BUILDING TRUST

PRODUCT DATA SHEET

SikaCor®-350 Blade

3-pack Polyurethane Putty, solvent free

DESCRIPTION

SikaCor®-350 Blade is a solvent free, 3-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®-350 Blade may only be used by experienced professionals.

SikaCor®-350 Blade is used as grindable fine putty for levelling the surface of rotor blades.

CHARACTERISTICS / ADVANTAGES

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

PRODUCT INFORMATION

Packaging	SikaCor®-350 Blade (A):	300 kg and 15 kg net.		
	SikaCor®-350 Blade/360 Blade (B):	220 kg and 5 kg net.		
	SikaCor®-350 Blade (C):	3 x 1 kg net.		
	Other packaging upon request.			
Appearance and colour	grey			
Shelf life	SikaCor®-350 Blade (A):	24 month		
	SikaCor®-350 Blade/360 Blade (B):	24 month		
	SikaCor®-350 Blade (C):	6 month		
Storage conditions	In originally sealed containers in a cool and dry environment			
Density	~1.55 kg/l			
Solid content	~99 % by volume ~99.5 % by weight			
Viscosity	Comp. (A)	Comp. (B)	Comp. (C)	(DIN 53019-1)
	$\dot{\gamma}$=50 s^{-1}: ~37 Pa s	$\dot{\gamma}$=100 s^{-1}: ~6 Pa s	$\dot{\gamma}$=100 s^{-1}: ~3 Pa s	
	$\dot{\gamma}$=5 s^{-1}: ~95 Pa s	$\dot{\gamma}$=10 s^{-1}: ~8 Pa s	$\dot{\gamma}$=10 s^{-1}: ~4 Pa s	

TECHNICAL INFORMATION

Shore D Hardness	D = 50-60	(ISO 868)
Mechanical resistance	Resistant against erosion.	
Tensile strain at break	30 % 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®-350 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 + C	
By weight	100 : 65 + 5 % b.w. comp. C
By volume	1.3 : 1 + 5 % b.w. comp. C

Consumption

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

Dry film thickness	1000 µm
Wet film thickness	1010 µm
Consumption	1.57 kg/m²
VOC	7.8 g/m²

The fine putty with component C is sag resistant up to approx. 3000 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

Climate	With 5 % accelerator C	Without accelerator
At 20°C / 20 % RH	5 min	> 60 min
At 23°C / 50 % RH	4 min	> 60 min

Waiting time to overcoating

By the use of 5 % accelerator C

Climate	Grindable after	Min.	Max.
23°C / 50 % RH	60 min	60 min	72 h

In case of waiting time > 72 h carefully grinding of the surface with sand paper (grain size 100 - 120) is required. Before overcoating with top coat 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

Mix component A and B in the recommended mixing ratio and stir very thoroughly using a mechanical mixer (start slowly). Fill mixed material into clean container and mix again shortly as described above. The material must be homogeneous and streak-free.

Subsequently take a partial quantity of the mixed material and add component C (accelerator) in the right mixing ratio. Mix again very carefully.

During mixing and handling of the materials always wear protective goggles, suitable
gloves and other protective clothings.

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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