

PRODUCT DATA SHEET

SikaForce®-424 L130

Two components gelling assembly adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaForce®-424 L130	Component B SikaForce®-010
Chemical base	Polyols, filled	Isocyanate derivatives
Colour (CQP001-1)	Beige	Brown
	mixed	Beige
Cure mechanism	Polycondensation	
Density (uncured)	1.45 g/cm ³	1.20 g/cm ³
	mixed, calculated	1.40 g/cm ³
Solid content	100 %	
Mixing ratio	by volume	100 : 22
	by weight	100 : 18
Viscosity	Brookfield-RVT 7/2.5	210 000 mPa·s ^A
	Brookfield-RVT 2/50	250 mPa·s ^A
	mixed	Gel ^A
Application temperature	15 – 50 °C	
Pot life (CQP536-2)	130 minutes ^A	
Press time (CQP590-4)	210 minutes ^A	
Shore D hardness (CQP023-1 / ISO 868)	60 ^B	
Tensile strength (CQP036-2 / ISO 527)	7 MPa	
Shelf life	12 months	9 months

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.^{B)} curing conditions: 21 days at 23 °C / 50 % r. h.**DESCRIPTION**

SikaForce®-424 L130 is the base part of a two-component polyurethane adhesive used with SikaForce®-010 hardener.

PRODUCT BENEFITS

- Chemical gelling
- Non sagging
- Solvent free
- Good gap filling property

AREAS OF APPLICATION

SikaForce®-424 L130 can be used for assembly of profiles and sandwich constructions of e.g. glass fibre reinforced polyester, wood, metal, ceramic materials and pre-treated plastic materials.

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®-424 L130 takes place by chemical reaction of the two components. Higher temperatures (max. 100 °C) speed up and lower temperatures slow down the curing process.

Full cure and final adhesion performance is achieved after 7 days.

CHEMICAL RESISTANCE

SikaForce®-424 L130 is resistant to hydrolysis. The chemical resistance is influenced by several factors such as chemical composition, concentration, period of exposure and temperature. Therefore a project related testing in case of chemical or thermal exposure is required.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust.

Based on the surface and type of material, a physical or chemical pre-treatment might be required. Type of pre-treatment must be determined by preliminary tests.

Application

Prior to application, check both components for crystallization. Never use components if crystallization has occurred.

Adhesion as well as curing speed can be improved by heat.

Typically a coat weight between 150 and 350 g/m² 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 base part thoroughly before use, add the hardener in the given ratio and stir constantly until a homogeneous mixture is obtained. Apply with trowel before reaching half of the pot-life and join parts together within the open time.

SikaForce®-424 L130 is processed by 2-component equipment. The mixer needs to be defined by tests.

To process SikaForce®-424 L130 adequate dosing units and mixers are required. For automated applications a suitable filter system must be used.

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

Pressing

An adequate bonding pressure to obtain a void less contact between the substrates and adhesive 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

SikaForce®-424 L130 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent.

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

All components of SikaForce®-424 L130 have to be stored at temperature 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 maximum 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

PACKAGING INFORMATION

SikaForce®-424 L130

Drum	195 l
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SikaForce®-010

Can	5 l
Pail	23 l
Drum	195 l

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

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

DISCLAIMER

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.

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