

# SikaTack<sup>®</sup> PRO

Premium choice for auto glass professionals

Typical Product Data

Chemical base	1-C polyurethane
Color (CQP <sup>1</sup> 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.3 kg/l
Non-sag properties (CQP 061-1)	Very good
Application temperature	-10 – 35 °C
Skin time <sup>2</sup> (CQP 019-1)	10 minutes
Open time <sup>2</sup> (CQP 526-1)	8 minutes
Curing speed (CQP 049-1)	see diagram 1
Shore A hardness (CQP 023-1 / ISO 868)	60
Tensile strength (CQP 036-1 / ISO 37)	7 MPa
Elongation at break (CQP 036-1 / ISO 37)	300 %
Tear propagation resistance (CQP 045-1 / ISO 34)	10 N/mm
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	4.5 MPa
Safe Drive-Away Time <sup>3</sup> (cars) according to FMVSS 212 (CQP 511-1)	with double-side airbags 30 minutes without airbag 30 minutes
Volume resistivity (CQP 079-2 / ASTM D 257-99)	Low conductive
Shelf life (storage below 25 °C) (CQP 016-1)	9 months

<sup>1)</sup> CQP = Corporate Quality Procedures

<sup>2)</sup> 23 °C / 50 % r. h.

<sup>3)</sup> For temperatures between -10 °C and 35 °C

**Description**

SikaTack<sup>®</sup> PRO is a cold applied automotive windshield adhesive offering 30 minutes Safe Drive-Away Time (SDAT). It is very easy to apply and offers high quality combined with safety.

SikaTack<sup>®</sup> PRO is suitable for mobile and in-house glass replacement on passenger cars with or without airbags.

**Product Benefits**

- True 30 minutes Safe Drive-Away Time, tested under new 95<sup>th</sup> percentile FMVSS 212 standard
- Compatible with Black-Primerless and All Black installation process
- Short cut-off string
- All in one modulus
- Automotive OEM quality

**Areas of Application**

SikaTack<sup>®</sup> PRO has been specially designed for the Automotive Glass Replacement business. It is ideal for mobile and in-house installations.

This product is to be used by professional experienced fitters only. If this product is used for other applications than Automotive Glass Replacement, tests with current substrates and conditions have to be performed to ensure adhesion and material compatibility.



## Cure Mechanism

SikaTack® PRO cures by reaction with atmospheric moisture. At low temperatures the absolute water content of the air is lower and the curing reaction proceeds more slowly (see diagram 1).

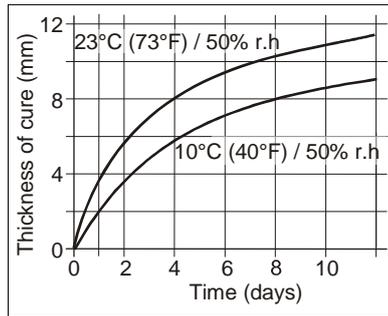


Diagram 1: Curing speed SikaTack® PRO

## Chemical Resistance

SikaTack® PRO is resistant to fresh water, seawater, limewater, sewage effluent, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

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## Method of Application

### Removal of old glass

Remove damaged glass in accordance with the vehicle manufacturer's instructions.

### Surface preparation

Surfaces must be clean, dry and free from dust, grease and contaminants. The bond faces must be treated according Sika's Black-Primerless or All Black installation process.

Detailed information on the application and use of activating agents, etc. can be found in the corresponding Product Data Sheet. Advice on specific applications is available from the Technical Department of Sika Industry.

## Application

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge or the unipack adapter.

It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see fig. 1 below). The glass must be installed within the open time. Following Sika's Black-Primerless or All Black process the substrate temperature must be between -10 °C (15 °F) and 35 °C.

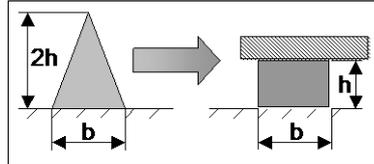


Fig 1: Compressing adhesive bead to final size

## Removal

Uncured SikaTack® PRO may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Hand-clean towels or a suitable industrial hand cleaner and water. Do not use solvents on skin!

## Further Information

Copies of the following publications are available on request:

- Safety Data Sheet
- Black-Primerless installation process chart
- All Black installation process chart

## Packaging Information

Cartridge	300 ml
Unipack	400 ml
	600 ml

## Basis of Product Data

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.

## 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.

Further information available at:

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