

PRODUCT DATA SHEET

SikaForce®-317 L14

Low viscosity, structural assembly adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaForce®-317 L14 (A)	SikaForce®-317 (B)
Chemical base	Polyols	Isocyanate derivatives
Color (CQP001-1)	Grey	Yellowish
mixed	Grey	
Cure mechanism	Polyaddition	
Density (uncured)	1.57 kg/l	1.21 kg/l
mixed (calculated)	1.47 kg/l	
Solid content	100 %	100 %
Mixing ratio	by volume 100 : 40 by weight 100 : 30	
Viscosity (CQP029-4)	Rheometer, PP25, shear rate 10 s ⁻¹ , d=1 mm mixed 8000 mPa·s ^A	8000 mPa·s ^A
Application temperature	15 – 30 °C	
Pot life (CQP536-1)	14 minutes ^A	
T-peel strength (CQP539-1)	60 N/cm ^{A, B}	
Shore D hardness (CQP023-1 / ISO 868)	70 ^{A, B}	
Tensile strength (CQP543-1 / ISO 527)	16 MPa ^{A, B}	
Elongation at break (CQP543-1 / ISO 527)	100 % ^{A, B}	
Tensile lap-shear strength (CQP546-1 / ISO 4587)	20 MPa ^{A, B, C}	
Shelf life	9 months	

CQP = Corporate Quality Procedure

^{B)} curing conditions: 48 h 23 °C/ 50 % r.h.+ 3 h 105 °C+ 24 h 23 °C/ 50 % r.h.^{A)} 23 °C / 50 % r. h.^{C)} Substrate: AlCuMg2 platinated, adhesive thickness: 1 mm

DESCRIPTION

SikaForce®-317 L14 is a 2-component polyurethane adhesive for industrial assembly applications.

It has been specifically designed for the assembly of condensers.

PRODUCT BENEFITS

- Room temperature curing
- Solvent free
- High strength
- Good flexibility
- Adhesion to a wide range of substrates

AREAS OF APPLICATION

SikaForce®-317 L14 is a low viscosity, hard, tough and elasticized 2-component adhesive with adhesion on different types of substrates like metals and plastics.

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®-317 L14 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 pre-treatment might be required, depending on surface and type of material.

The type of pre-treatment must be determined by tests.

Application

Volume and positioning of the adhesive must be defined in a way, that the intended gap is sufficiently filled after joining the parts. The specific applied quantity and position must be determined by tests.

Apply the Product and join parts together. Consider that, if mixed in larger amounts, the exothermic reaction can reduce pot-life significantly.

The components are processed by means of suitable metering and mixing machines.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured SikaForce®-317 L14 may be removed from tools and equipment with SikaForce®-096 Cleaner. 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®-317 L14 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.

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®-317 L14 (A)

Drum	250 kg
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SikaForce®-317 (B)

Drum	200 kg
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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.

PRODUCT DATA SHEET

SikaForce®-317 L14
Version 01.01 (05 - 2025), en_DE
012104533170001020

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