BUILDING TRUST

PRODUCT DATA SHEET

SikaCor®-420 Blade

2-pack Pore Filler, solvent free

DESCRIPTION

SikaCor®-420 Blade is a solvent free, 2-pack pore filler for rotor blades.

Solvent free referring to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04)

USES

SikaCor®-420 Blade may only be used by experienced professionals.

SikaCor®-420 Blade is used as pore filler between putty and top coat.

CHARACTERISTICS / ADVANTAGES

- High adhesion
- Fast curing and grinding time
- Adhesion directly on glass fibre reinforced plastic

PRODUCT INFORMATION

Packaging	SikaCor®-420 Blade (A)	8 kg net.		
	SikaCor®-420 Blade (B)	3.5 kg net.		
	Other packaging upon request.			
Appearance and colour	Yellow-translucent, grey			
Shelf life	12 month			
Storage conditions	In originally sealed containers in a cool and dry environment.			
Density	1.6 kg/l			
Solid content	~96 % by volume ~98 % by weight			
Viscosity	Comp. A+B	Comp. A	Comp. B	(DIN 53019-1)
	$\dot{\gamma}$=100 s^{-1}: ~5 Pa s	$\dot{\gamma}$=100 s^{-1}: ~8 Pa s	$\dot{\gamma}$=500 s^{-1}: ~1 Pa s	
	$\dot{\gamma}$=10 s^{-1}: ~7 Pa s	$\dot{\gamma}$=10 s^{-1}: ~13 Pa s		

TECHNICAL INFORMATION

Shore D Hardness	D = 60-70	(ISO 868)
Mechanical resistance	Resistant against erosion.	

Tensile strain at break	5 % Tensile stress at yield: 45 MPa	(DIN 53504)
Chemical resistance	SikaCor®-420 Blade in combination with the complete coating system is resistant against weathering.	

SYSTEM INFORMATION

System

Rotor blade:
1 x SikaCor®-350 Blade (fine putty)
1 x SikaCor®-420 Blade (pore filler)
1 x SikaCor®-550 Blade (top coat)

APPLICATION INFORMATION

Mixing ratio

Components A:B	
By weight	100 : 24

Consumption

Theoretical material-consumption/VOC without loss for medium dry film thickness:

Dry film thickness	150 µm
Wet film thickness	155 µm
Consumption	0.232 kg/m²
VOC	4.6 g/m²

Material temperature

Min. + 20°C

Relative air humidity

Max. 85 %, surface temperature shall be at least 3 K above dew point.

Substrate temperature

Min. + 20°C

Pot Life

Climate	
At 20°C / 20 % RH	~20 minutes
At 23°C / 50 % RH	~15 minutes
At 30°C / 80 % RH	~15 minutes

Curing time

Drying Stages (ISO 9117-5)

Climate 23°C/50 % RH	DS 1	DS 6	DS 7	Grindable
50 µm	15 min	30 min	60 min	when DS 6 is achieved
150 µm	20 min	60 min	120 min	when DS 6 is achieved

Waiting time to overcoating

Climate	Min.	Max.
23°C / 50 % RH	1 h	72 h

In case of waiting time > 72 h carefully grinding of the surface with sand paper (grain size 180 to 240) is required. Before overcoating with top coat we recommend to grind the surface first.

BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

IMPORTANT CONSIDERATIONS

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

Glass fibre and putty: Lightly grinding the surface carefully

Cupper, cast aluminium and powder coatings have to be primed with Sika Primer-207.
The surface has to be clean, dry, dust free and free of any separating agents and contaminations.

MIXING

Mix component A and B in the recommended mixing ratio and stir very thoroughly using a mechanical mixer (start slowly). The material must be homogeneous and streakfree.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

Putty:
Spread and smooth out with suitable metal and plastic trowel.

Roller:
With suitable short piled roller or foam roller

CLEANING OF EQUIPMENT

Sika Thinner P

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

LEGAL NOTES

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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