

SikaForce®-7700-9575 RT31

Unfilled two component polyurethane adhesive for sandwich panel bonding on continuous production lines

Technical Product Data

Properties	Component A SikaForce®-7700-9575 RT31	Component B SikaForce®-7010
Chemical base	Polyols	Isocyanate derivatives
Colour (CQP ¹ 001-1)	Transparent	Brown
Colour mixed	Beige	
Cure mechanism	Poly addition	
Density (CQP 006-5)	1.1 g/cm ³ approx.	1.2 g/cm ³ approx.
Density mixed (calculated)	1.1 g/cm ³ approx.	
Solids content	100%	100%
Mixing ratio	by volume by weight	100 : 115 100 : 125
Viscosity ² (CQP 538-2)	Brookfield - RVT 3/20 Brookfield - RVT 2/50	900 mPa·s approx. 250 mPa·s approx.
Application temperature	15 - 30°C (60 - 85°F)	
Cream time ²	15 sec. approx.	
Rise time ²	35 sec. approx.	
Gross calorific potential (prEN ISO 1716)	30 MJ/kg approx.	
Shelf life (storage between 10 and 30 °C)	6 months	9 months

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C / 50% r.h.

Description

SikaForce®-7700-9575 RT31 is the base part of a two component polyurethane adhesive used with Sika-Force®-7010 hardener. SikaForce®-7700-9575 RT31 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- Very fast curing at room temperature
- Highly foaming
- Range of speeds to suit most production lines
- Solvent free

Areas of Application

SikaForce®-7700-9575 RT31 is suitable for bonding sandwich panels with skin materials of primed steel and core material of expanded EPS foam and mineral wool. 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



* 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®-7700-9575 RT31 takes place by a chemical reaction of the two components. Higher temperatures speed up and lower temperatures slow down the curing process.

Chemical Resistance

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

Method of Application

Surface preparation

Usually it is necessary to prepare the substrates for bonding to ensure optimal adhesion and strength. After the cleaning process, a physical or chemical pre-treatment might be required, based on the surface and type of substrate. Type of pre-treatment must be determined by tests.

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

Application

Coat weights between 100 and 250 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 product is only suited for use on short continuous production lines. For further details contact the Technical Service Department of Sika Industry.

Pressing

An adequate bonding pressure to obtain a void-less contact between 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.

Removal

Uncured SikaForce®-7700-9575 RT31 may be removed from tools and equipment with SikaForce®-7260 Cleaner. 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®-7700-9575 RT31 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 0°C for maximum 6 hours. For Sika® Force-7710 refer to the actual product datasheet

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets

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 Material 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:
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