

## PRODUCT DATA SHEET

# SikaForce®-800 Blue

Fast curing profile and surface filler for blade repair applications

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaForce®-800 Blue (A)	SikaForce®-7800 (B)
Chemical base	Polyols	Isocyanate derivatives
Colour (CQP001-1)	Light blue	Brown
mixed	Light blue	
Cure mechanism	Polyaddition	
Density (uncured)	1.38 kg/l <sup>A</sup>	1.23 kg/l <sup>A</sup>
mixed (calculated)	1.33 kg/l <sup>A</sup>	
Solid content	100 %	
Mixing ratio	by volume 100 : 50	
Viscosity (CQP029-4)	25 mm PP, d = 1 mm, 10 s <sup>-1</sup> 35 Pa·s <sup>A</sup>	15 Pa·s <sup>A</sup>
Consistency	Thixotropic paste	
Application temperature	5 – 30 °C	
Working time	2.5 minutes <sup>A</sup>	
Sanding time	at 5 °C 40 minutes at 10 °C 30 minutes at 15 °C 15 minutes	
Glass transition temperature (ISO 11357)	55 °C	
Shelf life	15 months <sup>C</sup>	

CQP = Corporate Quality Procedure  
C) storage between 10 and 30 °C

A) 23 °C / 50 % r.h.

B) tested at 2 mm/min

## DESCRIPTION

SikaForce®-800 Blue is a two component polyurethane based profile and surface filler that works best at temperature below 15 °C. If ambient temperatures are higher than 15 °C it is advisable to use SikaForce®-7800 RED.

## PRODUCT BENEFITS

- Superior mixing, application and tooling properties
- Very good adhesion to GFRP
- Non-sag up to layer thicknesses of approx. 20 mm
- Fast sanding time
- Easy to sand, does not clog the sandpaper

## AREAS OF APPLICATION

SikaForce®-800 Blue is used for profile shaping and surface filling of damaged rotor blades in the wind turbine industry. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

The curing of SikaForce®-800 Blue takes place by a chemical reaction of the two components. Higher temperatures speed up the curing process and lower slow it down.

CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. After the cleaning process, a physical or chemical pretreatment might be required, depending on surface and type of material. The type of pretreatment must be determined by tests.

Application

For the cartridge application use a suitable manual or a compressed air piston-type cartridge gun. To ensure good mixing quality a static mixer of type Sulzer MixPac® Quadro MGQ 08-20T is to be used.  
Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose the first few cm of the bead before the application.

Removal

Uncured SikaForce®-800 Blue may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.  
Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.  
Do not use solvents on skin.

STORAGE CONDITIONS

SikaForce®-800 Blue has to be kept between 10 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost. After opening of the packaging, the content has to be protected against humidity.  
Minimum temperature during transportation is -20 °C for maximum 7 days

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.  
Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

SikaForce®-800 Blue

Cartridge (2C)	195 ml
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BASIS OF PRODUCT DATA

All technical data stated in this document 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.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse 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.

