BUILDING TRUST

PRODUCT DATA SHEET

SikaPower®-755

High-performance 2-component structural adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		SikaPower®-755 (A)	SikaPower®-755 (B)
Chemical base		Epoxy	Amine
Color (CQP001-1)		White	White
	mixed	White	
Density		1.16 kg/l	1.07 kg/l
	mixed (calculated)	1.12 kg/l	
Mixing ratio	by volume	100 : 50	
	by weight	100 : 47	
Viscosity (CQP029-4)	at 25 °C, shear rate 18 s^{-1}	65 Pa·s	
	at 25 °C, shear rate 0.9 s^{-1}		200 Pa·s
Consistency		Thixotropic paste	
Application temperature		15 – 30 °C	
Open time (CQP046-11 / ISO 4587)		60 minutes [A, B]	
Handling time (CQP046-11 / ISO 4587)		10 hours [A, B]	
Shore D hardness (CQP023-1 / ISO 868)		83 [C]	
Tensile strength (CQP543-1 / ISO 527)		53 MPa [A, C, D]	
E-Modulus (CQP543-1 / ISO 527)		1900 MPa [A, C, D]	
Elongation at break (CQP543-1 / ISO 527)		8.5 % [A, C, D]	
Tensile lap-shear strength (CQP046-9 / ISO 4587)		35 MPa [A, B, C]	
Shelf life		12 months	

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

B) adhesive layer: 25 x 12.5 x 0.3 mm / on epoxy composite

C) cured for 16 hours at 70 °C

D) specimen type 1A acc. to ISO 527

DESCRIPTION

SikaPower®-755 is a high-performance 2-component epoxy adhesive that cures at room temperature.
It is suitable for bonding metallic and composite substrates, offering very good application properties. This adhesive is designed to withstand a wide service temperature range, from -40 to 130°C.

PRODUCT BENEFITS

- Non-sagging pasty adhesive, suitable for vertical application and filling of irregular joints
- Long open time to cover and bond wide surfaces
- Good mechanical and thermal properties
- High resistance to dynamic loads, including vibrations and impacts
- Long durability, with good ageing resistance

AREAS OF APPLICATION

SikaPower®-755 is designed for bonding large parts in transportation and general industry that require high mechanical strength and good ageing resistance.
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
SikaPower®-755 cures by chemical reaction of the two components at room temperature. The cure rate is accelerated at higher temperatures, e.g. using ovens or infrared lamps. Final mechanical properties may be increased with higher curing temperature.

CHEMICAL RESISTANCE
In view of potential chemical or thermal exposure, it is required to conduct a project related testing.

METHOD OF APPLICATION
Surface preparation
Surfaces must be clean, dry and free from grease, oil and dust. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. All pretreatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application
SikaPower®-755 is applied from 1:1 dual cartridge with adequate dispenser. The use of electric or pneumatic dispensers with piston-driven plungers is recommended.
Extrude adhesive without mixer to equalize the filling levels. Attach the defined mixer and dispose of the first few cm of the bead before the application.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal
Uncured SikaPower®-755 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 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
SikaPower®-755 has to be kept between 15 °C and 25 °C in a dry place. Do not expose it to direct sunlight or frost.
After opening of the packaging, the contents have to be protected against humidity.

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
- ATI: Mixer alternatives for cartridges

PACKAGING INFORMATION
SikaPower®-755 (A+B)

Dual cartridge	400 ml
Mixer: MixPac™ MCH 10-24T	

SikaPower®-755 (A)

Pail	30 kg

SikaPower®-755 (B)

Pail	30 kg

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 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.

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