

## SikaTack® Ultrafast II

High-performance, non-conductive, primerless to glass, hot-applied autoglass replacement adhesive

### Technical Data

Chemical Base	One-component polyurethane	
Colour	Black	
Cure Mechanism	Moisture-curing	
Density (uncured)	1.15 kg/L	
Non-Sag Properties	Very Good	
Application Temperature	product	80 °C
	surface	-10 to 77 °C
	air	-10 to 49 °C
Heating Time	60 minutes	
Skin Time <sup>2</sup>	15 min. approx.	
Open Time <sup>2</sup>	10 min.	
Shore A Hardness (ASTM D 2240)	60 approx.	
Tensile Strength (ASTM D 412)	800 psi	
Elongation at Break (ASTM D 412)	400 % approx.	
Tensile-Lap Shear Strength (ASTM D 1002)	500 psi	
Safe Drive-Away Time <sup>2</sup> (cars) according to FMVSS 212/208 with double-sided airbags	See Chart	
Shelf Life (Stored below 25°C) (CQP 016-1)	9 months	

<sup>1</sup> CQP = Corporate Quality Procedures; <sup>2</sup> 23°C and 50% Relative Humidity.

### Description

SikaTack® Ultrafast II is an elastic, gap-filling, one-component, hot-applied polyurethane adhesive that develops high initial strength. The excellent working characteristics of the adhesive in terms of cut-off string and non-sag properties, as well as its high initial strength development are achieved by preheating prior to application. The cartridge is placed in the special SikaTack® oven and heated to a temperature of 80 °C. At this temperature, partial pre-curing of the adhesive takes place. Store cartridge below 23 °C. Avoid contact with alcohol and alcohol-containing solvents during cure. SikaTack® Ultrafast II is manufactured in accordance with the ISO 9001/14001 Quality Assurance System and exceeds all U.S.A. Federal requirements for FMVSS 212/208.

### Product Benefits

- 1-hour Safe Drive-Away Time -- when used in accordance with Sika's installation instructions;
- Black primerless to glass;
- "All-in-one Modulus";
- Solvent-free;
- Excellent non-sag properties;
- Can be applied at surface/air temperatures as low as -10 °C;
- Non-conductive; prevents contact corrosion in aluminum-bodied vehicles;
- High initial strength; very short cut-off string; fast cure.

**Areas of Application** SikaTack® Ultrafast II is suitable for direct glazing applications in both the automotive OEM and replacement markets. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



**Cure Mechanism** SikaTack® Ultrafast II cures by reaction with atmospheric moisture. Note: At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly.

**Safe Drive Away Time**

Relative Humidity	Temperature (°C)					
	> -18 °C	> 0 °C	> 10 °C	>20 °C	>30 °C	32 - 50 °C
> 90 %	60 min	60 min	60 min	60 min	60 min	60 min
> 70 %	60 min	60 min	60 min	60 min	60 min	60 min
> 40 %	60 min	60 min	60 min	60 min	60 min	60 min
> 20 %	60 min	60 min	60 min	60 min	60 min	60 min
> 0 %	60 min	60 min	60 min	60 min	60 min	60 min

**Surface Preparation** Surfaces must be sound, clean, dry and free from grease, oil and dust. All corrosion must be removed and all bare metal scrapes and scratches prepared in accordance with Sika's Corrosion Treatment recommendations. The bond area of the glass must be prepared with Sika® Aktivator-PRO to ensure a secure bond in case of a crash. If not used as directed, the product may not perform as intended which could lead to personal injury or damage. Refer to the Sika AGR Technician's Training Manual for detailed installation instructions and procedures, or contact your local Technical Sales Representative or Technical Services Department.

**Application**

Place cartridge in a Sika-approved oven for a minimum of 1 hour. Product can be heated for a total of 10 hours (either consecutively or in shorter periods adding up to a total of 10 hours). Remove SikaTack® Ultrafast II from heating device, puncture seal, attach appropriately-cut nozzle (e.g. "V" notch) and apply adhesive in accordance with instructions outlined in the Sika's installation instructions for hot-applied adhesives. Because of the fast-curing properties of SikaTack® Ultrafast II, the windshield must be installed within 10 minutes of application.

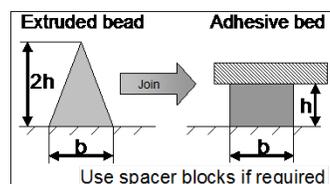


Figure 1: Recommended Bead Configuration

**Tooling and Finishing**

Tooling and finishing must be carried out within the skin time of the adhesive. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for suitability and compatibility.

**Removal**

Uncured SikaTack® Ultrafast II may be removed from tools and equipment with Sika® Remover-208 or other suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Hand Cleaner. Do not use solvents!

**Further Information** Copy of the following publication is available upon request:

- Safety Data Sheet
- Sika AGR Technician's Training Manual

**Packaging**

300 ml cartridges

**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 influence.

**Health and Safety Information**

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. All Product Data Sheets and Material Safety Data Sheets are available on our website at: [www.sika.ca](http://www.sika.ca).

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, within their shelf life. 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 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 Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under [www.sika.ca](http://www.sika.ca).

**Sika Canada Inc.**  
 601 Delmar Avenue  
 Pointe-Claire, QC H9R 4A9  
 Tel.: 514-697-2610  
 Fax: 514-697-3910

**1-800-689-SIKA**  
[www.sika.ca](http://www.sika.ca)

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