

PRODUCT DATA SHEET

# SikaPower®-752 L120 FR

Self-extinguishing 2-component structural epoxy adhesive

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaPower®-752 L120 FR (A)	SikaPower®-752 L120 FR (B)
<b>Chemical base</b>	Epoxy	Amine
<b>Color (CQP001-1)</b>	Black	Beige
<b>Density</b>	1.40 kg/l	1.30 kg/l
	mixed (calculated)	1.38 kg/l
<b>Mixing ratio</b>	by volume by weight	100 : 50 100 : 47
<b>Viscosity (CQP538-2)</b>	at 25 °C, spindle 7, speed 10	145 Pa·s 185 Pa·s
<b>Consistency</b>	Thixotropic paste	
<b>Application temperature</b>	15 – 30 °C	
<b>Open time (CQP046-11 / ISO 4587)</b>	120 minutes <sup>A, B</sup>	
<b>Handling time (CQP046-11 / ISO 4587)</b>	8 hours <sup>A, B</sup>	
<b>Shore D hardness (CQP023-1 / ISO 868)</b>	85 <sup>C</sup>	
<b>Tensile strength (CQP543-1 / ISO 527)</b>	42 MPa <sup>A, C, D</sup>	
<b>E-Modulus (CQP543-1 / ISO 527)</b>	4000 MPa <sup>A, C, D</sup>	
<b>Elongation at break (CQP543-1 / ISO 527)</b>	3 % <sup>A, C, D</sup>	
<b>Tensile lap-shear strength (CQP046-9 / ISO 4587)</b>	22 MPa <sup>A, B, C</sup>	
<b>Service temperature</b>	-40 – 150 °C	
<b>Shelf life</b>	24 months	

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r.h.

C) cured for 16 hours at 70 °C

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

D) specimen type 1A acc. to ISO 527

**DESCRIPTION**

SikaPower®-752 L120 FR is a structural 2-components epoxy adhesive, which cures at room temperature.

It is designed for high strength bonding of metallic substrates, like steel and aluminum, as well as of composite substrates, like GFRP and CFRP laminates.

It shows good self-extinguishing behavior and good ageing resistance.

**PRODUCT BENEFITS**

- High-performance bonding of large parts
- High level of mechanical properties and aging resistance
- Self-extinguishing according to EN 45545-2, FAR 25 (FAR 25§853) and AITM (ABD0031) standards
- Retain high lap-shear strength until 80 °C
- Contains 0.25 mm beads for optimal bonding thickness

**AREAS OF APPLICATION**

SikaPower®-752 L120 FR is suitable for high performance bonding of panels (e.g., honeycomb, aluminum sheets, stainless steel sheets, wood, composites, thermoplastic materials, foam) and assembly of composites (e.g., CFRP, GFRP) or metals.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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## CURE MECHANISM

SikaPower®-752 L120 FR 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. Final mechanical properties 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 pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

### Application

SikaPower®-752 L120 FR is applied from 2:1 dual cartridge with adequate dispenser. The use of electric or pneumatic dispensers with piston-driven plungers is 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®-752 L120 FR 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®-752 L120 FR 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®-752 L120 FR (A+B)

Dual cartridge	50 ml 400 ml
Mixer: MixPac™ MBQ 05-24L (50 ml) Mixer: MixPac™ MCH 10-24T (400 ml)	
SikaPower®-752 L120 FR (A)	

Pail	39 kg
SikaPower®-752 L120 FR (B)	
Pail	

## 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.

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