

SikaTack[®]-Drive

The application champion in automotive glass replacement

Technical Product Data

Chemical base	1-C polyurethane
Colour (CQP ¹ 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.25 kg/l approx.
Stability (non-sag properties)	Very good
Application temperature	5 - 35°C (40 - 95°F)
Tack-free time ² (CQP 019-1)	15 min. approx.
Open time ² (CQP 526-1)	10 min. approx.
Curing speed (CQP 049-1)	(see diagram)
Shore A hardness (CQP 023-1 / ISO 868)	70 approx.
Tensile strength (CQP 036-1 / ISO 37)	8 N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	250% approx.
Tear propagation strength (CQP 045-1 / ISO 34)	10 N/mm approx.
Tensile lap-shear strength for a 4 mm applied thickness (CQP 046-1 / ISO 4587)	6 N/mm ² approx.
Safe Drive-Away Time ³ (cars) according to US safety standards FMVSS 212 / 208	with double side airbags without airbags 2 h 30 min
Volume resistivity (CQP 079-2 / ASTM D 257-99)	10 ⁹ Ω cm approx.
Shelf life (storage below 25 °C) (CQP 016-0)	9 months

¹⁾ CQP = Corporate Quality Procedures ²⁾ 23°C (73°F) / 50% r.h. ³⁾ 5°C (41°F) / 60% r.h. - 35°C (95°F) / 10% r.h.

Description

SikaTack-Drive is a cold-applied windshield adhesive which is easy to apply. It exhibits excellent technical characteristics such as primerless application, compatibility with glass-mounted aerials, nonconductivity, and offers quality combined with safety. It is suitable for glass replacement on all passenger cars, with or without airbags. SikaTack-Drive can be used all year and provides a 2-hour Safe Drive Away Time in a wide climatic range (see Safe Drive-Away Time Chart).

SikaTack-Drive is manufactured in accordance with the ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- Primerless
- Short cut-off string
- Very good non-sag properties
- Easy and clean application
- Sika All-in-One Modulus
- Suitable for cars with integral antennas
- Short Safe Drive-Away Time³ (according FMVSS 212/208, no seat belts, twin airbags fitted)
- Prevents contact corrosion for aluminium-bodied vehicles
- Solvent-free

Area of Application

SikaTack-Drive has been specially designed for the Automotive Glass Replacement (AGR) business.

SikaTack-Drive is ideal for mobile or in-house fittings.

This product is to be used by professional experienced fitters only. If this product is used for other applications than Automotive Glass Replacement, trials must be carried out prior to use.

Cure Mechanism

SikaTack-Drive 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).

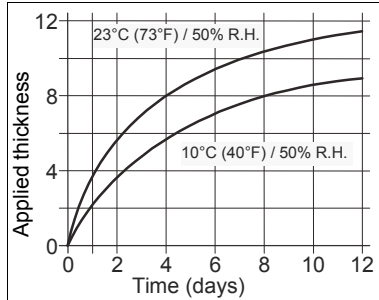


Diagram 1: Cure progression for SikaTack®-Drive (New Formulation)

Chemical Resistance

SikaTack-Drive is resistant to water and proprietary aqueous cleaning agents (including windshield cleaners containing alcohol); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions or paint thinners. The above information is offered for general guidance only. Advice on specific applications will be given on request.

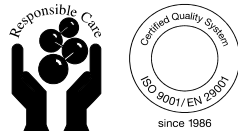
Method of Application

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 all traces of dust and grease. The bond faces must be treated with a cleaning and activating agent or primed with the appropriate primer as follows:



Glass with uniform and continuous opaque, mineral based ceramic frit (valid for passenger cars only)	Sika Activator PRO
Old polyurethane direct glazing adhesive (cut face)	Sika Activator PRO
Metal with paint primer or with partial new painting (<25% of total bonding area)	Sika Activator PRO
Metal with paint primer or with partial new painting (>=25% of total bonding area)	Sika Activator PRO and Sika Primer 206 G+P
Glass without black ceramic border or cover trim (valid for passenger cars only)	Sika Activator PRO and Sika Primer 206 G+P

Removal

Uncured SikaTack-Drive 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 a suitable industrial hand cleanser and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:
- Safety Data Sheet

Packaging

Unipack	600 ml
Cartridge	300 ml

Value Bases

All technical data stated in this Product Data Sheet are laboratory test based. Current measured values may vary due to factors beyond our influences.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet containing physical, ecological, toxicological and other safety related data.

Legal Notes

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.

Detailed information on the application and use of activating agents, etc. can be found in the individual Product Data Sheet. The information provided here is intended for general guidance only. Specific advice on your intended application is available on request.

Application

Cartridges: Pierce membrane.

Unipacks: Place unipack in the application gun and snip off the closure clip.

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge. If using unipacks, attach nozzle with adapter to the pack.

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 be applied in the form of a triangular bead (see fig. 1 below).

The glass must be installed within 10 minutes of starting to apply the adhesive.

In combination with Sika Activator PRO the substrate temperature must be between -10°C and 35°C, for other pre-treatments the lower limit is 5°C.

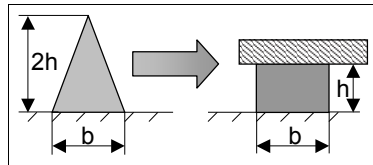


Fig 1: Compressing adhesive bead to final size

