SikaForce®-7727 L8 W
Thixotropic, low outgassing filter adhesive with short curing time

Technical Product Data (typical values) *Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

<table>
<thead>
<tr>
<th>Properties</th>
<th>Component A SikaForce®-7727 L8 W</th>
<th>Component B SikaForce®-7010</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical Base</td>
<td>Polyols</td>
<td>Isocyanate derivatives</td>
</tr>
<tr>
<td>Color (CQP 001-1)</td>
<td>White</td>
<td>Brown</td>
</tr>
<tr>
<td>Color mixed</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cure mechanism</td>
<td>Beige</td>
<td></td>
</tr>
<tr>
<td>Density (CQP 006-5)</td>
<td>8.3 lbs/gallon</td>
<td>10 lbs/gallon</td>
</tr>
<tr>
<td>Density mixed (calculated)</td>
<td>9.2 lbs/gallon</td>
<td></td>
</tr>
<tr>
<td>Solids content</td>
<td>100%</td>
<td>100%</td>
</tr>
<tr>
<td>Mixing ratio</td>
<td></td>
<td></td>
</tr>
<tr>
<td>by volume</td>
<td>100 : 34</td>
<td>100 : 40</td>
</tr>
<tr>
<td>by weight</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Viscosity2 (CQP 538-2)</td>
<td>1350 mPa·s approx.</td>
<td>250 mPa·s approx.</td>
</tr>
<tr>
<td>Brookfield –RVT 4/10</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Viscosity (mixed)</td>
<td>Thixotropic</td>
<td></td>
</tr>
<tr>
<td>Application temperature</td>
<td>59-86°F (15-30°C)</td>
<td></td>
</tr>
<tr>
<td>Pot-life2 (CQP 536-3) (10 g sample)</td>
<td>9 min. approx.</td>
<td></td>
</tr>
<tr>
<td>Shore D hardness2 (CQP 537-2)</td>
<td>66 approx.</td>
<td></td>
</tr>
<tr>
<td>Shelf life (storage between 50 and 86°F (10 and 30°C))</td>
<td>6 months</td>
<td>9 months</td>
</tr>
</tbody>
</table>

1) CQP = Corporate Quality Procedure  2) 73.4°F (23°C) / 50% r.h.

Description
SikaForce®-7727 L8 W is the base part of a two component polyurethane adhesive used with Sika-Force®-7010 Hardener. This product is manufactured in accordance with ISO 9001 / 14001 quality assurance systems.

Product Benefits
- Low phosphorous content
- Low outgassing
- No halogens
- Can be used at a temperature up to 212°F (100°C)

Areas of Application
Bonding of filter media. 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.
Cure Mechanism
The curing of SikaForce®-7727 L8 W takes place by a chemical reaction of the two components. Higher temperatures speed up and lower temperatures slow down the curing process.

Chemical Resistance
In case of chemical or thermal exposure, project related testing is recommended. Please consult our Technical Service for advise at tsmh@us.sika.com

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 pretreatment 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 Service Department of Sika Industry at tsmh@us.sika.com

Application
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 before reaching half of the pot-life and join parts together immediately. 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 at tsmh@us.sika.com

Tooling and finishing: Pressing
An adequate bonding pressure to obtain good contact between the substrates is necessary. The specific pressure is, however, dependent on the core material and must be determined by tests. The pressure must always be below the maximum compressive strength of the core. The bonded parts should not be moved during the pressing stage.

Removal
Uncured SikaForce®-7727 L8 W may be removed from tools and equipment with cleaners containing >90% di(propylene glycol) monomethyl ether and use according to the suppliers guidelines. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Handcleaner Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Overpainting
Not intended for overpainting. If overpainting is desired, the paint and paint process compatibility must be tested before use. Contact the Sika Industry Technical Services Department at tsmh@us.sika.com.

Limitations
Suitability of SikaForce®-7728 L8 for any given application must be determined beforehand and testing done to validate. This includes but is not limited to: adhesion testing, process compatibility evaluation, performance requirement testing, environmental compatibility evaluation, and health and safety concerns.

CAUTION: IRRITANT
Contains Ethylene diamine propoxilate (CAS:102-60-3) and titanium dioxide (CAS:13463-67-7). May cause skin/eye/respiratory tract irritation. May cause gastrointestinal disturbance if swallowed.

HMIS
Health  *1
Flammability  1
Reactivity  0
Personal Protection  B

First Aid
Eyes – Hold eyelids apart and flush thoroughly with tepid water for 15 minutes. Skin – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and tepid water. Inhalation – Remove to fresh air. Ingestion – Do not induce vomiting. Dilute with water. Contact physician. In all cases contact a physician immediately if symptoms persist.

Further Information
For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- KEEP CONTAINER TIGHTLY CLOSED
- FOR PROFESSIONAL USE ONLY

Copies of the following publications are available on our website www.sikausa.com:
- Material Safety Data Sheets
- Product Data Sheet

In case of emergency call: Chemtrec: 800-424-9300
International: 703-527-3887

Packaging Information

<table>
<thead>
<tr>
<th>Component</th>
<th>A</th>
<th>B</th>
</tr>
</thead>
<tbody>
<tr>
<td>Totes</td>
<td>1000</td>
<td>1000</td>
</tr>
<tr>
<td>Liters</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Value Basis
All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Handling and Storage
Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse. To be kept between 50°F (+10°C) and 86°F (+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 the atmospheric humidity. The minimum...
The temperature during transportation is 32°F (0°C).

**Cleanup**
Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and place in suitable sealed container. Uncured material can be removed with approved solvent. Follow solvent manufacturer's instructions for use and warnings. Dispose of excess product and container in accordance with applicable environmental regulations.

**Limited Material Warranty**
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer’s sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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Further information available at:
[www.sikausa.com](http://www.sikausa.com)