



POLYURETHANE WINDSHIELD ADHESIVE

1 – DESCRIPTION

Polyurethane Windshield Adhesive is a component, moisture curing polyurethane based adhesive for direct glazing in Automotive Glass Replacement.

2 – PROPERTIES

- One component formulation
- Good non-sag properties
- Short cut-off string
- Cold application
- Fast curing – Rapid strength development
- High mechanical performance
- High Modulus
- High initial bond strength
- Can be overpainted

3 - APPLICATIONS

It is especially useful in bonding windshield glass into automotive frames

4 - INSTRUCTIONS

- Remove the damaged glass. Before application ensure that surfaces are clean, dry and free from dust and grease.
- Shake the Polyurethane Windshield Adhesive Primer for at least 30 seconds (after hearing the ball move) before application.
- Apply Windshield Adhesive Primer to the outer edge of the glass where the urethane bond will be made and allow to dry.
- Ensure that primer is tack-free dry before proceeding.
- Cut tip of the nozzle to desired shape and size to provide a bead height sufficient to give good contact with the windshield around the entire perimeter. A triangular shaped notch will provide the optimal bead shape and height.
- It is recommended to apply the adhesive with a pneumatic sealant gun.
- Apply Polyurethane Windshield Adhesive directly to the glass
- Position the glass by aligning the masking tape on glass and car body. Press glass in place to assure complete contact with the Polyurethane Windshield Adhesive



5- STORAGE AND SHELF LIFE

9 months if stored properly in its original package between +5 °C and 30 °C.

6- PACKAGING

| Product | Volume | Package |
|-----------------|--------|---------|
| Black | 310ml | 12 |
| Black (Bottle) | 300ml | 12 |
| Black (Sausage) | 600ml | 12 |

7- RESTRICTIONS

- Avoid application below 5 °C and above 40 °C.
- Do not apply on frozen or wet surfaces or through standing water.

8- TECHNICAL PROPERTIES

| BEFORE CURING | |
|-------------------------|--------------------------------------|
| Basis | : Polyurethane |
| Consistency | : Thixotropic |
| Curing Mechanism | : Moisture Curing |
| Density | : 1,13±0,03 g/ml |
| Tack free time | : 30±10 min. (23°C and 50% R.H) |
| Curing Rate | : Min. 3,5 mm/day (23°C and 50% R.H) |
| Sagging | : 0 mm (EN ISO 7390) |

| AFTER CURING | |
|----------------------------|--|
| Hardness Shore A | : 55-60 After 28 days |
| Paintability | : Yes * |
| Elongation at break | : Min. 300% (ASTM D412) |
| Tensile Strength | : Min. 4 N/mm ² (ASTM D412) |

*Considering the diversity of paint base and quality, compatibility tests should be done before application.