

## PRODUCT DATA SHEET

# SikaCor®-360 Blade

2-pack Polyurethane Putty, solvent free

### DESCRIPTION

SikaCor®-360 Blade is a solvent free, 2-pack putty based on aliphatic polyurethane for rotor blades.

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

### USES

SikaCor®-360 Blade may only be used by experienced professionals.

SikaCor®-360 Blade is used as grindable putty for leveling the surface of rotor blades.

### CHARACTERISTICS / ADVANTAGES

- High adhesion
- Fast curing and grinding time
- High mechanical resistant
- Resistant against weathering

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor®-360 Blade (A)	15 kg net.
	SikaCor®-350 Blade/360 Blade (B):	5 kg net.
Other packaging upon request.		
<b>Appearance and colour</b>	grey	
<b>Shelf life</b>	12 months	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.	
<b>Density</b>	~1.71 kg/l	
<b>Solid content</b>	~100 % by volume	
	~100 % by weight	
<b>Viscosity</b>	Component A	Component B
	$\dot{\gamma}=250 \text{ s}^{-1}$ : ~40 Pa s	$\dot{\gamma}=500 \text{ s}^{-1}$ : ~6 Pa s
	$\dot{\gamma}=5 \text{ s}^{-1}$ : ~50 Pa s	$\dot{\gamma}=10 \text{ s}^{-1}$ : ~8 Pa s

## TECHNICAL INFORMATION

Shore D Hardness	D = 50-60	(ISO 868)
Mechanical resistance	Resistant against erosion.	
Tensile strain at break	35 % Tensile stress at yield: 10 MPa	(DIN 53504)
Tensile adhesion strength	~ 8 MPa on glass fibre reinforced plastic with Inmould	(ISO 4624)
Chemical resistance	SikaCor®-360 Blade in combination with the complete coating system is resistant against weathering.	

## SYSTEM INFORMATION

System	<u>Rotor blade:</u> 1 x SikaCor®-360 Blade (putty) 1 x SikaCor®-420 Blade (pore filler) 1 x SikaCor®-550 Blade (top coat)
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## APPLICATION INFORMATION

Mixing ratio	Components A : B			
	By weight	100	44.4	
	By volume	1.7	1	
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness:			
	Dry film thickness	1000	µm	
	Wet film thickness	1000	µm	
	Consumption	1.65	kg/m <sup>2</sup>	
	VOC	0	g/m <sup>2</sup>	
	The putty is sag resistant up to approx. 5000 µm.			
Material temperature	Min. + 15°C			
Relative air humidity	Max. 85 %, surface temperature shall be at least 3 K above dew point.			
Substrate temperature	Min.+ 15°C			
Pot Life	At 20°C / 20 % RH	~3	min	
	At 23°C / 50 % RH	~3	min	
	At 30°C / 80 % RH	~2	min	
Curing time	Drying stages		(ISO 9117-5)	
	Cilmate	DS 1	DS 6	DS 7
	20°C / 20 % RH	30 min	50 min	120 min
	23°C / 50 % RH	25 min	45 min	110 min
	30°C / 80 % RH	20 min	40 min	90 min
Waiting time to overcoating	Cilmate	Grindable after	Min.	Max.
	20°C / 20 % RH	30 min	30 min	72 h
	23°C / 50 % RH	30 min	30 min	72 h
	30°C / 80 % RH	30 min	20 min	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 topcoat we recommend to grind the putty 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

Lightly grinding the surface carefully  
The surface has to be clean, dry, dust free and free of any separating agents and contaminations.

### MIXING

The application is carried out using suitable 2-component dosage and mixing equipment.  
The material must be homogeneous and streak-free.

### 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.

### 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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#### **PRODUCT DATA SHEET**

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