

SikaForce[®]-7700 RT110

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

Technical Product Data

Properties	Component A SikaForce [®] -7700 RT110	Component B SikaForce [®] -7000
Chemical base	Polyols	Isocyanate derivatives
Color (CQP ¹ 001-1)	Yellow	Brown
Color mixed	Beige	
Cure mechanism	Poly addition	
Density (CQP 006-5)	1.0 g/cm ³ approx.	1.26 g/cm ³
Density mixed (calculated)	1.1 g/cm ³ approx.	
Solids content	100%	100%
Mixing ratio	by volume by weight	100 : 100 100 : 115
Viscosity ² (CQP 538-2)	Brookfield – RVT 3/20	1660 mPa·s approx. 880 mPa·s approx.
Application temperature	15°C - 30°C	
Cream time	30 seconds	
Rise time	110 seconds	
Shelf life (storage between 10°C and 25°C)	6 months	6 months
Gross calorific potential (MJ/kg, prEN ISO 1716)	28.5	

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C / 50% r.h.

³⁾ Curing according to CQP 542-2

Description

SikaForce[®]-7700 RT110 is the base part of a two component unfilled, highly reactive, forming polyurethane adhesive used with Sika-Force[®]-7000 Hardener.

Product Benefits

- Very fast curing at low temperature
- Highly foaming
- Range of speeds to suit all lines
- Can be used with existing equipment
- Solvent-free

Areas of Application

Primarily for bonding of sandwich constructions with skin materials of pre-treated or primed aluminium and steel and core material of extruded/expanded polystyrene, PUR/PIR 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.



Cure Mechanism

The curing of SikaForce®-7700 RT110 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 may be required, based on the surface and type of material. 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 80 and 200 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 automatic application on continuous production lines.

Further details can be obtained from the Technical Service Department of Sika Industry.

Pressing

An adequate bonding pressure to obtain good 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.

Removal

Uncured SikaForce®-7700 RT110 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 Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Storage Conditions

SikaForce®-7700 RT110 has to be kept between 10°C and 25°C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the contents should be protected against humidity.

Minimum temperature during transportation is 0°C for maximum 6 hours.

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets

Packaging Information

Component A Resin	Drum	220 kg
	IBC	1200 kg
Component B Hardener	Drum	220 kg
	IBC	1200 kg

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 should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

"Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based of approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure that our products are suitable for the use in question and further make sure that the products are kept and used correctly and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is effected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise."

Further information available at:
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