



PRODUCT DATA SHEET

SikaForce®-735 GG

Two-part, self-leveling, pu-grout for embedding of glass panels

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaForce®-735 GG (A)	SikaForce®-735 GG (B)
Chemical base	Polyols, filled	Isocyanate derivatives
Colour (CQP001-1)	Beige	Brown
	mixed	Beige
Cure mechanism	Polyaddition	
Density (uncured)	1.5 g/cm ³	1.2 g/cm ³
	mixed (calculated)	1.5 g/cm ³
Solid content	100 %	100 %
Mixing ratio	by volume by weight	100 : 25 100 : 20
Viscosity (CQP538-2)	Brookfield - RVT 6/20 Brookfield - RVT 2/50 (mixed) Brookfield - RVT 6/20	6 500 mPa·s ^A 250 mPa·s ^A 5 200 mPa·s ^A
Application temperature	ambient	15 – 30 °C
Pot-life (CQP536-3)	25 minutes ^A	
Shore D hardness (CQP023-1 / ISO 48-4)	60 ^B	
Tensile strength (CQP036-2 / ISO527-2)	3.8 MPa ^{B, C}	
Elongation at break (CQP036-2 / ISO 527-2)	20 % ^{B, C}	
Shelf life	12 months ^D	9 months ^D

CQP = Corporate Quality Procedure
C) test speed 10 mm/min

A) 23 °C / 50 % r.h.
D) storage between 10 °C and 30 °C

B) curing 28 days at 23 °C / 50 % r.h.

DESCRIPTION

SikaForce®-735 GG is a pourable, self-levelling, two-component polymer grout based on polyurethane resin technology and designed for glass embedding.

PRODUCT BENEFITS

- Stress-free glass embedding process
- Allows homogenous load distribution
- Long pot-life, easy to use
- Room temperature curing
- Solvent-free
- Suitable for interior and exterior applications (when sealed with Sikasil® WS product)

AREAS OF APPLICATION

- Embedding of monolithic or laminated glass panes in U-shaped support channels for standard glass railing, frameless or postless guard rail and balcony glazing

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CURE MECHANISM

The curing of SikaForce®-735 GG takes place by a chemical reaction of the two components. Higher temperatures speed up and lower slow down the curing process.

CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

METHOD OF APPLICATION

Consult the General Guideline "Glass Embedding" for construction details and dimensions prior to the product application.

Surface Preparation

Surfaces must be clean and dry.

Application

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

The procedure for manual application is as follows:

Stir the SikaForce®-735 GG (A) thoroughly until it is mixed homogeneously. Add the SikaForce®-735 GG (B) in the specified ratio into the SikaForce®-735 GG (A) and stir until a homogeneous mixture is obtained. Apply before reaching half of the pot-life and join parts together within the open time. Consider that if mixed in bigger masses the exothermic reaction can influence the pot-life and open time significantly. Prevent adhesion to glass with a release agent or bond breaker.

Outdoor Application

To protect the embedding material from UV radiation it is required to apply a bead of Sikasil® WS sealant on top.

SikaForce®-735 GG must be cured 24 hours prior to the sealant application.

Removal

Uncured SikaForce®-735 GG may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin.

Application Limits

- The compatibility of setting blocks, backer rods and other accessory materials in direct and indirect contact with SikaForce®-735 GG have to be approved by Sika in advance. It is recommended to use setting blocks made of SikaForce®-735 GG
- Avoid any stress caused by thermal dilatation. The mechanical properties of SikaForce®-735 GG change depending on service temperature.
- Impacts on glass and U-shaped support channel must be verified.

STORAGE CONDITIONS

SikaForce®-735 GG has to be stored between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has to be protected against humidity.

Minimum temperature during transportation is -20 °C for max. 7 days.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry. Copies of the following publications are available on request:

- Safety Data Sheets
- General Guideline
Glass Embedding

PACKAGING INFORMATION

SikaForce®-735 GG (A)

Pail	15.14 L
	3.78 L

SikaForce®-735 GG (B)

Can	3.78 L
	0.94 L

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

DISCLAIMER

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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

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