

Product Data Sheet

Version nos: 12/11 (replaces 12/10)

SikaForce[®]-7710 L100

Two-component polyurethane adhesive for bonding sandwich panels

Technical Product Data

Properties	Component A: SikaForce-7710 L100	Component B: SikaForce-7010 (* Refer Separate Data Sheet)
Chemical base	Polyols, filled	Isocyanate derivatives
Colour (CQP 001-1)	Beige	Brown
Colour mixed	Beige	
Curing mechanism	Poly addition	
Density (CQP 006-4)	1.6 g/cm ³ approx.	1.2 g/cm ³ approx.
Density mixed (calculated)	1.5 g/cm ³ approx.	
Mixing ratio	by volume 100	25
	by weight 100	19
Solids content	100%	100%
Viscosity ¹⁾ (CQP 538-2)	30,000 mPa·s approx. (Brookfield RVT 6/20)	250 mPa·s approx. (Brookfield RVT 2/50)
Viscosity mixed ¹⁾ (CQP 538-2)	10,000 mPa·s approx.	
Pot life ¹⁾ (CQP 536-3)	100 min. approx.	
Application temperature range	15-30°C	
Application time ¹⁾	50 min. approx. (see figure 1)	
Open time ¹⁾ (CQP 590-1)	(see diagram 1)	
Press time ¹⁾ (CQP 590-1)	(see diagram 1)	
Shore D hardness ²⁾ (DIN 53505, CQP 537-2)	80 D approx.	
Tensile strength ³⁾ (ISO 527, CQP 545-2)	13 N/mm ² approx.	
Elongation at break ³⁾ (ISO 527, CQP 545-2)	8% approx.	
Tensile shear strength ²⁾ (DIN EN 1465, CQP 546-2)	9 N/mm ² approx.	
Shelf life (SikaForce 7710 L100)	12 months	

¹⁾ Testing temperature: +23°C and 50% r.h.²⁾ Curing conditions: 21 days at +23°C and 50% r.h.³⁾ Curing conditions: 90 days at +23°C and 50% r.h.⁴⁾ CQP: Corporate Quality Procedures**Description**

SikaForce-7710 L100 is the base part of a 2-component polyurethane adhesive used with SikaForce-7010 Hardener.

This product is manufactured in accordance with ISO 9001 and ISO 14001 quality assurance systems.

Product Benefits

- Room temperature curing
- Solvent-free
- Long open time/short press time
- Approved for bulkheads according to IMO Res. A.653(16)

Areas of Application

Bonding of metal, fibre cement, wood and glass fibre reinforced polyester to expanded and extruded polystyrene foam, polyurethane foam and mineral wool in the manufacturing of sandwich elements and other constructions.

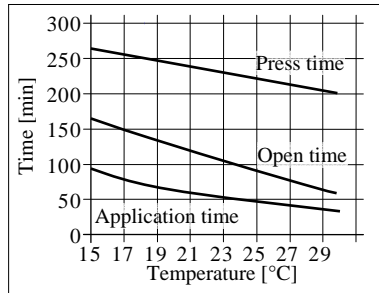
This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Cure Mechanism

The curing of SikaForce-7710 L100 takes place by chemical reaction when mixed with SikaForce 7010. Higher temperatures speed up the curing process; lower temperatures slow down the curing process.



Chemical Resistance

In case of expected chemical or thermal exposure, project related testing is recommended. Please consult Sika's Technical Service Department for advice.

Method of Application

Surface preparation

It is generally necessary to prepare the substrates for bonding to ensure optimal adhesion and strength. The preparation may consist of sanding, degreasing, corona treatment, priming or solvent wiping, etc. Metals in particular may require a primer to enhance adhesion. The type of pre-treatment must be determined by tests. Please consult Sika's Technical Service Department for advice.

Application

Coat weights between 150 and 350 m/m² are recommended depending on the substrates to be bonded. The specific coat weight for a given substrates combination is to be determined by tests. The procedure for manual application is as follows: Stir the base part thoroughly before use, add the hardener in the given ratio and stir constantly until a homogeneous mixture is obtained. Apply with a trowel before reaching half of the pot-life and join parts together within the open time. Further details can be obtained from the Sika Technical Department.

Apply with a trowel before expiry of the application time and press parts together before end of the open time.

Pressing

A minimum bonding pressure of 200 g/cm² should be used. The specific pressure is dependent on the core material and should be determined by tests. The pressure must always be below the maximum compressive strength of the core. The bonded items should not be moved during the pressing stage.

Cleaning

Uncured adhesive on tools and application equipment can be removed with Sika Remover 208. Cured adhesive can only be removed mechanically. Hands and exposed skins should be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents!

Storage Conditions

To be kept between +10°C and +30°C in a dry place. Do not expose to direct sunlight or frost. After opening of the packaging, the contents should be protected against the atmospheric humidity. The minimum temperature during transportation is 0°C for max. 6 hours. For B components refer to the actual Product Data Sheet.

Further Information

The following publications are available on request:
- Material Safety Data Sheet

Packaging Information

SikaForce 7710 L100	Drum 300 kg
SikaForce 7010	Can 5kg or 20kg Pail

Important

For information and advice on the safe handling, storage, and disposal of chemical products, users should refer to the relevant material safety data sheet(s) containing physical, ecological, toxicological and other safety related data for the appropriate type of substance.

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 product's 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.

