan® and glass-reinforced plastic (GRP).

Recognizable packaging line

Our pre-treatment products have their own unique color. As a result, they can be identified right away, with a minimal risk of a switch during production. This illustrates how SABA thinks about process security, including from a practical point of view.

User-friendly

In the development of new products, their impact on the user and the environment are explicitly taken into account. SABA has added alternative, sustainable pre-treatment products to its range. With these, we make a contribution to the users' process security and their protection.





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a strong bond