



**Dealer
Service
Bulletin**

NO.: 7SB002-24-01A

SECTION: Body

DATE: February 23, 2024

MODELS

AFFECTED: All Models

SUBJECT: Sikaflex-715 Chemical-curing Roof Sealant

PLEASE FORWARD THIS INFORMATION TO YOUR RV SERVICE, WARRANTY & PARTS MANAGERS.

Winnebago Motorhomes began using Sikaflex-715 chemical-curing roof sealant in July 2020. The characteristics of Sikaflex-715 differ from other roof sealant products and the pace of curing can vary with thickness, temperature, and humidity conditions. Regardless of environmental conditions, by the time an RV leaves our factory, Sikaflex-715 will have formed a durable, outer skin that will not be damaged by transportation or rain. It may be possible to penetrate the skin with a sharp object, exposing soft sealant, but this doesn't indicate that the product isn't functioning as designed. The product will further cure over time.

Sika has provided the information attached to help you understand the curing process and what to expect as the product cures. We hope that this information will answer some of the questions that your technicians and customers have regarding the characteristics of Sikaflex-715 vs other roof sealants.

Thank you for your continued support of Winnebago.

Dean Casad
Director of Customer Support

IMPORTANT THAT ALL PARTS AND SERVICE PERSONNEL READ AND INITIAL

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The purpose of this document is to provide information of our Sikaflex-715 Semi-self-leveling product used at Winnebago and others in the RV industry.

SIKA HAS DEDICATED CONSIDERABLE RESOURCES IN DEVELOPMENT OF A ROOF SEALANT FOR EPDM ROOF MEMBRANE.

The result is Sikaflex®-715, which is a chemical curing roof sealant that is suitable for a wide range of RV roofing components and open joints. Sikaflex®-715 has low VOC content, meaning it doesn't shrink and retains UV resistance over time.

Key Benefits of Sikaflex®-715

CROSS-LINKING DURABILITY

Born in the Sikaflex® tradition, Sikaflex®-715 is moisture cured, flexible, elastic, and durable. Traditional roof sealants are non-curing, drying, elastomer products. In essence these products never cure; rather they are more like putty. Sikaflex®-715 cures and this imparts a highly elastic internal strength to the product. **Sikaflex®-715 provides a long lasting durable sealant!**



Traditional sealant has stringy, putty like substance and easily pulls apart and breaks.



Sikaflex®-715 is a "cured" product and demonstrates good flexibility and retains its shape.



CRACK RESISTANT

Imagine a roof sealant that won't crack and the peace of mind that your RVs won't leak. Traditional roof sealants have large shrinkage characteristics, quickly dry and crack when exposed to the environment. Cracking roof sealant which causes leaks has been a persistent problem in the RV Industry.

Sikaflex®-715 is UV stable and stands up to the harshest environmental conditions. From extreme cold, to hot and humid, the product remains stable, and the RV roof is sealed.

When a sealant cracks it creates a path for water to enter the RV. Left undetected, it spells disaster for the owner and costly repairs for the manufacturer if under warranty. Mold growth as a result can cause extensive damage to the RV and personal property. **Sikaflex®-715 provides peace of mind!**



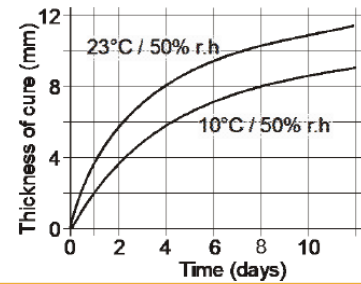
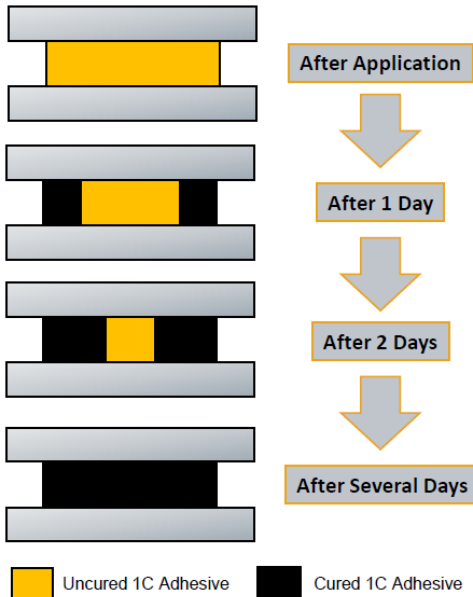
Traditional industry roof sealant showing common problematic cracking.

LOW SHRINKAGE AND LOW VOCs

Traditional roof sealants are solvent-laden, which translates into high VOCs, A typical roof sealant with a VOC of greater than 25% leads to evaporation into the atmosphere resulting in shrinkage of the sealant, allowing for water penetration. Sikaflex®-715 has a VOC content of less than 0.5% which means virtually none of the Sikaflex®-715 is evaporating and almost no VOCs are being released into the atmosphere.

Low solvent content means low shrinkage. **Sikaflex®-715 is environmentally friendly!**

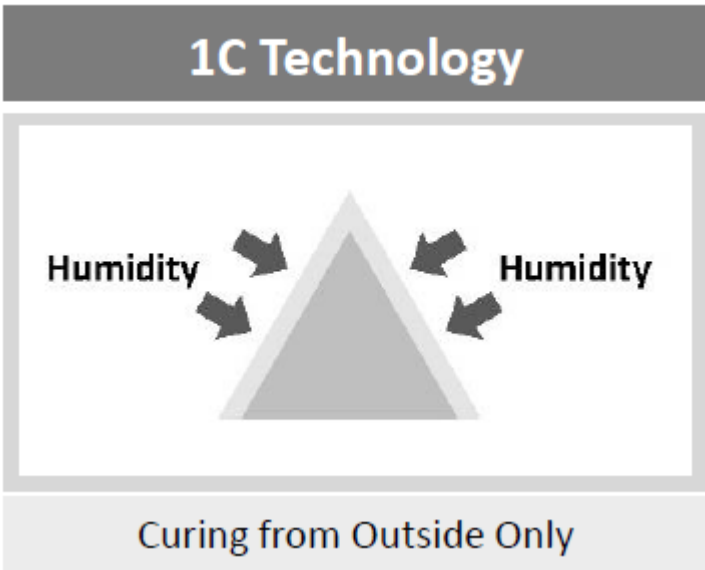
CURING PRINCIPLE
1C PUR OR STP ADHESIVE



- The curing depends on air humidity and temperature
- The curing speed slows down with increased bead thickness

- Requires significant time to reach handling and operation strength
- Large joints (5/8") need long cure time
- Process depends on working climate

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Sikaflex®-715 begins curing immediately and will skin over in about 30 minutes (depending on humidity conditions). Full curing requires 3 to 7 days depending on climate conditions and sealant thickness. The RV can be moved, transported, or driven outdoors, even in rainy conditions, after a durable skin forms on the sealant.