

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
Color (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

Please contact customer service DK regarding availability

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

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 on 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 correct 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 affected 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.

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