

SikaForce®-7720 L45/ SikaForce®-7050

Two Component Non-Sagging Assembly Adhesive

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.

	Component A SikaForce®-7720 L45	Component B SikaForce®-7050
Chemical Base	Polyols, filler	Isocyanate, derivatives
Color (CQP ¹) 001-1)	White	Brown
Mixed		Beige
VOC (EPA method 24)		0 g/L
Cure mechanism	Polymerization	
Density (CQP 006-5)	13.3 lbs./gallon (1.6 g/cm ³)	10 lbs. /gallon (1.2 g/cm ³).
Mixed Density (calculated)	12.6 lbs. /gal. (1.5 g/cm ³)	
Mixing Ratio by volume (by weight)	100 : 25 (100 : 19)	
Solid Content	100 %	
Viscosity (CQP 538-2) Brookfield-RVT 7/2.5 Brookfield-RVT 2/50	1,000,000 mPa·s approx.	35,000 mPa·s approx.
Mixed Viscosity, Brookfield-RVT 6/20	200,000 mPa·s approx	
Application Temperature	60-85°F (15 to 30°C)	
Pot-Life ² (CQP 536-3)	45 min approx.	
Open Time ² (CQP 590-1)	60 min / 23°C approx.	
Press Time ² (CQP 590-1)	150 min / 23°C approx.	
Shore D Hardness ² (CQP 537-2)	80 D approx.	
Shelf life (storage between 50 and 86°F (10 and 30°C))	12 months	6 months

1) CQP = Corporate Quality Procedure 2) 73°F (23°C) / 50% r.h. 3) Curing conditions: 21 days at 73°F (23°C) / 50% r.h.

Description

SikaForce®-7720 L45/ SikaForce®-7050 two component polyurethane is for bonding a wide range of substrates in structural assembly applications. The thixotropic consistency of the adhesive makes it ideal for gap filling and application even to vertical surfaces.

Product Benefits

- Thixotropic
- Gap filling
- Low VOC's

Areas of Application

SikaForce®-7720 L45/ SikaForce®-7050 can be used for assembling profiles and sandwich constructions of, e.g., glass fiber reinforced polyester, wood, metal, ceramic materials and pre-treated plastic materials. 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®-7720 L45/ SikaForce®-7050 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

For chemical or thermal exposure, project related testing is recommended. Please contact Sika Technical Service for advice at tsmh@us.sika.com.

Method of Application

Mixing

SikaForce®-7720 L45/ SikaForce®-7050 is best used with approved meter-mix-dispense application equipment or from Sika supplied cartridges. For advice on application equipment contact Sika Systems Engineering at 248-577-0020. If manually mixing, stir the base part thoroughly before use, add the hardener in the given ratio and stir constantly until a homogeneous mixture is obtained. Apply mixed material within one half of the given pot-life and press parts together within the given open time. Please consult our Sika Technical Service for detailed information at tsmh@us.sika.com.

Surface preparation

Prepare the substrates for bonding to ensure optimal adhesion and strength. Ensure that the surface is clean and dry. Certain substrates might require a physical or chemical pre-treatment. The type of pre-treatment must be determined by tests. Please contact Sika Technical Service for advice at tsmh@us.sika.com.

Application

Lamination:

Coat weights between 150 and 350 g/m² are recommended depending on the substrates to be bonded. The specific coat weight for a given substrate combination is to 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. Please contact Technical Service for advice at tsmh@us.sika.com. For automated applications, please contact Sika Technical Service for advice at tsmh@us.sika.com.

Pressing:

Adequate bonding pressure to obtain a voidless contact between the adhesive and 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. After starting the press process do not release the pressure until the press time has elapsed.

Tooling and finishing

Clean away excess squeezeout. Clean area around bondline with a material which is safe for the substrates. Do not use alcohol or alcohol-containing cleaners.

Removal

Uncured SikaForce®-7720 L45/ SikaForce®-7050 may be removed from tools and equipment with acetone. Once cured, the material can only be removed mechanically.

Limitations

The information in this document is intended for use by Sika Corporation (USA) customers in the United States only. Suitability SikaForce®-7720 L45/ SikaForce®-7050 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. Application Temperature Range is 60-85°F (15-30°C).

Part A: SikaForce®-7720 L45

Warning Contains: Titanium dioxide (CAS: 13463-67-7). Suspected of causing cancer. **WARNING!** This product contains a chemical known in the State of California to cause cancer.

Part B: SikaForce®-7050

Danger Contains:

Diphenylmethanediisocyanate, isomers and homologues (CAS: 9016-87-9). Causes skin irritation. May cause an allergic skin reaction. Causes serious eye irritation. Harmful if inhaled. May cause allergy or asthma symptoms or breathing difficulties if inhaled. May cause respiratory irritation. May cause damage to organs through prolonged or repeated exposure if inhaled. This product does not contain any chemicals known to the State of California to cause cancer, birth, or any other reproductive defects.

HMIS

	Part A	Part B
-Health:	*2	*3
-Flammability:	1	1
-Reactivity:	0	0
-Personal Protective Equipment:	X	X

First Aid

Part A: SikaForce®-7720 L45

IF exposed or concerned: Get medical advice/attention.

Part B: SikaForce®-7050

IF ON SKIN: Wash with plenty of soap and water. Rest in a position comfortable for breathing. **IF IN EYES:** Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing **IF INHALED:** Remove victim to fresh air and keep. **If skin irritation or rash occurs:** Get medical advice/attention. If eye irritation persists: Get medical advice/attention. **If experiencing respiratory symptoms:** Call a POISON CENTER or doctor/physician.

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

Further information available at:
www.sikausa.com

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- 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

Cartridge	Component A/B: 415 ml
Hobcock	Component B: 20kg
Drum	Component A: 300 kg
	Component B: 250 kg

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

Obtain special instructions by contacting Sika Technical Service at tsmh@us.sika.com. Do not handle until all safety precautions have been read and understood. Use personal protective equipment as required. Store in original container. Keep in a well-ventilated place. Observe label precautions. Store in accordance with local regulations.

Store product 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 atmospheric humidity. The minimum temperature during transportation is 32°F (0° C) for a maximum of 7 days.

Cleanup

Non cured adhesive on tools and application equipment can be removed with acetone. Cured adhesives can only be removed mechanically. Use personal protective

equipment (chemical resistant gloves/goggles/clothing). Without direct contact, sweep up spilled or excess product and place in suitable sealed container. Dispose of excess "product and container in accordance with applicable local, state, and federal 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.**

Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must

test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikausa.com or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at www.sikausa.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at:
www.sikausa.com

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