

# SikaSense<sup>®</sup> -4710

## 2C-contact adhesive for Hypalon

### Technical Product Data:

Chemical Base	2C Polychloroprene
Colour	White- light yellowish
Solid content (CQP 002-0)	21% approx.
Density (CQP 006-3)	0.9 kg/l approx.
Viscosity, 20°C/ Brookfield RVT, [Sp. 2/20 Rpm]	1300 mPas approx
Flash Point (CQP007-0)	<21°C
Curing agent (hardener)	SikaCure <sup>®</sup> -4960
Mix ratio	5-10 parts by weight curing agent to 100 parts by weight polymer solution
Pot life	3 hours approx. <sup>2)</sup>
Bonding process	Contact bonding at room temperature <sup>1)</sup> or hot contact bonding
Coverage	150-200 g/m <sup>2</sup> , wet (depends on substrate)
Method of application	Roller, brush or tooth-comb
Drying conditions (flash-off time before fitting) (CQP 565-1)	5 min. approx.
Open time <sup>1)</sup> (CQP567-1)	40 min. approx. (with reactivation up to 120 min at 80°C)
Application temperature	15 to 25°C
Time to reach maximum strength	3 to 4 days at room temperature <sup>1)</sup>
Shelf life in unopened can	12 months at the storage temperature of 5 to 25°C, SikaSense <sup>®</sup> is sensitive to frost, store above +5°C. An excess of the recommended storage temperature during transport is not critical

<sup>1)</sup> 23°C and 50% relative humidity

<sup>2)</sup> high air humidity, pot life is reduced

### Description:

SikaSense<sup>®</sup>-4710 is an approved fast drying 2C polychloroprene contact adhesive for Hypalon material which is used for production of inflatable boats and life raft's. SikaSense<sup>®</sup>-4710 is manufactured in accordance with the ISO 9001/14001 quality assurance system

### Product benefits:

- Very short flash-off time
- Excellent water resistance
- High initial strength
- Free of toluene
- Excellent ageing resistance

### Areas of application:

SikaSense<sup>®</sup>-4710 provides an excellent adhesion to Hypalon materials and results in an elastic, strong and durable bond. SikaSense<sup>®</sup>-4710 is designed for the production and repair of inflatable boats and life raft's.

**Curing mechanism:**

SikaSense<sup>®</sup>-4710 cures primarily due to the evaporation of the solvent. Final strength is attained in three to four days after the completion of a chemical curing process. At elevated temperatures the chemical curing is significantly quicker.

**Chemical resistance**

SikaSense<sup>®</sup>-4710 is resistant to all types of water, temporarily resistant to weak acids and caustic solutions, fuels, mineral oils, vegetable and animal fats and oils, not resistant to organic acids, alcohol and paint thinners. These are only general indications. In case of expected chemical or thermal exposure, we recommend a project related testing or refer to a Technical Representative.

**Method of application:***Mixing:*

The normal mixing ratio of SikaSense<sup>®</sup>-4710 (polymer solution) in combination with SikaCure<sup>®</sup>-4960 is 100 parts by weight polymer solution to 8 parts by weight of the curing agent. The curing agent is added into the continuously stirred adhesive. Mix for an additional minute to obtain a homogeneous composition. Care should be taken to avoid air inclusion. The pot life is about 3 hours at room temperature.

*Surface preparation:*

The adhesion surfaces must be clean, dry and free of oils and fats and then grind the Hypalon surface with a 90 grit abrasive or grinding machine. Clean the surface from dust after the grinding process with SikaSense<sup>®</sup>-8200. The adhesive generally is applied with a suitable roller, tooth-comb or a brush. For the use in automatic application systems a suitable filter system is recommended.

*Application*

For two side contact bonding it is mandatory to fit and press the parts together within the pot life of the mix. Care must be taken to avoid the formation of adhesive pools on the bonding surfaces. Entrapped solvent provoke a reduced bonding strength.

The processing temperature must be at least 5°C and less than 35°C. Optimal working temperature is between 15 °C and 25 °C.

**Important**

Once the can or pail is opened, SikaSense<sup>®</sup>-4710 must be used in a short time.

*Cleaning of tools*

SikaSense<sup>®</sup>-8200 can be used to clean the tools from uncured adhesive residues. Cured adhesive can only be removed by laborious mechanical means.

**Further information:**

Copies of the following publication are available on request:

- Material Safety Data Sheet

**Packaging information:**

Pail	23 kg
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**Important**

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheet containing physical, ecological and other safety related data.

**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 Technical Data Sheet for the product concerned, copies of which will be supplied on request.



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