BUILDING TRUST

PRODUCT DATA SHEET

SikaForce®-800 Red

(formerly SikaForce®-7800 RED)

Fast curing profile and surface filler for blade repair applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		SikaForce®-800 Red (A)	SikaForce®-800 (B)
Chemical base		Polyols	Isocyanate derivatives
Color (CQP001-1)		Light red	Brown
	mixed	Light red	
Cure mechanism		Polyaddition	
Density (uncured)	mixed (calculated)	1.30 kg/l [A]	
Solid content		100 %	
Mixing ratio	by volume	100 : 50	
Viscosity (CQP029-4)	25 mm PP, d = 1 mm, 10 s^{-1}	35 Pa·s [A]	13 Pa·s [A]
Consistency		Thixotropic paste	
Application temperature		5 – 30 °C	
Working time		2.5 minutes [A]	
Sanding time	at 15 °C	40 minutes	
	at 23 °C	30 minutes	
	at 30 °C	15 minutes	
Elongation at break (CQP036-2 / ISO 527)		2.5 % [A, B]	
Glass transition temperature (ISO 11357-2)		55 °C	
Shelf life		15 months [C]	

CQP = Corporate Quality Procedure
[A)] 23 °C / 50 % r.h.
[B)] tested at 2 mm/min
[C)] storage between 10 and 30 °C

DESCRIPTION

SikaForce®-800 Red is a two component polyurethane based profile and surface filler that works best at temperature above 15 °C. If ambient temperatures are lower than 15 °C it is advisable to use SikaForce®-800 Blue.

PRODUCT BENEFITS

- Superior mixing, application and tooling properties
- Very good adhesion to GFRP
- Non-sag up to layer thicknesses of approx. 20 mm
- Fast sanding time
- Easy to sand, does not clog the sandpaper

AREAS OF APPLICATION

SikaForce®-800 Red is used for profile shaping and surface filling of damaged rotor blades in the wind turbine industry.
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®-800 Red 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
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.

Application
For the cartridge application use a suitable manual or a compressed air piston-type cartridge dispenser. To ensure good mixing quality the defined static mixer is to be used.
Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose the first few cm of the bead before the application.

Removal
Uncured SikaForce®-800 Red may be removed from tools and equipment with Sika® Remover-208. 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®-800 Red has to be kept between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost.
Minimum temperature during transporation 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®-800 Red

Coaxial cartridge	195 ml
Mixer: MGQ 08-20T by medmix	

Dual cartridge	400 ml
Mixer: MFQ 08-24T 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
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.

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