

## PRODUCT DATA SHEET

# SikaForce®-712 L80

Two Component Low Viscous Sandwich Panel Adhesive With Long Open Time

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

Properties	Component A SikaForce®-712 L80	Component B SikaForce®-7010
<b>Chemical base</b>	Polyols	Isocyanate derivatives
<b>Color (CQP001-1)</b>	Beige	Brown
	mixed Beige	
<b>CURE MECHANISM</b>	Poly addition	
<b>Density (uncured)</b>	1.5 g/cm <sup>3</sup>	1.2 g/cm <sup>3</sup>
	mixed (calculated) 1.4 g/cm <sup>3</sup>	
<b>Solid content</b>	100 %	100 %
<b>Mixing ratio</b>	by volume 100 : 31	
	by weight 100 : 26	
<b>Viscosity (CQP029-4)</b>	Rheometer, PP25, shear rate 10 s <sup>-1</sup> , d=1 mm	
	7 000 mPa·s <sup>A</sup>	300 mPa·s <sup>A</sup>
	mixed 4 000 mPa·s <sup>A</sup>	
<b>Application temperature</b>	15 – 30 °C	
<b>Pot-life (CQP536-3)</b>	85 minutes <sup>A</sup>	
<b>Open time (CQP526-3)</b>	155 minutes <sup>A</sup>	
<b>Press time (CQP590-4)</b>	1 MPa	205 minutes <sup>A</sup>
<b>Shore D hardness (CQP023-1 / ISO 868)</b>	69 <sup>B</sup>	
<b>Tensile strength (CQP543-1 / ISO 527)</b>	14 MPa <sup>B</sup>	
<b>Elongation at break (CQP543-1 / ISO 527)</b>	56 % <sup>B</sup>	
<b>Tensile lap-shear strength (CQP546-1 / ISO 4587)</b>	9 MPa <sup>B</sup>	
<b>Shelf life</b>	12 months	9 months

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

B) 3 months 23 °C / 50 % r.h.

**DESCRIPTION**

SikaForce®-712 L80 is a long open time, low viscous two component polyurethane adhesive for sandwich elements and other constructions with different materials.

**PRODUCT BENEFITS**

- Low density
- Low viscosity
- Long open time
- Room temperature curing
- Solvent free

**AREAS OF APPLICATION**

SikaForce®-712 L80 is used primarily for bonding of metal, fiber cement, wood and glass fiber reinforced plastic to expanded and extruded polystyrene foam, polyurethane foam and mineral wool in the manufacturing of sandwich elements and other constructions. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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## CURE MECHANISM

The curing of SikaForce®-712 L80 takes place by a chemical reaction of the two components. Higher temperatures speed up and lower slow down the curing process.

## CHEMICAL RESISTANCE

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

## METHOD OF APPLICATION

### Product preparation

SikaForce®-712 L80 must be stirred thoroughly before use.

### 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

Usually a coat weight between 150 and 350 g/m<sup>2</sup> is applied, depending on the substrates to be bonded. The specific coat weight for a given substrate combination must be determined by tests.

The procedure for manual application is as follows: Stir the A-component thoroughly until it is mixed homogeneously. Add the B-component in the specified ratio in the A-component and stir until a homogeneous mixture is obtained. Apply before reaching half of the pot-life and join parts together within the open time. Consider that, if mixed in larger amounts, the exothermic reaction can reduce the pot-life and open time significantly.

For automated applications, contact the System Engineering Department of Sika Industry.

### Pressing

An adequate bonding pressure is necessary to obtain a voidless contact between the substrates and the adhesive. 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.

### Removal

Uncured SikaForce®-712 L80 may be removed from tools and equipment with SikaForce®-7260 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®-712 L80 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.

Minimum temperature during transportation is -20 °C for max. 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

## 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.

## 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.

## 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.

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