

# SikaForce®-7723 L175

Structural adhesive with long open time for sandwich panel bonding

## Technical Product Data

Properties	Component A SikaForce®-7723 L175	Component B SikaForce®-7010
Chemical base	Polyols, filled	Isocyanate derivatives
Colour (CQP <sup>1</sup> 001-1)	Beige	Brown
Colour mixed	Beige	
Cure mechanism	Polyaddition	
Density (CQP 006-5)	1.6 g/cm <sup>3</sup> approx.	1.2 g/cm <sup>3</sup> approx.
Density mixed (calculated)	1.5 g/cm <sup>3</sup> approx.	
Solids content	100%	100%
Mixing ratio	by volume by weight	100 : 25 100 : 19
Viscosity <sup>2</sup> (CQP 538-2)	Brookfield - RVT 6/10 Brookfield - RVT 2/50	20'000 mPa·s approx. 250 mPa·s approx.
Viscosity (mixed)	Brookfield - RVT 6/20	6'500 mPa·s approx.
Application temperature	15 - 30°C (60 - 85°F)	
Pot-life <sup>2</sup> (CQP 536-3)	175 min. approx.	
Open time <sup>2</sup> (CQP 590-1)	150 min. approx.	
Press time <sup>2</sup> (CQP 590-1)	300 min. approx.	
Shore D hardness <sup>2</sup> (CQP 537-2)	65 D approx.	
Tensile strength <sup>3</sup> (CQP 545-2 / ISO 527)	5 N/mm <sup>2</sup> approx.	
Elongation at break <sup>3</sup> (CQP 545-2 / ISO 527)	18% approx.	
Shelf life (storage between 10 and 30°C)	1000 l smaller packaging	6 months 12 months 9 months

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

<sup>2)</sup> +23°C / 50% r.h

<sup>3)</sup> Curing conditions: 21 days at 23°C / 50% r.h.

### Description:

SikaForce®-7723 L175 is the base part of a 2-component polyurethane adhesive used with SikaForce® 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

### Areas of Application

SikaForce®-7723 L175 is designed for bonding of metal, fibre cement, wood and glass fibre reinforced polyester to polystyrene, polyurethane foams and mineral wool 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-7723 L175 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

It is generally necessary to prepare the items for bonding to ensure optimal adhesion and strength. The pre-treatment may consist of sanding, degreasing, corona treatment, priming, etc. Especially on metals, it may be an advantage to use a primer. Type of pre-treatment must be determined by tests. Please consult our Technical Service for advice.

#### 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.

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 voidless contact between the substrates is necessary. The specific pressure is, however, dependent on the core material and should 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®-7723 L175 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® 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 maximum 6 hours.

For the component B 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	Pail	20 kg
	Drum	300 kg
Component B Hardener	Can	5 kg
	Drum	250 kg

### Important

For information and advice on the safe handling, storage, and disposal of chemical products, users should refer to the relevant Material 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.



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