

## PRODUCT DATA SHEET

# SikaForce®-735 GG

Two-part, self-leveling, pu-grout for embedding of glass panels

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

Properties	SikaForce®-735 GG (A)	SikaForce®-735 GG (B)
Chemical base	Polyols, filled	Isocyanate derivatives
Color (CQP001-1)	Beige	Brown
	mixed	Beige
Cure mechanism	Polyaddition	
Density (uncured)	1.5 g/cm <sup>3</sup> (12.5 lbs/gal)	1.2 g/cm <sup>3</sup> (10.0 lbs/gal)
	mixed (calculated)	1.5 g/cm <sup>3</sup> (12.5 lbs/gal)
Solid content	100 %	100 %
Mixing ratio	by volume 100 : 25	
	by weight 100 : 20	
Viscosity (CQP538-2)	Brookfield - RVT 6/20 6 500 mPa·s <sup>A</sup> Brookfield - RVT 2/50 (mixed) Brookfield - RVT 6/20 5 200 mPa·s <sup>A</sup>	250 mPa·s <sup>A</sup>
Application temperature	ambient 15 – 30 °C (59 – 86 °F)	
Pot-life (CQP536-3)	25 minutes <sup>A</sup>	
Shore D hardness (CQP023-1 / ISO 48-4)	60 <sup>B</sup>	
Tensile strength (CQP036-2 / ISO527-2)	3.8 MPa (550 psi) <sup>B, C</sup>	
Elongation at break (CQP036-2 / ISO 527-2)	20 % <sup>B, C</sup>	
Shelf life	12 months <sup>D</sup>	9 months <sup>D</sup>

CQP = Corporate Quality Procedure

C) test speed 10 mm/min

A) 23 °C (73 °F) / 50 % r.h

D) storage between 10 °C and 30 °C (50 °F and 86 °F)

B) curing 28 days at 23 °C (73 °F) / 50 % r.h.

**DESCRIPTION**

SikaForce®-735 GG is a pourable, self-levelling, two-component polymer grout based on polyurethane resin. It has been designed for embedding of monolithic or laminated glass panes in U-shaped support channels for standard glass railing, frameless or postless guard rail and balcony glazing. It is suitable for indoor and outdoor applications, if sealed with Sikasil® WS product.

**PRODUCT BENEFITS**

- Stress-free glass embedding process
- Allows homogenous load distribution
- Long pot-life, easy to use
- Room temperature curing
- Solvent-free

**AREAS OF APPLICATION**

SikaForce®-735 GG is designed for embedding of monolithic or laminated glass panes in U-shaped support channels for standard glass railing, frameless or postless guard rail and balcony glazing. It is suitable for indoor and outdoor applications, if sealed with Sikasil® WS product.

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

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## CURE MECHANISM

The curing of SikaForce®-735 GG takes place by a chemical reaction of the two components. Higher temperatures speed up and lower slow down the curing process.

## CHEMICAL RESISTANCE

In case of chemical or thermal exposure, conduct project related testing.

## METHOD OF APPLICATION

Consult the General Guideline "Glass Embedding" for construction details and dimensions prior to the product application.

## Surface Preparation

Surfaces must be clean and dry.

## Application

The procedure for manual application is as follows:

Stir the SikaForce®-735 GG (A) thoroughly until it is mixed homogeneously. Add the SikaForce®-735 GG (B) in the specified ratio into the SikaForce®-735 GG (A) and stir until a homogeneous mixture is obtained. Apply before reaching half of the pot-life and join parts together within the open time. Consider that if mixed in bigger masses the exothermic reaction can influence the pot-life and open time significantly.

Prevent adhesion to glass with a release agent or bond breaker.

## Outdoor Application

To protect the embedding material from UV radiation it is required to apply a bead of Sikasil® WS sealant on top.

SikaForce®-735 GG must be cured 24 hours prior to the sealant application.

## Removal

Uncured SikaForce®-735 GG may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin.

## Application Limits

The compatibility of setting blocks, backer rods and other accessory materials in direct and indirect contact with SikaForce®-735 GG have to be approved by Sika in advance. It is recommended to use setting blocks made of SikaForce®-735 GG.

Avoid any stress caused by thermal dilatation. The mechanical properties of SikaForce®-735 GG change depending on service temperature. Impacts on glass and U-shaped support channel must be verified.

## STORAGE CONDITIONS

SikaForce®-735 GG has to be stored between 10 °C and 30 °C (50 °F and 86 °F) in a dry place. Do not expose it to direct sunlight or frost.

After opening of the packaging, the content has to be protected against humidity.

Minimum temperature during transportation is -20 °C (-4 °F) for max. 7 days.

## 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
- General Guideline  
Glass Embedding

## PACKAGING INFORMATION

SikaForce®-735 GG (A)

Pail	4 gal (US)
	1 gal (US)

SikaForce®-735 GG (B)

Can	1 gal (US)
	0.25 gal (US)

## 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.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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