

Product Data Sheet

Version 2/2012 (08/2016)

SikaForce®-7710 L35

General-Purpose Sandwich Panel Adhesive

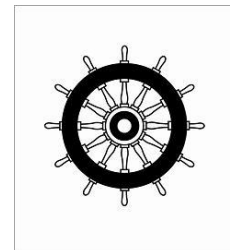
Technical Data

		Comp. A: SikaForce®- 7710 L35	Comp. B: SikaForce®- 7010
Chemical Base		Polyols, filled	Isocyanate derivatives
Colour (CQP ¹ 001-1) Colour - Mixed		Beige	Brown
Cure Mechanism		Polyaddition	
Density (CQP 006-5) Density - Mixed (calculated)		1.6 g/cm ³ approx	1.2 g/cm ³ approx
Mixing Ratio		1.5 g/cm ³ approx	
		100 : 25 100 : 19	
Solids Contents		100%	100%
Viscosity ² (CQP 538-2) Brookfield - RVT 6/20 Brookfield - RVT 2/50		30,000 mPas approx	250 mPas approx
Viscosity (mixed) Brookfield - RVT 6/20		10,000 mPas approx	
Application Temperature		15°C to 30°C	
Pot Life ² (CQP 536-3)		35 minutes approx	
Open Time ² (CQP 590-01)		80 minutes approx	
Press Time ² (CQP 590-01)		125 minutes approx	
Shore D-Hardness ² (CQP 537-2)		80 D approx	
Tensile Strength ³ (CQP 545-2/ISO 527)		11 N/mm ² approx	
Elongation at Break ³ (CQP 545-2/ISO 527)		9% approx	
Tensile Lap-Shear Strength ³ (CQP546-2/ISO 4587)		9 N/mm ² approx	
Shelf Life Intermediate Bulk Container (IBC)		6 months	9 months
(storage between 10 and 30°C) Smaller Packaging		12 months	
¹ CQP: Corporate Quality Procedure ² 23°C and 50% Relative Humidity			

Description SikaForce®-7710 L35 is the base-part of a two-component polyurethane adhesive used with the hardener, SikaForce®-7010. SikaForce®-7710 L35 is manufactured in accordance with the ISO 9001/14001, quality assurance system.

- 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 SikaForce®-7710 L35 is used for bonding metals, 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 applicators only. Tests with actual substrates and conditions must first be performed to ensure adhesion and material compatibility.



SikaForce®-7710 L35

Cure Mechanism	SikaForce®-7710 L35 cures as the result of a chemical reaction between the two components. Higher temperatures speed up the curing process, while lower temperatures slow it down.
Chemical Resistance	We recommend project-related testing based on anticipated chemical and/or thermal exposure. Please consult the Technical Services Department of Sika Industry for advice.
Surface Preparation	It is reasonable to expect that the surfaces will need to be adequately prepared prior to bonding if optimal adhesion and strength is to be achieved. Based on the surface condition and type of material, physical and/or chemical pre-treatment may be required after the cleaning process. The type of pre-treatment must be determined by testing. Advice on specific applications is available from the Technical Services Department of Sika Industry.
Application	Coat weights between 150 and 350 g/m ² are recommended depending on the substrates to be bonded. The specific coat weight for a given substrate combination is to be determined by testing. 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 product reaches half of its Pot Life and join the parts together within the Open Time. Further details can be obtained from the Technical Services Department of Sika Industry. For automated applications, contact the System Engineering Department of Sika Industry.
Pressing	An adequate bonding pressure to obtain a voidless contact between the substrates and the adhesive is necessary. The specific pressure is, however, dependent upon the core material and must be determined by testing. 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®-7710 L35 may be removed from tools and equipment with SikaForce®-7260 Cleaner. Cured material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® HandClean towels or other suitable industrial hand cleaner and water. Do not use solvents!
Storage	SikaForce®-7710 L35 must be stored in a dry area at a temperature between 10°C and 30°C. Do not expose to direct sunlight or frost. After the packaging is opened, the contents should be protected from humidity. Minimum temperature during transportation is -20°C for a maximum of 7 days. For Component B, please refer to its individual Product Data Sheet.
Further Information	Copies of the following publications are available upon request: Material Safety Data Sheet.
Packaging	Component A: 25 kg pails; 300 kg drums, 1500 kg IBC. Component B: 1 kg cans; 5 kg cans; 20 kg pails; 250 kg drums, 1200 kg IBC. Two-Part Cartridges: 1.2 kg.
Value Bases	All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.
Health and Safety Information	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. Product Data Sheets and Material Safety Data Sheets are available on our website at: www.sika.ca or via your local Sika representative.

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, within their shelf life. 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under www.sika.ca.

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