



**SikaForce<sup>®</sup>-7712**  
**3-COMPONENT PUR ADHESIVE**  
**FOR SANDWICH PANEL BONDING**

## PRODUCT DESCRIPTION

SikaForce®-7712 is a 3-component PUR adhesive solution for bonding sandwich panels. The solution comprises two A components, one fast curing and one slow curing and a B component. The two A components can be mixed in any ratio to achieve the optimal panel production speed, depending on the complexity of the panels being produced and the workshop ambient temperature. Bead application machines designed for 3 components, available from machine suppliers, can be used to pump, meter and mix the two A components and the B component. The result is one adhesive system that can be adjusted on the application machine to give a range of open and press times.



## FEATURES AND BENEFITS

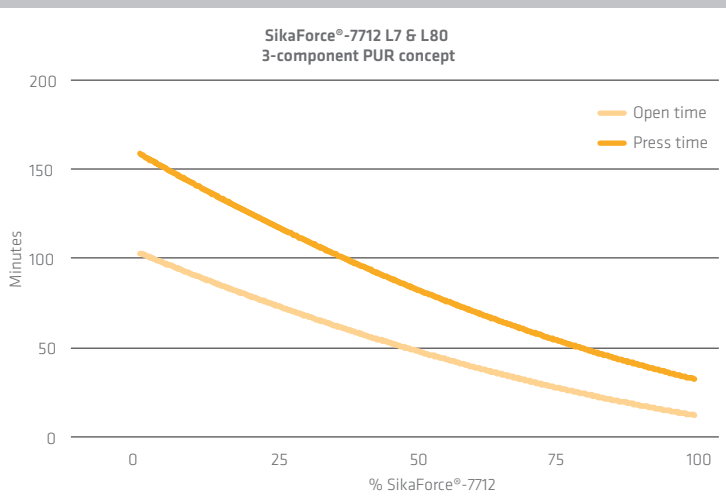
- Faster panel production
- Increased productivity
- One system for all types of panels
- Compensate varying climatic workshop conditions

## TECHNICAL DATA

Chemical base	3-Component PUR
Colour mixed	Beige
Cure mechanism	Poly addition
Density mixed	1.4 g/cm <sup>3</sup> approx.
Mixing ratio (A:B)	by volume 100 : 30 by weight 100 : 26
Tensile lap-shear strength <sup>1</sup>	12 N/mm <sup>2</sup>
Open time <sup>2</sup>	12 min. approx. (L7) 110 min. approx. (L80)
Press time <sup>2</sup>	30 min. approx. (L7) 160 min. approx. (L80)

<sup>1</sup>) Curing conditions: 21 days at 23°C / 50% RH

<sup>2</sup>) 23°C / 50% RH



Our most current General Sales Conditions shall apply.  
Please consult the Data Sheet prior to any use and processing.

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