BUILDING TRUST

PRODUCT DATA SHEET

SikaForce®-335 GG

Self-levelling 2-component PU-grout for embedding of glass panels

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties		SikaForce®-335 GG Base Component	SikaForce®-010 Hardener
Chemical base		Polyols, filled	Isocyanate derivatives
Color (CQP001-1)		Beige	brown
	mixed	Beige	
Cure mechanism		Polyaddition	
Density (uncured)		1.6 g/cm³	1.2 g/cm³
	mixed (calculated)	1.5 g/cm³	
Solid content		100 %	100 %
Mixing ratio	by volume	100 : 25	
	by weight	100 : 19	
Viscosity (CQP538-2)	Brookfield - RVT 6/20	30 000 mPa·s [A]	
	Brookfield - RVT 2/50		250 mPa·s [A]
	(mixed) Brookfield - RVT 6/20	10 000 mPa·s [A]	
Application temperature	ambient	5 – 35 °C	
Pot-life (CQP536-3)		30 minutes [A]	
Shore D hardness (CQP023-1 / ISO 48-4)		60 [B]	
Tensile strength (CQP036-2 / ISO527-2)		7.7 MPa [B, C]	
Elongation at break (CQP036-2 / ISO 527-2)		20 % [B, C]	
Glass transition temperature (ISO 11359-2)		5 °C [D]	
Shelf life		12 months [E]	9 months [E]

CQP = Corporate Quality Procedure
[A] 23 °C / 50 % r.h.
[B] curing 28 days at 23 °C / 50 % r.h.
[C] test speed 5 mm/min
[D] cured 4 months at 23 °C / 50 % r.h.; heating rate 5 K/min
[E] storage between 10 °C and 30 °C

DESCRIPTION

SikaForce®-335 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®-335 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.

CURE MECHANISM
The curing of SikaForce®-335 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 base part thoroughly until it is mixed homogeneously. Add the hardener in the specified ratio in the base part 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®-335 GG must be cured 24 hours prior the sealant application.

Removal
Uncured SikaForce®-335 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 hand wipes such as Sika® Cleaner-350H or 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®-335 GG have to be approved by Sika in advance. It is recommended to use setting blocks made of SikaForce®-335 GG.
Avoid any stress caused by thermal dilatation.
The mechanical properties of SikaForce®-335 GG change depending on service temperature.
Impacts on glass and U-shaped support channel must be verified.

STORAGE CONDITIONS
SikaForce®-335 GG base component and SikaForce®-010 hardener have to be kept between 10 °C and 30 °C 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 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®-335 GG Base Component

Can	5 kg
Pail	25 kg

SikaForce®-010 Hardener

Can	1 kg 5 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.

Oy Sika Finland Ab
TM Industry
Tammiston kauppatie 22 B
01510 Vantaa
Puh. 09-511 431
www.sika.fi