

# SikaForce® -7570 HP L05

Flexible assembly adhesive for hang on parts

## Typical Technical Data

Properties	Component A SikaForce®- 7570 HP L05 (A)	Component B SikaForce®-7570 (B)
Chemical base	Polyols, filled	Isocyanate derivates
Color (CQP <sup>1</sup> 001-1)	Black	White
Color mixed	Black	
Cure mechanism	Polyaddition	
Density (CQP 553-1)	1.5 kg/l	1.2 kg/l
Mixing ratio	by volume by weight	100 : 20 100 : 17
Viscosity (CQP 029-9)	50'000 mPa s	20'000 mPa s
Application temperature	15 - 25 °C	
Pot life (CQP 536-2)	measured until 500 Pa s 5 min	
Shore A hardness <sup>1</sup> (CQP 537-1)	60	
Tensile strength <sup>1,3</sup> (CQP 545-1/ ISO 527)	3.5 N/mm <sup>2</sup>	
Elongation at break <sup>1,3</sup> (CQP 545-1/ ISO 527)	250 %	
Tensile lap-shear strength <sup>1,2</sup> (CQP 546-1/ EN 1465)	3.1 N/mm <sup>2</sup>	
E-Modulus <sup>1,3</sup> (ISO 527/ CQP 545-1)	4.7 N/mm <sup>2</sup>	
Shelf life	6 months	

<sup>1)</sup> 7 days at 23 °C/ 50% r.h.

<sup>2)</sup> e-coated steel; bonding area 45x15 mm

<sup>3)</sup> ISO-527-2 Type 5A

### Description

SikaForce®-7570 HP L05 is a flexible two component adhesive. It consists of a filled polyol based resin and an isocyanate based hardener.

### Product Benefits

- Perfect balance of strength and flexibility
- Very good ageing resistance
- Curing at room temperature
- Free of solvents and plasticizers
- minimized risk for stress cracking
- Broad adhesion range
- Suitable for primerless bonding of several plastics
- Short handling time when curing under temperature
- Application by cartridge possible

### Areas of Application

SikaForce®-7570 HP L05 is designed for bonding automotive parts like spoilers, covers, back door, etc.. SikaForce®-7570 HP L05 can be used to bond different substrates like e-coated metals or plastics (PC/ABS, PC/PET, PBT, etc.). This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



\* This product is currently in the field test phase and has not been finally released. Technical data stated herein is based on preliminary testing and experience and is subject to change. Product is only suitable for experienced users and only after suitable pre-testing. Subject to mandatory legal provisions, Sika's liability is limited to the replacement of the defective products.

### Cure Mechanism

The curing of SikaForce®-7570 HP L05 takes place by chemical reaction of the two components. Higher temperatures (max. 100 °C) speed up and lower temperatures do slow down the curing process.

When curing at 23 °C after 24 h approx. 70 % of the final strength will be reached.

Full cure and final adhesion performance is achieved after 7 days, when cured at standard conditions.

### Chemical Resistance

SikaForce®-7570 HP L05 is resistant to hydrolysis. The chemical resistance is influenced by several factors such as chemical composition, concentration, period of exposure and temperature. Therefore a project related testing in case of chemical or thermal exposure is required.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

### Method of Application

#### Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Based on the surface and type of material, a physical or chemical pre-treatment might be required. Type of pre-treatment must be determined by tests.

Advice on specific applications is available from the Technical Department of Sika Industry.

### Application

To process SikaForce®-7570 HP L05 proper dosing units and mixers are required; static or dynamic mixing devices can be used. The selection of the mixing device requires process orientated trials. For automated applications a suitable filter system is recommended. The curing can be accelerated and the adhesion can sometimes be improved by heat.

After opening of the packaging SikaForce®-7570 HP L05 must be protected against humidity. It could be possible that yellowing on the surface of the hardener appears. That is not a quality defect.

Never use crystalized or inhomogeneous components.

Further details especially in combination with automated applications can be obtained from the System Engineering Department of Sika Industry.

### Removal

Uncured SikaForce®-7570 HP L05 may be removed from tools and equipment with Sika®Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika®Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents!

### Storage conditions

SikaForce®-7570 HP L05 resin and hardener have to be stored at temperature between 5 °C and 25 °C in a dry place. For transportation purposes, the storage temperature can be exceeded for a period of max. 2 weeks from 0 °C up to 40 °C.

It is possible that the hardener is slightly yellowing on the surface which does not influence the quality of the product.

Never use crystalized or inhomogeneous components.

### Further Information

Copies of the following publications are available on request:

- Safety Data Sheet

### Packaging Information

Component A Resin	Pail 25 kg Drum 300 kg
Component B Hardener	Pail 20 kg Drum 200 kg
Cartridge	270 ml

### Bases of Product Data

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 should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

### Disclaimer

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.sikaautomotive.com](http://www.sikaautomotive.com)

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