Industry

SikaForce®-7712 L35

Two component low viscous sandwich panel adhesive

Technical Product Data

Properties		Component A SikaForce®-7712 L35	Component B SikaForce®-7010
Chemical base		Polyols, filled	Isocyanate derivatives
Colour (CQP[1] 001-1)		Beige	Brown
Colour mixed		Beige	
Cure mechanism		Poly addition	
Density (CQP 006-5)		1.4 g/cm³ approx.	1.2 g/cm³ approx.
Density mixed (calculated)		1.3 g/cm³ approx.	
Solid content		100 %	
Mixing ratio	by volume	100 : 30	
	by weight	100 : 26	
Viscosity[2] (CQP 538-2)	Brookfield - RVT 6/20	9'500 mPa·s approx.	
	Brookfield - RVT 2/50		250 mPa·s approx.
Viscosity (mixed)	Brookfield - RVT 4/20	4'000 mPa·s approx.	
Application temperature		15 - 30°C	
Pot life[2] (CQP 536-3)		35 min. approx.	
Open time[2] (CQP 590-3)		60 min. approx.	
Press time[2, 4]		120 min. approx.	
Shore D hardness (CQP 537-2)		70 approx.	
Tensile strength[3] (CQP 545-2 / ISO 527)		10 N/mm² approx.	
Elongation at break[3] (CQP 545-2 / ISO 527)		35 % approx.	
Shelf life (storage between 10 and 30°C)		6 months	9 months

[1] CQP = Corporate Quality Procedure [2] 23°C / 50% r.h. [3] Curing 4 weeks at 23°C / 50% r.h.
[4] 1 MPa tensile strength

Description

SikaForce®-7712 L35 is the base part of a two component, low viscosity, low density polyurethane adhesive used with SikaForce®-7010 hardener.

Product Benefits

- Room temperature curing
- Solvent free
- Low viscosity
- Low density

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. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Cure Mechanism

The curing of SikaForce®-7712 L35 takes place by chemical reaction of the two components. Higher temperatures speed up and lower temperatures slow down the curing process.

Chemical Resistance

In case of chemical or thermal exposure, we recommend a project related testing. Please consult our Technical Service Department of Sika Industry for advice.

Method of Application

Surface preparation

Usually it is necessary to prepare the substrates for bonding to ensure optimal adhesion and strength. Based on the surface and type of material, a physical or chemical pre-treatment might be required after the cleaning process. Type of pre-treatment must be determined by tests.

Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

Coat weights between 150 and 350 g/m² are recommended depending on the substrates to be bonded. The specific coat weight for a given substrate 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 trowel before reaching half of the pot life and join parts together within the open time. Further details can be obtained from the Technical Service Department of Sika Industry.

For automated applications please contact the System Engineering Department of Sika Industry.

Pressing

An adequate bonding pressure to obtain a void-less contact between the substrates and adhesives is necessary. The specific pressure is, however, dependent on the core material and must be determined by tests. The pressure must always be below the maximum compressive strength of the core. After starting the press process do not release the pressure until the press time has elapsed.

Removal

Uncured SikaForce®-7712 L35 may be removed from tools and equipment with SikaForce®-7260 Cleaner. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Hand clean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Storage conditions

SikaForce®-7712 L35 has to be kept 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 must be protected against humidity.

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

For B component refer to the actual Product Data Sheet.

Further Information

Copies of the following publications are available on request:

- Safety Data Sheet

Value Bases

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

Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

Further information available at:
www.sika.ch
www.sika.com

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