

PRODUCT OVERVIEW

SELECTOR GUIDE



Ref.		Application, description	Colour	Liquid	Viscous	Pasty	Open time	Hardness (shore)	Viscosity (Pa.s.)	Handling time HT 23°C / HT 60°C	Lap shear strength on alu (MPa)	Peel resistance (kN/m)	Elongation at break (%)	Substrates								Resistance					50 ml	400 ml	Other sizes	Industrial packages		
														Ferrous metals	Non ferrous metals	Composites, laminates	Thermoplasts	Glass, ceramics	Foam materials (PU, PS)	Elastomer, rubber	Polyurethane (hard)	Temperature	Chemically	Water	Shear stress	Peel stress					Ageing	
POLYURETHANE																																
SikaForce®-410 L60	A210	Bonding of bodywork, metallic structures (racing vehicles and aeronautics), of inserts and composite structures.				X	60'	93A	thixo	5h	10	5	80	0	+	++	+	+	+	+	+	+	+	+	+	+	+	+	X	X		
SikaForce®-410 L60 FR	A211 BG	For electronic components bonding. Self-extinguishing adhesive with FAR 25.853.				X	40'	95A	thixo	4h	10	9	80	0	+	++	+	+	+	+	+	+	+	+	+	+	+	+	X			
SikaForce®-490 L15	A220	Excellent for vibration, impact and noise dampening. Excellent behavior at low temperature. Product adapted to assemblies involving dissimilar materials with regular glue thickness. Impact resistance: 30 N/mm.				X	15'	48D	150	60' (15')	16	12	95	0	+	++	+	+	+	+	+	+	+	++	++	++	+	X	X		Kit & drum	
SikaForce®-430 L10	A230	Bonding of composite parts (RTM, SMC, laminate,...) & metallic structures. High strength & high peel combined with flexibility. Suitable for vertical applications and to fill irregular joints.			X		6'	70D	thixo	35' (10')	15	6	30	++	++	++	+	0	+	0	++	+	+	++	++	+	+		X		Drum	
SikaForce®-436 L25 SikaForce®-436 L120	A236	Allows gaps up to 40mm and parts assembly with large dimensions (deck/hull, wind mill). Various reactivities and colours. Machine or hand mix version.				X	25' 120'	55D	pasty	3,5h (1,5h) 6h (3h)	16	5	60	++	++	++	0	0	++	0	+	+	++	++	++	+	++		X		Kit & drum	
SikaForce®-453 L04	A252	Non sagging paste product suitable for vertical applications and to fill irregular joints. Fast setting product to reduce assembly time. High flexibility. Impact Resist: 50 N/mm.				X	4'	75A	600	60' (10')	12	9	300	0	+	++	+	++	+	++	+	0	0	++	0	++	+	X	X		Drum	
SikaForce®-458 L25	A256-25	Recommended for plastics bonding sensitive to the phenomenon of bond line witness marks (composite, thermoplastic). Broad spectrum of accession. Available in two reactivities, can be used in thick seal, vertical or ceiling.				X	4'	80A	pasty	90'	5	7	200	+	+	++	++	++	++	++	+	+	0	++	+	++	++		X	400 ml	Drum	
SikaForce®-457 L05	A257 BK	Recommended for the bonding of plastics sensitive to the phenomena of bond line witness marks (composite, thermoplastic). Low hardness. Flexible product. Short handling with limited heating. Impact Resist: 55 N/mm.				X	5'	60A	pasty	90' (2)	5	10	350	+	+	++	++	++	++	0	+	+	+	++	+	++	++		X		Drum	
SikaForce®-490 L03 SikaForce®-490 L10	A290 A280	Structural bonding of spoiler, metallic inserts/big head to composites. Vibration absorbing. Good chemical resistance. Short handling with limited heating. Impact Resist: 30 N/mm.				X	3' 10'	48D	150	10' (4') 45' (10')	16	12	95	+	+	++	+	+	+	+	++	+	+	++	++	++	+	X	X		Drum	
SikaForce®-440 L07	A730	High performance bonding for assembly requiring high modulus and stiffness. White UV stable and sandable. Safe PU.			X		6'	85	20	30'	25	2	10	++	++	++	+	0	0	0	+	+	++	++	++	+	++		X	400 ml		
METHACRYLATE																																
SikaFast®-300 SikaFast®-310	A300-1 A310-1	Excellent mechanical and thermal performances up to 120°C. Multipurpose product with thermoplastic aspect. Product able to bond dissimilar materials.				X	5' 10'	75D	pasty	20' 40'	24	9	30 35	++	++	++	++	0	0	0	0	++	+	++	++	+	++	X	X		Drum	
EPOXY																																
SikaPower®-730	A130	Fast cure at room temperature. Suitable for injection. Bonding of substrates such as composites, metal, wood, concrete.	Transparent	X	X		6'	75D 85D	45 15	12'	17	1.5	3	+	+	+	0	+	++	0	++	0	0	+	++	0	+	X X		200 ml	Kit & drum	
SikaPower®-740	A140-1	Multipurpose with very good mechanical features. Pasty non sagging gap filler material. Impact Resist: 10 N/mm.				X	40'	80D	430	4h30' (30')	20	6	4	++	++	++	0	++	++	0	++	++	+	++	++	+	+	X	X		Kit & drum	
SikaPower®-755	A155	Pasty constructive adhesive with long pot life. For large composite parts, repair and maintenance. Good mechanical performance & chemical and temperature resistance. Impact Resist: 15 N/mm.				X	60'	84D	160	10h (1')	35	3	8.5	+	+	++	0	+	++	+	++	++	+	++	++	0	++		X	400 ml	Drum	
SikaPower®-770 SikaPower®-771 FR	A170-1 A171-1	High performances room temperature curing adhesive. Slow setting product adapted to cover and bond wide surfaces. A 171: self-extinguishing adhesive with FAR 25.853.				X	30' 50'	83D	1600 130	3h30'	24 20	5 3	3	++	++	++	0	++	++	+	++	++	+	++	++	+	0	X X			Drum	
SikaPower®-775	A175-1	High performances room temperature curing adhesive. Slow setting product adapted to bond wide surfaces and heavy duty applications subject to impact or vibration. Shock resistant.				X	90'	80D	940	10h (45')	21	4	5	++	++	++	0	++	++	+	++	++	++	++	++	+	++		X		Drum	
SikaPower®-711	H9011	Multipurpose liquid adhesive. Bond most of materials. For general industry and maintenance.	Transparent	X			100'	75D	45	7h (30')	24	5	9	++	++	++	+	+	++	+	+	+	++	++	+	++	X	X	200 ml	Kit & drum		
SikaPower®-750 SikaPower®-750 T	H9950 H9950T	Non-filled adhesive. High structural performances and low outgassing for aerospace applications. Large sizes bodies, structural and panel bonding. Long open time.			X	X	2h	80D	50 200	4h	15	3	3	++	++	++	0	+	++	0	+	++	++	++	++	+	++				Drum	
SikaPower®-751 SikaPower®-751 T	H9951-1 H9951-1-T	Non-filled adhesive for bonding large surfaces (ie panels) when mechanical and ageing as well as high peel resistance is needed. T for thixotropic product (hot cure process). Used in railway.		X	X		40'	75D	9 28	6h	26	4	10	++	++	++	+	+	+	0	++	++	+	+	++	+	++				Kit & drum	
SikaPower®-752 L120 FR BLACK	H9952 BK	High shear/peel/ageing resistance. Filled with Nanoparticles. Short handling time with limited heating. Self-extinguishing according to EN 45545-2, FAR 25 (FAR 25.853 @ 60s) and AITM (ABD0031) standards.				X	120'	85D	230	8h (30')	25	5	3	++	++	++	+	0	++	0	+	++	++	++	++	+	++	X	X	400 ml	Drum	

T = Thixotropic, FR= Fire Regulation
++ Very well + Well 0 Medium