BUILDING TRUST

PRODUCT DATA SHEET

SikaForce®-422 L13

Non sagging assembly adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		Component A SikaForce®-422 L13	Component B SikaForce®-010
Chemical base		Polyols	Isocyanate derivatives
Color (CQP001-1)		Beige	Brown
	mixed	Beige	
Cure mechanism		Polyaddition	
Density (uncured)		1.60 g/cm³	1.23 g/cm³
	mixed (calculated)	1.53 g/cm³	
Solid content		100 %	100 %
Mixing ratio	by volume	100 : 25	
	by weight	100 : 19	
Viscosity (CQP029-4)	Rheometer, PP25, shear rate 10 s^{-1}, d=0.5 mm	115 000 mPa·s [A]	300 mPa·s [A]
	mixed	45 000 mPa·s [A]	
Application temperature		15 – 30 °C	
Press time (CQP590-4)	1 MPa	40 minutes [A]	
Shore D hardness (CQP023-1 / ISO 48-4)		76 [B]	
Tensile lap-shear strength (CQP546-1 / ISO 4587)		13 MPa [B]	
Shelf life		12 months	9 months

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

B) 12 weeks at 23 °C / 50 % r.h.

DESCRIPTION

SikaForce®-422 L13 is a high viscous 2-component polyurethane adhesive for assembling sandwich panels and similar constructions of various materials.

PRODUCT BENEFITS

- Non sagging
- Good gap filling properties
- Solvent free

AREAS OF APPLICATION

SikaForce®-422 L13 is used primarily for assembling of profiles and sandwich constructions of e.g. glass fiber reinforced plastic, wood, metal, ceramic materials and pretreated 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®-422 L13 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
Volume and positioning of the adhesive must be defined in a way, that the intended gap is sufficiently filled after joining the parts. The specific applied quantity and position must be determined by tests.
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.
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.
For automated applications, contact the System Engineering Department of Sika Industry.

Pressing
An adequate bonding pressure is necessary to obtain a voidless contact between the substrates and the adhesive. 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
Uncured SikaForce®-422 L13 may be removed from tools and equipment with SikaForce®-096 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®-422 L13 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.
Lowest 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

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