

# SikaForce®-7800 Blue

Fast curing profile and surface filler for blade repair applications

## Technical Product Data

Properties	Component A SikaForce®-7800 Blue (A)	Component B SikaForce®-7800 (B)
Chemical base	Polyols	Isocyanate derivatives
Color (CQP <sup>1</sup> 001-1) Color mixed	Light blue	Brown
Curing mechanism	Polyaddition	
Density <sup>2</sup> (CQP 006-5) Density mixed (calculated)	1.38 g/cm <sup>3</sup> approx.	1.22 g/cm <sup>3</sup> approx.
Mixing ratio	100 : 50	
Solids content	100%	
Viscosity <sup>2</sup> (CQP 029-1) 40 mm PP, d=800 µm, 300 s <sup>-1</sup> 40 mm PP, d=800 µm, 300 s <sup>-1</sup>	6'600 mPa·s approx.	2'100 mPa·s approx.
Consistency (mixed)	Thixotropic paste	
Application temperature	5 – 15 °C (40 – 60 °F)	
Working time <sup>3</sup>	2 min approx.	
Sanding time at 5°C (40°F) 10°C (50°F) 15°C (60°F)	40 min approx. 30 min approx. 15 min approx.	
Elongation at break (CQP 545-2 / ISO 527-2)	2.5 % approx.	
Glass transition temperature (ISO 11357-2)	55 °C (131 °F) approx.	
Shelf life (CQP 016-1) (stored at 10 - 30 °C (50 - 85 °F))	9 months	

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

<sup>2)</sup> 23 °C (50 °F) / 50 % r.h.

<sup>3)</sup> 10 °C (50 °F) / 50 % r.h.

### Description

SikaForce®-7800 Blue is a two component polyurethane based profile and surface filler designed for lower temperatures.

SikaForce®-7800 Blue is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

### Product Benefits

- Excellent mixing, application and tooling properties
- Very good adhesion to fiberglass surfaces
- Non-sag up to layer thicknesses of approx. 20 mm
- Fast sanding time at low ambient temperature
- Easy to sand, does not clog the sandpaper

### Areas of Application

SikaForce®-7800 Blue is used for profile shaping and surface filling of damaged rotor blades in the wind turbine industry.

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.



\* This product is currently in the field test phase and has not been finally released. Technical data stated herein is based on preliminary testing and experience and is subject to change. Product is only suitable for experienced users and only after suitable pre-testing. Subject to mandatory legal provisions, Sika's liability is limited to the replacement of the defective products.

### Cure Mechanism

The curing of SikaForce®-7800 Blue takes place by chemical reaction of the two components. Higher temperatures speed up the curing process and lower temperatures slow down the curing process.

### Environmental Resistance

In case of expected chemical or thermal exposure, we recommend a project related testing. Consult the Technical Department of Sika Industry for advice.

### Method of Application

#### Surface preparation

Usually it is necessary to prepare the substrates to ensure optimal adhesion. Based on the surface condition and type of material, physical or chemical pre-treatment may be required after the cleaning process.

Advice on specific applications is available from the Technical Department of Sika Industry.

#### Cartridge application

For the cartridge application we recommend the use of a suitable manual or a compressed air piston-type cartridge gun. To ensure good mixing quality a static mixer of type Sulzer MixPac® MC10-24 is recommended. Similar static mixers may be suitable but have to be thoroughly tested beforehand.

#### Cleaning

Uncured SikaForce®-7800 Blue may be removed from tools and equipment with SikaRemover®-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleaner and water. Do not use solvents!

### Storage Conditions

SikaForce®-7800 Blue has 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 cartridge, the contents need to be protected against humidity.

### Further Information

The following publications are available on request:  
- Safety Data Sheet

### Packaging Information

SikaForce®-7800 Blue

Cartridge (2C)	195 ml
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### Value Bases

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

### Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

### Legal Notes

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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:  
[www.sika.ch](http://www.sika.ch)  
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