

SikaForce[®]-7737 L50 (formerly 1959)

Two component high strength adhesive for bonding of metal to wood constructions

Technical Product Data

Properties	Component A: SikaForce [®] -7737 L50	Component B: SikaForce [®] -7020
Chemical base	Polyols, filled	Isocyanate derivatives
Colour (CQP ⁴⁾ 001-1)	Red	Brown transparent
Colour mixed	Red	
Curing mechanism	Poly addition	
Density (CQP 006-4)	1.8 g/cm ³ approx.	1.2 g/cm ³ approx.
Density mixed (calculated)	1.5 g/cm ³ approx.	
Mixing ratio	by volume 100	37
	by weight 100	25
Solids content	100%	100%
Viscosity ¹⁾ (CQP 538-2)	11,000 mPa·s approx. (Brookfield RVT 6/10)	90 mPa·s approx. (Brookfield RVT 2/20)
Viscosity mixed ¹⁾ (CQP 538-2)	3,200 mPa·s approx.	
Pot-life ¹⁾ (CQP 536-3)	50 min. approx.	
Application temperature range	15-30°C	
Application time ¹⁾	25 minutes approx.	
Shore D hardness ²⁾ (DIN 53505 / CQP 537-2)	85 D approx.	
Tensile strength ³⁾ (ISO 527 / CQP 545-2)	18 N/mm ² approx.	
Elongation at break ³⁾ (ISO 527 CQP 545-2)	4% approx.	
Compression strength ²⁾ (ISO 604)	56 N/mm ² approx.	
E-modulus ²⁾ (ASTM D 790)	2239 N/mm ² approx.	
Shelf life in closed packaging	12 months	

¹⁾ Testing temperature: +23°C / 50% r.h.

²⁾ Curing conditions: 21 days at +23°C / 50% r.h.

³⁾ Curing conditions: 90 days at +23°C / 50% r.h.

⁴⁾ CQP: Corporate Quality Procedure

Description

SikaForce[®]-7737 L50 is the base part of a two component polyurethane adhesive used with SikaForce[®]-7020 Hardener. This product is manufactured in accordance with ISO 9001 and 14001 quality assurance systems.

Product Benefits

- Room temperature curing
- Solvent-free
- High impact strength
- The open time is not affected by the humidity of the air

Areas of Application

Bonding of wood, metal and special constructions.



Cure Mechanism

The curing of SikaForce®-7737 L50 takes place by chemical reaction of the two components. Higher temperatures speed up the curing process; lower temperatures slow down the curing process.

Chemical Resistance

In case of expected chemical or thermal exposure, we recommend a project related testing. Please consult our Technical Service for advice.

Method of Application

Surface preparation

It is generally necessary to prepare the items for bonding to ensure optimal adhesion and strength. The pre-treatment may consist of sanding, degreasing, corona treatment, priming, etc. Especially on metals, it may be an advantage to use a primer. Type of pre-treatment must be determined by tests. Please consult our Technical Service for advice.

Application

Coat weights between 150 and 350 g/m² are recommended depending on the substrates to be bonded. The specific coat weight for a given substrate combination should be determined by tests. Automated application: Bead application requires metering and application equipment which can be supplied by Sika Danmark A/S. Manually: 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 expiry of the application time and press parts together before end of the open time. Please consult our Technical Service for detailed information.

Pressing

A minimum bonding pressure of 200 g/cm² should be used. The specific pressure is dependent on the core material and should be determined by tests. The pressure must always be below the maximum compressive strength of the core. The bonded items should not be moved during the pressing stage.

Cleaning

Non-cured adhesive on tools and application equipment can be removed with SikaForce®-7260 Cleaner. Cured adhesive can only be removed mechanically.

Storage Conditions

To be kept between +10°C and +30°C in a dry place. Do not expose to direct sunlight or frost. After opening of the packaging, the contents should be protected against the atmospheric humidity. Minimum temperature during transportation is 0°C.

Further Information

The following publications are available on request:
- Safety data sheet

Packaging Information

Component A Resin	Pail	30 kg
	Drum	300 kg
Component B Hardener	Can	0.5 kg
	Can	5 kg
	Drum	250 kg

Important

For information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Notice:

"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 of 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 effected 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 updated 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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Safety Data Sheet

according to 91/155/EEC and ISO 11014-1

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Revised: 19.12.2005

SDS No.: 057-00217648.0000

* 1. Identification of the substance/preparation and company

Product

Product name

SikaForce-7737 L50 (formerly 1959)

Manufacturer/supplier information

Manufacturer/supplier:

Sika Danmark A/S

Street/postbox:

Præstemoosevej 2-4

Town/City and Post Code:

DK-3480 Fredensborg

Country:

Danmark

Phone:

(0045) 48 18 85 85

Telefax:

(0045) 48 18 84 96

General information:

-

Emergency information phone:

Giftinformations centralen

(Bispebjerg Hospital) telefon 35 31 60 60

2. Composition/information on ingredients

Chemical characterization

Modified polyol

3. Hazards identification

See chapter 11 and 12

4. First-aid measures

General instructions

In any case show the physician the Safety Data Sheet

After inhalation

In the event of symptoms take medical treatment.

After skin contact

In case of contact with skin wash off immediately with soap and water

Consult a doctor if skin irritation persists.

After eye contact

In case of contact with the eyes, rinse immediately for at least 15 minutes with plenty of water.

Summon a doctor immediately.

After ingestion

Do not induce vomiting.

Summon a doctor immediately.

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5. Fire-fighting measures

Suitable extinguishing media

compatible with all usual extinguishing media

Exposure hazard arising from the product, its combustion products or resulting gases

In the event of fire the following can be released:

Carbon monoxide (CO)

Carbondioxide (CO2)

Nitrogen oxides (NOx)

Additional information

Fire residues and contaminated firefighting medium must be disposed of in accordance with the local regulations.

Collect contaminated firefighting water separately, must not be discharged into the drains.

6. Accidental release measures

Personal precautions

Ensure adequate ventilation.

Use personal protective clothing.

Use breathing apparatus if exposed to vapours/dust/aerosol.

Environmental precautions

Do not allow to enter drains or waterways

In case of entry into waterways, soil or drains, inform the responsible authorities.

Procedures for cleaning up

Pick up with absorbent material (e.g. sand, sawdust, general-purpose binder).

When picked up, treat material as prescribed under heading "Disposal".

7. Handling and storage

Handling

Instructions for safe handling

See chapter 8 / Personal protective equipment.

Instructions for fire and explosion protection

Not applicable.

Storage

Requirements for storage rooms and containers

Keep container tightly closed and dry in a cool, well-ventilated place

Combined storage instructions

Keep away from food, beverages and animal feedstocks.

Additional information regarding storage

Protect from frost.

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7. Handling and storage (continued)

Protect from heat and direct sunlight
Protect from atmospheric moisture and water

8. Exposure controls/personal protection

Personal protective equipment

General protective and hygiene measures
Take care for sufficient ventilation or exhaust on the workshop place.
Avoid contact with eyes and skin
Use barrier skin cream.
Remove soiled or soaked clothing immediately.
Do not eat, drink or smoke during work time.
Wash hands before breaks and after work.

Respiratory protection
Not applicable.

Hand protection
Butyl rubber/nitrile rubber gloves

Eye protection
Safety glasses

Body protection
Working clothes

9. Physical and chemical properties

Appearance

Physical state: liquid
Colour: red

Data relevant to safety		Method
Flash point	> 101 °C	
Density at 20°C	1.6 g/cm ³	
Solubility in water	insoluble	
Viscosity at 20°C	approx. 11000 mPas	

10. Stability and reactivity

Materials to avoid/dangerous reactions

No hazardous reactions when stored and handled according to prescribed instructions.

Thermal decomposition and hazardous decomposition products

No decomposition if used as prescribed.

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11. Toxicological information

Experience on humans

When skin contact:

May cause irritation.

When eyes contact:

May cause irritation.

When inhalation:

May cause irritation.

When swallowed:

May cause health disorders.

12. Ecological information

Additional information

Do not allow to enter waste water drain, waterways or soil.

13. Disposal considerations

Product

Recommendations

Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

See chapter 15, national regulations.

Packaging

Recommendations

Completely emptied packagings may be given for recycling.

Empty packaging may still contain hazardous residues.

Empty packaging should be removed by a licensed waste contractor.

14. Transport information

ADR/RID

Further information

No dangerous goods.

IMO/IMDG

Marine pollutant: no

Further information

No dangerous goods.

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14. Transport information (continued)

IATA/ICAO

Further information

No dangerous goods.

15. Regulatory information

Labelling according to EEC Directive

The product does not require a hazard warning label in accordance with EC directives/the relevant national laws.

16. Other information

asterisk (*) on left margin marks modification of previous version

Recommended use: Chemical product for construction and industry

The information contained in this Safety Data Sheet corresponds to our level of knowledge at the time of publication. All warranties are excluded. Our most current General Sales Conditions shall apply. Please consult the Technical Data Sheet prior to any use and processing.