

## PRODUCT DATA SHEET

# SikaForce®-479 L45

High performance assembly adhesive

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

Properties	SikaForce®-479 L45 (A)	SikaForce®-479 L45 (B)
Chemical base	Polyol	Isocyanate
Colour (CQP001-1)	Cream White	Cream White
	mixed	Cream White
Density (uncured)	1.20 kg/l	1.56 kg/l
	mixed (calculated)	1.38 kg/l
Mixing ratio	by volume by weight	1 : 1 1 : 1.3
Viscosity (CQP029-4)	15 Pa·s <sup>A</sup>	34 Pa·s <sup>A</sup>
Application temperature	ambient	10 – 35 °C
Shore D hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (CQP036-2 / ISO 527)		8 MPa <sup>A, B</sup>
Elongation at break (CQP036-2 / ISO 527)		30 % <sup>A, B</sup>
E-Modulus (CQP036-2 / ISO 527)	elongation 0.05 – 0.25 %	300 MPa <sup>A, B</sup>
Shelf life		12 months <sup>C</sup>

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r.h.<sup>B)</sup> cured for 7 days at 23 °C<sup>C)</sup> stored between 10 °C and 30 °C
**DESCRIPTION**

SikaForce®-479 L45 is a 2-component polyurethane adhesive which cures by chemical reaction of the 2-components mainly designed for corner connection application.

**PRODUCT BENEFITS**

- Good filling and flowing properties
- Easy to process
- High strength and high modulus

**AREAS OF APPLICATION**

SikaForce®-479 L45 is used for bonding e.g. corner connections for frame profiles that are usually used for windows and doors. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

## CURE MECHANISM

The curing of SikaForce®-479 L45 takes place by a chemical reaction of the two components. Higher temperatures speed up the curing process and lower slow it down.

In big bead applications, the generated heat of exothermic reaction can speed up the cure, reducing the pot-life.

## 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 pre-treatment might be required, depending on surface and type of material. The type of pre-treatment must be determined by tests.

### Application

SikaForce®-479 L45 is dispensed by piston guns adequate for 620 ml 1:1 side-by-side cartridges. For application out of the cartridge the extrusion force must not exceed 3.3 kN. Extrude adhesive without mixer to equalise the filling levels. Attach the mixer and dispose off the first few cm's of the bead prior to the application. Check the colour of the adhesive and make sure it is mixed properly (no strings or stripes in the extruded bead). The mixer must be changed if the application is interrupted for longer than 7 minutes. For cartridge application, a Ritter static mixer KWM 18K is required.

## Removal

Uncured SikaForce®-479 L45 may be removed from tools and equipment with SikaForce®-096 Cleaner. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

## STORAGE CONDITIONS

SikaForce®-479 L45 has to be kept between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has 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

Cartridge	600 ml
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## BASIS OF PRODUCT DATA

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 Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse 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.

## PRODUCT DATA SHEET

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