



PRODUCT DATA SHEET

# SikaForce®-800 Red

Fast curing profile and surface filler for blade repair applications

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaForce®-800 Red (A)	SikaForce®-800 (B)
Chemical base	Polyols	Isocyanate derivatives
Colour (CQP001-1)	Light red	Brown
	mixed	Light red
Cure mechanism	Polyaddition	
Density (uncured)	mixed (calculated) 1.30 kg/l <sup>A</sup>	
Solid content	100 %	
Mixing ratio	by volume 100 : 50	
Viscosity (CQP029-4)	25 mm PP, d = 1 mm, 10 s <sup>-1</sup> 35 Pa·s <sup>A</sup>	13 Pa·s <sup>A</sup>
Consistency	Thixotropic paste	
Application temperature	5 – 30 °C	
Working time	2.5 minutes <sup>A</sup>	
Sanding time	at 15 °C 40 minutes	
	at 23 °C 30 minutes	
	at 30 °C 15 minutes	
Elongation at break (CQP036-2 / ISO 527)	2.5 % <sup>A, B</sup>	
Glass transition temperature (ISO 11357-2)	55 °C	
Shelf life	15 months <sup>C</sup>	

CQP = Corporate Quality Procedure  
C) storage between 10 and 30 °C

A) 23 °C / 50 % r.h.

B) tested at 2 mm/min

**DESCRIPTION**

SikaForce®-800 Red is a two component polyurethane based profile and surface filler that works best at temperature above 15 °C. If ambient temperatures are lower than 15 °C it is advisable to use SikaForce®-800 Blue.

**PRODUCT BENEFITS**

- Superior mixing, application and tooling properties
- Very good adhesion to GFRP
- Non-sag up to layer thicknesses of approx. 20 mm
- Fast sanding time
- Easy to sand, does not clog the sandpaper

**AREAS OF APPLICATION**

SikaForce®-800 Red is used for profile shaping and surface filling of damaged rotor blades in the wind turbine industry. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

## CURE MECHANISM

The curing of SikaForce®-800 Red takes place by a chemical reaction of the two components. Higher temperatures speed up the curing process and lower slow it down.

## CHEMICAL RESISTANCE

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

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. After the cleaning process, a physical or chemical pre-treatment might be required, depending on surface and type of material. The type of pre-treatment must be determined by tests.

### Application

For the cartridge application use a suitable manual or a compressed air piston-type cartridge dispenser. To ensure good mixing quality the defined static mixer is to be used.

Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose the first few cm of the bead before the application.

## Removal

Uncured SikaForce®-800 Red 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.

## STORAGE CONDITIONS

SikaForce®-800 Red has to be kept between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost.

Minimum temperature during transportation is -20 °C for maximum 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

## PACKAGING INFORMATION

SikaForce®-800 Red

Coaxial cartridge	195 ml
Mixer: MGQ 08-20T by medmix	

Dual cartridge	400 ml
Mixer: MFQ 08-24T by medmix	

## 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](http://www.sika.ca)

## PRODUCT DATA SHEET

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