BUILDING TRUST

PRODUCT DATA SHEET

SikaPower®-740

High-performance 2-component structural adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		SikaPower®-740 (A)	SikaPower®-740 (B)
Chemical base		Epoxy	Amine
Color (CQP001-1)		Black, beige	Beige
	mixed	Black, beige	
Density		1.38 kg/l	1.22 kg/l
	mixed (calculated)	1.30 kg/l	
Mixing ratio	by volume	100 : 100	
	by weight	100 : 90	
Viscosity (CQP029-4)	at 25 °C, 10 s^{-1}	950 Pa·s	380 Pa·s
Application temperature		15 – 30 °C	
Open time (CQP046-11 / ISO 4587)		40 minutes [A, B]	
Handling time (CQP046-11 / ISO 4587)		4 hours [A, B]	
Shore D hardness (CQP023-1 / ISO 48-4)		80 [C]	
Tensile strength (CQP543-1 / ISO 527)		30 MPa [A, C, D]	
E-Modulus (CQP543-1 / ISO 527)		2500 MPa [A, C, D]	
Elongation at break (CQP543-1 / ISO 527)		4 % [A, C, D]	
Tensile lap-shear strength (CQP046-9 / ISO 4587)		20 MPa [A, B, C]	
Service temperature (CQP513-2)		-40 – 130 °C	
Shelf life (CQP016-1)		12 months	

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

B) adhesive layer: 25 x 12.5 x 0.3 mm / on aluminium

C) cured for 16 hours at 70 °C

D) specimen type 1A acc. to ISO 527

DESCRIPTION

SikaPower®-740 is a high-performance 2-component epoxy adhesive with good application properties, which cures at room temperature. It is suitable for bonding metallic stubstrates, like steel and aluminium, as well as composite substrates, like GFRP and CFRP laminates.

PRODUCT BENEFITS

- High mechanical performances and resistance to vibrations and impacts
- Curing at room temperature, accelerated curing by heat
- Good non-sag behavior, suitable for vertical applications and filling irregular joints
- Good ageing resistance
- Does not contain solvents or PVC

AREAS OF APPLICATION

SikaPower®-740 is suitable for fast assembly bonding applications in transportation and general industry.

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
SikaPower®-740 cures by chemical reaction of the two components at room temperature. The cure rate is accelerated at higher temperatures, e.g. using ovens or infrared lamps. The tensile and shear strengths, may be increased with higher curing temperature.

CHEMICAL RESISTANCE
In view of potential chemical or thermal exposure, it is required to conduct a project related testing.

METHOD OF APPLICATION
Surface preparation
Surfaces must be clean, dry and free from grease, oil and dust. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. All pretreatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application
SikaPower®-740 is applied from 1:1 dual cartridge with suitable dispenser or with an adequate pump equipment. In case of cartidge use, an electric or pneumatic dispensers with piston-driven plungers are recommended. For 50 ml cartridges a manual dispenser is used.
Extrude adhesive without mixer to equalize the filling levels. Attach the defined mixer and dispose of the first few cm of the bead before the application.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal
Uncured SikaPower®-740 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. 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
SikaPower®-740 has to be kept between 15 °C and 25 °C in a dry place. Do not expose it to direct sunlight or frost.
After opening of the packaging, the contents have 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
- ATI: Mixer alternatives for cartridges

PACKAGING INFORMATION
SikaPower®-740 (A+B)

Dual cartridge	50 ml 400 ml
Mixer (50 ml): Bayonet Mixer TAH 295-620 Mixer (400 ml): Turbo Bell Mixer 180AN-824	

SikaPower®-740 (A)

Pail	5 kg
Drum	40 kg

SikaPower®-740 (B)

Pail	4.5 kg
Drum	36 kg

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 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.

Sika Deutschland CH AG & Co KG
Industry
Stuttgarter Straße 139
72574 Bad Urach
Tel. +49 7125 940-7692
verkauf.industry@de.sika.com
www.sika.de