

# SikaForce® -7900

High performance adhesive for aluminum assembly

## Technical Product Data

Properties	Component A SikaForce® -7900	Component B SikaForce® -7900
Chemical base	Polyols	Isocyanate derivatives
Color (CQP <sup>1</sup> 001-1)	White	Brown
Color mixed	Cream White	
Curing mechanism	Polyaddition	
Density (CQP 553-2)	1.43 g/cm <sup>3</sup> approx.	1.61 g/cm <sup>3</sup> approx.
Density mixed (calculated)	1.52 g/cm <sup>3</sup> approx.	
Mixing ratio	by volume by weight	1 : 1 1 : 0.9
Solids content	100 %	
Consistency (mixed)	Thixotropic paste	
Application temperature	ambient	10 - 35 °C (50 - 95 °F)
Application time <sup>2</sup> (CQP 536-3)	25 min. approx.	
Pot life <sup>2</sup> (CQP 536-3)	50 min. approx.	
Shore D hardness <sup>2</sup> (CQP 537-2 / DIN 53505)	85 approx.	
Tensile strength (CQP 545-2 / ISO 527)	32 N/mm <sup>2</sup> approx.	
Elongation at break (CQP 545-2 / ISO 527)	1.5 % approx.	
E-Modulus (CQP 545-2 / ISO 527)	3200 N/mm <sup>2</sup> approx.	
Glass transition temperature (DIN 51007)	61 °C (142 °F) approx.	
Shelf life (CQP 016-1) (storage between 10 °C and 30 °C)	12 months	12 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23 °C (73 °F) / 50 % r.h.

### Description

SikaForce®-7900 is a two component polyurethane adhesive which cures by chemical reaction of the two components to form a durable polymer. The two components are applied via side by side cartridge by means of a manual or pneumatic driven gun and mixed homogeneously with the supplied static mixer.

### Product Benefits

- Good non-sag property
- High strength and modulus for structural bonding applications
- Ageing resistant
- Easy application
- Does not contain solvent
- Can be overpainted

### Areas of Application

SikaForce®-7900 is suitable for corner bonding of powder coated and anodized aluminum frames and sash frame profiles, usually used for windows, doors and façade's.

This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



PDS Approval for Trading Products		Place Company stamp below
The original product name is: _____		
<b>The manufacturer approves the validity of this Product Data Sheet.</b>		
Name / first name:	_____	
Function:	_____	
Date / signature:	_____	

### Cure Mechanism

The curing of SikaForce®-7900 takes place by chemical reaction of the two components. Higher temperatures speed up and lower temperatures slow down the curing process.

### Method of Application

#### Surface preparation

Surfaces must be clean, dry and free from oil, grease and dust.

Usually bonding takes place on chemical pretreated, painted or coated aluminum.

Advice on specific applications and surface pre-treatments is available from the Technical Department of Sika Industry.

#### Application

The adhesive is applied out of the side by side cartridge using a suitable manual driven or air pressured piston cartridge gun. When the cartridge is opened and the static mixer is installed, extrude approx. 20 g of the mixed adhesive. Check about the color of the adhesive and make sure it is mixed properly (no strings in the bead). Apply mixed adhesive within application time.

### Cleaning

Uncured SikaForce®-7900 may be removed from tools and equipment with SikaForce®-7260 Cleaner. Once cured, the material can only be removed mechanically.

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

### Storage Conditions

SikaForce®-7900 has 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 need to be protected against humidity. The minimum temperature during transportation is 0 °C.

### Further Information

The following publications are available on request:

- Safety Data Sheet

### Packaging Information

#### SikaForce®-7900

Cartridge	600 ml
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### Value Bases

All technical data stated in this Product Data Sheet 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.

### Legal Notes

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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:

[www.sika.ch](http://www.sika.ch)  
[www.sika.com](http://www.sika.com)

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