

PRODUCT DATA SHEET

SikaForce®-710 L30

Fast curing 2-component balancing material

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaForce®-710 L35	Component B SikaForce®-050
Chemical base	Polyols	Isocyanate derivatives
Colour (CQP001-1)	Beige	Brown
	mixed	Beige
Cure mechanism	Polyaddition	
Density (uncured)	1.64 g/cm ³	1.22 g/cm ³
	mixed (calculated)	1.56 g/cm ³
Mixing ratio	by volume 100 : 25	
	by weight 100 : 19	
Viscosity (CQP029-4)	Rheometer, PP25, shear rate 10 s ⁻¹ , d=1 mm	
	24 Pa·s ^A	15 Pa·s ^A
	mixed	14 Pa·s ^A
Application temperature	10 – 40 °C	
Pot-life (CQP536-3)	30 minutes ^A	
Shore D hardness (CQP023-1 / ISO 48-4)	45 ^B	
Tensile strength (CQP543-1 / ISO 527)	6 MPa ^{B, C}	
Elongation at break (CQP543-1 / ISO 527)	22 % ^{B, C}	
Tensile lap-shear strength (CQP546-1 / ISO 4587)	7 MPa ^{B, D}	
Shelf life	drum	12 months
	cartridge	9 months

CQP = Corporate Quality Procedure

C) tested at 2 mm/min

A) 23 °C / 50 % r. h

D) adhesive layer: 25 x 12.5 x 3 mm / on GFRP

B) cured for 28 days at 23 °C / 50 % r. h

DESCRIPTION

SikaForce®-710 L30 is a 2-component polyurethane adhesive which cures at room temperature.

It is designed for balancing of wind turbine blades. The system is characterized by high injectability and thixotropic viscosity build up.

PRODUCT BENEFITS

- Room temperature curing
- High injectability
- Medium viscosity
- Easy to apply
- Solvent free

AREAS OF APPLICATION

SikaForce®-710 L30 is primarily used for balancing of wind turbine blades in factory but also for onsite-rebalancing. The material can be used in other industry applications such as bonding of sandwich panels after a detailed project review.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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CURE MECHANISM

The curing of SikaForce®-710 L30 takes place by a chemical reaction of the two components. Higher temperatures speed up the curing process and lower slow it down.

CHEMICAL RESISTANCE

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

METHOD OF APPLICATION

Product preparation

Component A 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 pretreatment might be required, depending on surface and type of material. The type of pretreatment must be determined by tests.

Mixing process

The procedure for manual application is as follows: Ensure that the A-component is stirred thoroughly to avoid any sediment or separation, taking care not to stir too vigorously as this may introduce air into the product. Add the B-component in the specified ratio and stir thoroughly, ensuring a homogeneous mixture is achieved.

Application

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.

SikaForce®-710 L30 can be applied with automated application equipments. For automated applications, contact the System Engineering Department of Sika Industry.

Removal

Uncured SikaForce®-710 L30 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®-710 L30 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.

The lowest allowed 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

PACKAGING INFORMATION

SikaForce®-710 L35 (A)

Pail	25 kg
Drum	300 kg
Container	1 500 kg

SikaForce®-050 (B)

Can	0.45 kg
	1 kg
	5 kg
	20 kg
Pail	25 kg
Drum	250 kg

SikaForce®-710 L30 (A+B)

Dual cartridge	415 ml
Mixer: MFHX 10-32 by medmix	
Mixer: MFHX 10-24 by medmix	

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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