

# SikaForce<sup>®</sup>-7710 L35

## General purpose sandwich panel adhesive

### Technical Product Data

Properties	Component A: SikaForce <sup>®</sup> -7710 L35	Component B: SikaForce <sup>®</sup> -7010
Chemical base	Polyols, filled	Isocyanate derivatives
Color (CQP <sup>1)</sup> 001-1)	Beige	Brown
Colour mixes	Beige	
Curing mechanism	Poly addition	
Density (CQP 006-4)	1.6 g/cm <sup>3</sup> approx.	1.2 g/cm <sup>3</sup> approx.
Density mixed (calculated)	1.5 g/m <sup>3</sup> approx.	
Mixing ratio	by volume 100 : 25	
	by weight 100 : 19	
Solids content	100%	100%
Viscosity <sup>2)</sup> (CQP 538-2)	Brookfield - RVT 6/20 Brookfield - RVT 2/50	30,000 mPa.s approx. 250 mPa.s approx.
Viscosity (mixed)	Brookfield - RVT 6/20	10,000 mPa.s approx.
Pot life <sup>2)</sup> (CQP 536-3)	35 min. approx.	
Application temperature range	15 - 30°C	
Open time <sup>1)</sup> (CQP 590-1)	80 min. approx.	
Press time <sup>1)</sup> (CQP 590-1)	125 min. approx.	
Shore D Hardness <sup>2)</sup> (CQP 537-2)	80 D approx.	
Tensile strength <sup>3)</sup> (ISO 527, CQP 545-2)	11 N/mm <sup>2</sup> approx.	
Elongation at break <sup>3)</sup> (ISO 527, CQP 545-2)	9% approx	
Tensile shear strength <sup>3)</sup> (CQP 546-2, ISO 4587)	9 N/mm <sup>2</sup> approx	
Shelf life (store between 10 and 30°C)	12 months	9 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23°C / 50% r.h.

<sup>3)</sup> Curing according to CQP 542-2

#### Description:

SikaForce<sup>®</sup>-7710 L35 is the base part of a 2-component polyurethane adhesive used with SikaForce<sup>®</sup>-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 polystyrene, polyurethane foams and mineral wood in 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 L35 takes place by chemical reaction of the two components. Higher temperatures speed up the curing process; lower temperatures slow down the curing process.

**Chemical Resistance:**

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

**Method of Application:***Surface preparation*

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

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

*Application*

Coat weights between 150 and 350 g/m<sup>2</sup> are recommended depending on the substrates to be bonded. The specific coat weight for a given substrate combination should be determined by tests.

Automated application: Bead application requires metering and application equipment which can be supplied by Sika.

Manually: 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 press parts together before end of the open time. Please consult our Technical Service for detailed information.

**Pressing**

An adequate bonding pressure to obtain void-less contact between the substrates is necessary. 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*

Non-cured adhesive on tools and application equipment can be removed with SikaForce®-7260 Cleaner. Cured adhesive can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean Towel or 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 atmospheric humidity. The minimum temperature during transportation is 0°C for a maximum 6 hours.

For B component refer to the actual Product Data Sheet

**Further Information:**

The following publications are available on request:

- Material Safety Data Sheet

**Packaging Information:**

Component A Resin	Drum 300 kg
Component B Resin	Drum 250 kg
	Can 5 kg

**Important:**

For information and advice on the safe handling, storage, and disposal of chemical products, users should refer to the relevant 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 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 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 Australian version of the Product Data Sheet for the product concerned, copies of which will be supplied on request.

