

PRODUCT DATA SHEET

SikaForce®-432 L03 (EASYMAX ISOCYANATE / EASYMAX-R POLYOL)

POLYURETHANE PUTTY

FAST SETTING – ODOR FREE – SANDABLE – LOW DENSITY

DESCRIPTION

Repairs, filling and bonding of low density machinable slabs,
Filletts,
Splinning of surfaces on any material.

PROPERTIES

- Easy mixing ratio 100 :100
- Easy to mix and to apply with a spatula
- Fast setting; sanding after 20 min at 25°C
- Can be applied on metal, wood, Composites, PU or Polyester foams....
- Very smooth grain after sanding
- Low density
- Almost no shrinkage (< 0.01% on 10 mm thick sample)
- Odour free, not flammable
- Can be applied at temperatures from 0°C to 60°C

PHYSICAL PROPERTIES

Composition	POLYOL (B)	ISOCYANATE (A)	MIX	METHOD
Mix ratio by weight	100	100		
Mix ratio by volume at 25 °C	100	100		
Aspect	Pasty	Pasty	Pasty	
Colour	Grey		Grey	
	Brown	Beige	Brown	
	Beige		Beige	
Density at 25 °C (KP)	0.67	0.69	-	LT-020
Density of cured product at 23 °C	-	-	0.68	ISO 2781
Pot life at 25°C on 40g (KP) (min)			3 min 20 s	LT-002-B

(KP) Key properties. These values are enclosed in Certificate of Analysis.

SPECIFIC PROPERTIES at 23 °C ⁽¹⁾

Hardness	(Shore D)	64	ISO 868
Application temperature	(°C)	0°C to 60°C	-
Thickness on vertical wall	(mm)	Max. 30	-
Full hardening time	(days)	6	-

(1) Cured 7 days at room temperature

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MECHANICAL PROPERTIES ⁽¹⁾

Flexural modulus	(MPa)	1465	
Flexural strength	(MPa) -	21	ISO 178
Flexural strain at flexural strength	(%)	2	
Impact strength CAHRPY ⁽²⁾	(kJ/m ²)	6	ISO 179/1eU
Linear shrinkage on 1000*50*10 mm (%)		< 0.01	-

(1) Cured 7 days at room temperature.

(2) Unnotched specimens.

MECHANICAL PROPERTIES ON ASSEMBLIES ⁽¹⁾

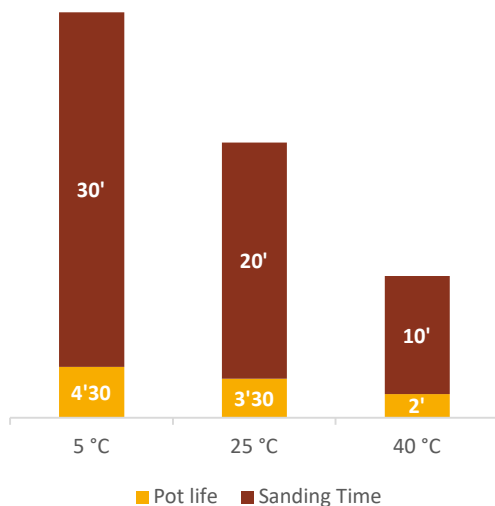
		LAP SHEAR STRENGTH AT 23°C		METHOD
Aluminium 2017A (sandblasted)	(MPa)	Initial	12	LT-006-B
		After 14 days at 70°C	9	
		After 14 days at 100°C	10	

(1) Cured 7 days at room temperature.

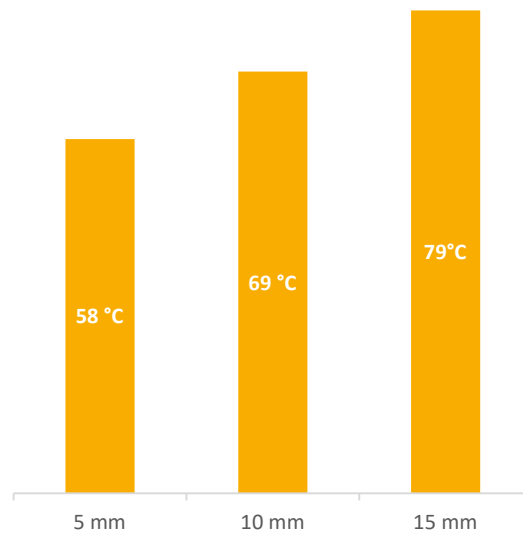
PROCESSING

- Both parts must be thoroughly mixed according to the mixing ratio indicated in this Technical Data Sheet. Before use, check that the support is free of any dust, grease or pollution.
- During processing, pot life and time before sanding may vary depending of room temperature (see graphic below). The exotherm developed during hardening varies with the thickness of applied product, up to a maximal value of 79°C (174°F) (See graphic below).
- Advice: Test is necessary when using painting in order to check compatibility between the putty and the primer. A Polyester based primer is recommended.**

Pot life and sanding time versus temperature



Exotherm versus thickness



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BUILDING TRUST



HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

STORAGE CONDITIONS

Shelf life of **SikaForce®-432 L03 (AB) BEIGE**, in 400ml cartridges and of **SikaForce®-432 L03 (AB) BROWN**, in 50ml and 400ml cartridges is **12 months** in a dry place and in original unopened containers at a temperature between 15 and 25° C.

PACKAGING

▪ SikaForce®-432 L03 (AB) BEIGE / 400ml	Box of 12 cartridges
▪ SikaForce®-432 L03 (AB) BROWN / 50ml	Box of 12 cartridges
▪ SikaForce®-432 L03 (AB) BROWN / 400ml	Box of 12 cartridges

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 Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets.

VALUE BASES

All technical data stated in this Product Data Sheet 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.

LEGAL NOTICE

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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