

PRODUCT DATA SHEET

SikaForce®-800 Red

Fast curing profile and surface filler for blade repair applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaForce®-800 Red (A)	SikaForce®-800 (B)
Chemical base	Polyols	Isocyanate derivatives
Color (CQP001-1)	Light red	Brown
	mixed	Light red
Cure mechanism	Polyaddition	
Density (uncured)	mixed (calculated) 1.30 kg/l (10.8 lb/gal) ^A	
Solid content	100 %	
Mixing ratio	by volume 100 : 50	
Viscosity (CQP029-4)	25 mm PP, d = 1 mm, 10 s ⁻¹ 35 Pa·s ^A	13 Pa·s ^A
Consistency	Thixotropic paste	
Application temperature	5 – 30 °C (41 – 86 °F)	
Working time	2.5 minutes ^A	
Sanding time	at 15 °C (59 °F)	40 minutes
	at 23 °C (73 °F)	30 minutes
	at 30 °C (86 °F)	15 minutes
Elongation at break (CQP036-2 / ISO 527)	2.5 % ^{A, B}	
Glass transition temperature (ISO 11357-2)	55 °C (131 °F)	
Shelf life	15 months ^C	

CQP = Corporate Quality Procedure

^A) 23 °C (73 °F) / 50 % r.h.^B) tested at 2 mm/min^C) storage between 10 and 30 °C (50 and 86 °F)
DESCRIPTION

SikaForce®-800 Red is a two component polyurethane based profile and surface filler that works best at temperature above 15 °C (59 °F). If ambient temperatures are lower than 15 °C (59 °F) it is advisable to use SikaForce®-800 Blue.

PRODUCT BENEFITS

- Superior mixing, application and tooling properties
- Very good adhesion to GFRP
- Non-sag up to layer thicknesses of approx. 20 mm (0.75 in)
- Fast sanding time
- Easy to sand, does not clog the sandpaper

AREAS OF APPLICATION

SikaForce®-800 Red is used for profile shaping and surface filling of damaged rotor blades in the wind turbine industry. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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Version 02.01 (03 - 2023), en_US

012104588000001000

CURE MECHANISM

The curing of SikaForce®-800 Red takes place by a chemical reaction of the two components. Higher temperatures speed up the curing process and lower slow it down.

CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. After the cleaning process, a physical or chemical pretreatment might be required, depending on surface and type of material. The type of pretreatment must be determined by tests.

Application

For the cartridge application use a suitable manual or a compressed air piston-type cartridge dispenser. To ensure good mixing quality the defined static mixer is to be used.

Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose the first few cm of the bead before the application.

Removal

Uncured SikaForce®-800 Red may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water.

Do not use solvents on skin.

STORAGE CONDITIONS

SikaForce®-800 Red has to be kept between 10 °C and 30 °C (50 °F and 86 °F) in a dry place. Do not expose it to direct sunlight or frost.

Minimum temperature during transportation is -20 °C (-4 °F) for maximum 7 days.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

SikaForce®-800 Red

Coaxial cartridge	195 ml
Mixer: MGQ 08-20T by medmix	
Dual cartridge	400 ml
Mixer: MFQ 08-24T by medmix	

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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 the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED 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.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

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