

## PRODUCT DATA SHEET

# SikaPower®-880

Toughened and fast-curing 2-component structural adhesive

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaPower®-880 (A)	SikaPower®-880 (B)
Chemical base	Epoxy	Amine
Color (CQP001-1)	White	Grey
	mixed	Grey
Density	1.25 kg/l (10.4 lb/gal)	1.26 kg/l (10.5 lb/gal)
	mixed (calculated)	1.26 kg/l (10.5 lb/gal)
Mixing ratio	by volume 100 : 100	
	by weight 100 : 102	
Viscosity (CQP029-4)	at 10 s <sup>-1</sup> 120 Pa·s <sup>A</sup>	100 Pa·s <sup>A</sup>
Consistency	Thixotropic paste	
Application temperature	15 – 30 °C (59 – 86 °F)	
Open time (CQP046-11 / ISO 4587)	45 minutes <sup>A, B</sup>	
Handling time (CQP046-11 / ISO 4587)	5 hours <sup>A, B</sup>	
Shore D hardness (CQP023-1 / ISO 48-4)	70 <sup>C</sup>	
Tensile strength (CQP543-1 / ISO 527)	22 MPa (3 200 psi) <sup>A, C</sup>	
E-Modulus (CQP543-1 / ISO 527)	2 100 MPa (300 ksi) <sup>A, C</sup>	
Elongation at break (CQP543-1 / ISO 527)	3 % <sup>A, C</sup>	
Tensile lap-shear strength (CQP046-9 / ISO 4587)	23 MPa (3 350 psi) <sup>A, B, C</sup>	
Glass transition temperature (CQP509-1 / ISO 6721)	77 °C (171 °F) <sup>C</sup>	
Shelf life (CQP016-1)	12 months <sup>D</sup>	

CQP = Corporate Quality Procedure

<sup>C</sup> cured for 1 week at 23 °C (73 °F)<sup>A</sup>) 23 °C (73 °F) / 50 % r.h.<sup>D</sup>) stored between 10 and 30 °C (50 and 86 °F)<sup>B</sup>) adhesive layer: 25 x 12.5 x 0.3 mm / on steel
**DESCRIPTION**

SikaPower®-880 is a thixotropic, fast curing, gap-filling 2-component epoxy adhesive, which cures at room temperature. It is designed for use in structural joints, where toughness and high strength are required. SikaPower®-880 is particularly suitable for bonding metallic substrates, like steel and aluminium, as well as composite substrates, like GFRP and CFRP laminates. The adhesive has very good application properties and shows elevated heat resistance.

**PRODUCT BENEFITS**

- High strength and high resistance to fatigue and impacts
- Long open time
- Fast curing at room temperature
- Very good non-sag and application properties
- Contains glass beads of 0.3 mm (0.012 in) to ensure optimal bonding thickness
- Does not contain solvents or PVC

**AREAS OF APPLICATION**

SikaPower®-880 is suitable for fast assembly bonding applications in transportation and general industry, especially if high toughness and strength is required. It can also be used for repair applications as well as in hybrid joints in combination with spot welding, riveting or clinching.

This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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## CURE MECHANISM

SikaPower®-880 cures by a fast chemical reaction of the two components at room temperature. The cure rate can be further accelerated at higher temperatures, e.g., using ovens or infrared lamps. The final glass transition temperature, as well as the tensile and shear strengths, may be increased with higher curing temperature.

## CHEMICAL RESISTANCE

In view of potential chemical or thermal exposure, it is required to conduct a project related testing.

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

### Application

SikaPower®-880 is dispensed from 1:1 dual cartridges with adequate dispensers. The use of electric or pneumatic guns with piston-driven plungers is recommended. Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose of the first few cm of the bead before the application.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

### Removal

Uncured SikaPower®-880 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. 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

SikaPower®-880 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. After opening of the packaging, the contents have to be protected against humidity.

## 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

SikaPower®-880 (A+B)

Dual cartridge	400 ml
Mixer: Sulzer MixPac™ MFQ 08-24T	

SikaPower®-880 (A)

Pail	19 kg
Drum	225 kg

SikaPower®-880 (B)

Pail	19 kg
Drum	227 kg

## 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](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto: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.

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