BUILDING TRUST

PRODUCT DATA SHEET

SikaForce®-325 CB

Two component heat conductive and flame retardant polyurethane structural adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		Component A SikaForce®-325 CB (A)	Component B SikaForce®-325 CB (B)
Chemical base		Polyols	Isocyanates
Color		Grey	Off-white
(CQP001-1)	mixed	Grey	
Cure mechanism		Poly addition	
Density		1.81 Kg/L	1.84 Kg/L
(uncured)	mixed	1.83 Kg/L	
Mixing ratio	by volume	1 : 1	
	by weight	1 : 1	
Viscosity (CQP538-2)		Paste	
Pot-life (CQP536-3)		30 min [A]	
Shore D hardness (CQP023-1 / ISO 868)		65	
Thermal conductivity (ASTM D5470)		1.2 W/m·K	
Flammability (UL 94-2013 Rev.7-2017 s.8)		V0	
Tensile strength (CQP036-2 / ISO527-2)		15 MPa	
Elongation at break (CQP036-2 / ISO 527-2)		20 %	
Tensile lap-shear strength (CQP546-1 / ISO 4587)		10 MPa	
Service temperature (CQP509-1 / CQP513-1)		-40 — 120 °C	
Shelf life		6 months [B]	

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r. h.

B) stored (unopened) in a dry place at 15 - 25 °C

DESCRIPTION

SikaForce®-325 CB is a 2-component, high-strength, thixotropic polyurethane structural adhesive. It has good thermal conductivity and flame retardancy.

PRODUCT BENEFITS

- High strength
- High thermal conductivity
- Flame retardant and self extinguishing
- Solvent free

AREAS OF APPLICATION

SikaForce®-325 CB is used for structural bonding with high strength, thermal conductivity and flame retardant requirements.

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®-325 CB 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. Please consult the Technical Service Department of Sika Industry for advice.

METHOD OF APPLICATION
Surface preparation
It is generally necessary to prepare the items for bonding to ensure optimal adhesion and strength. Type of pre-treatment must be determined by tests. Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application
Cartrideg use: SikaForce®-325 CB can dispensed from dual cartridges with adequate pneumatic guns. Extrude adhesive without mixer to equalized the filling levels. Attach the mixer and dispose of the first few cm of the bead before the application. To ensure good mixing quality a static mixer of type Sulzer Mixpac 10.7z-19 to be used. Other static mixers may be suitable but have to be thoroughly tested beforehand.

SikaForce®-325 CB is dispensed from pails or drums with adequate 2-component equipment.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal
Uncured SikaForce®-325 CB 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.

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
Dual cartridge	400 ml
Cartridge	160 ml 600 ml
Pail	23 L
Drum	195 L

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.

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