

# SikaForce<sup>®</sup>-7570 L03

## The Fast and Flexible Assembly adhesive

### Technical product data:

	Component A (Resin)	Component B (Hardener)
Reaction Mechanism	Polyaddition	
Chemical base	Polyols, filled	Isocyanate derivates, unfilled
Solid content	100 %	100 %
Colour	Black	Whitish
Mixing colour	Black	
Density (25°C) (CQP 553-1)	1,5 g / cm <sup>3</sup> approx.	1,2 g / cm <sup>3</sup> approx.
Viscosity (25°C) (CQP 538-1)	50.000 mPas approx.	20.000 mPas approx.
Mixing ratio	parts per weight part per volume	100 100
Pot life 25°C <sup>1)</sup> (CQP 536 -2)	3 min approx.	
Application temperature range	15 - 30°C	
Shore-A hardness <sup>2)</sup> (DIN 53505 / CQP 537-1)	60 approx.	
Tensile strength <sup>2)4)</sup> (ISO 527 / CQP 545-1)	2 MPa approx.	
Elongation at break <sup>2)4)</sup> (ISO 527 / CQP 545-1)	150% approx.	
Lap shear strength <sup>2)3)</sup> (DIN EN 1465 / CQP 546-1)	4 MPa approx. (substrate dependent)	
T-Peel strength (DIN 53282 / CQP 539-1) <sup>2)</sup>	200 N / 3 cm approx.	
E-Modulus <sup>2)4)</sup> (ISO 527 / CQP 545-1)	2 MPa approx.	
Green Strength 60°C (CQP 548-1)	0,5 MPa approx. after 5 min	
Shelf life (in original closed packaging)	6 months	

<sup>1)</sup> Cup method: 20 g component A + 3,4 g component B, conditioned in waterbath at 25°C

<sup>2)</sup> Testing temperature: 23°C and 50% relative humidity ; curing conditions: 48 hrs. RT + 3 hrs. 105°C + 24 hrs. RT

<sup>3)</sup> Substrate: AlCuMg<sub>2</sub> plated; film thickness: 1,0 mm

<sup>4)</sup> Film thickness of test sample: 4 mm

### Description

SikaForce<sup>®</sup>-7570 L03 is a flexible two component adhesive. It consists of a filled polyol based resin and an isocyanate based hardener. The components are processed by means of suitable metering and mixing machines.

SikaForce<sup>®</sup>-7570 L03 is manufactured in accordance with the ISO 9001/14001 quality assurance system.

### Product benefits

- Flexible
- Ageing resistant
- Room temperature curing
- Solvent free

### Areas of application

SikaForce<sup>®</sup>-7570 L03 is especially designed for flexible, industrial bonding of different materials like metals, ceramics, woods and wood derivatives.

### Cure mechanism

The curing of SikaForce®-7570 L03 takes place by chemical reaction of the two components.

Higher temperatures fasten the curing process, lower temperatures extend the curing process.

### Chemical resistance

SikaForce®-7570 L03 is resistant to hydrolysis. As the chemical resistance depends on type and condition of the substrate, chemical concentration, exposure duration and temperature, a project adapted adhesive performance test is strongly recommended. The same is valid for the temperature resistance. Without exposure to chemicals the adhesive is permanent resistant to temperatures up to 120°C. For short time exposure it resists even to higher temperatures.

In case of expected chemical or thermal exposure, we recommend a project related testing.

### Method of application

Bond-line application requires a metering machine with dynamic or static mixers. For advice on selecting and setting up a suitable pump system, as well on the techniques of pump operated application, please contact our System Engineering.

The application temperature must be higher than 15°C.

### Surface preparation.

Bonding area must be clean, dry and free from grease, oil and dust. Due to a variety of substrates and mechanical load requirements, technical consultations with our Technical Service are in any case advisable.

### Cleaning up.

SikaForce®-7570 L03 in uncured state may be removed from tools and equipment with Sika® Remover-208, isopropanol, acetone, etc. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean Towels or a suitable industrial hand cleaner and water. Do not use solvents!

### Storage conditions

Resin and Hardener are sensitive to moisture. Therefore they have to be stored in tightly closed containers. After product take-out the containers have to be closed immediately.

The resin must be stored between 15 - 30°C.

The hardener must be stored between 15 - 30°C.

During delivery both components can be exposed to temperatures down to 0°C for a maximum of 3 days. Do not use crystallized or inhomogeneous components.

### Further information

The following publications are available on request:

- Material Safety Data Sheet

### Packaging information

Component A (Resin)	Hobbock 25 kg Drum 300 kg
Component B (Hardener)	Hobbock 20 kg Drum 200 kg

### Important

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the relevant Safety Data Sheet(s) containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance.

### Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

For specific advice concerning preparation of the substrates or the choice of appropriate application devices, please contact our Technical Service.



Sika Automotive GmbH  
Reichsbahnstr. 99  
D-22525 Hamburg  
Germany  
Tel.: +49 40 540 02-0  
Fax: +49 40 540 02-241