

Product Data Sheet

Version 03/2018 (03/2017)

Sikaflex® P2G PLUS**Primerless Autoglass Replacement Adhesive****Technical Data**

Chemical Base	One-component polyurethane	
Colour (CQP1 001-1)	Black	
Cure Mechanism	Moisture-curing	
Density (uncured) (CQP 006-4)	1.29 kg/L	
Non-Sag Properties (CQP 061-1)	Excellent	
Application Temperature	Product	10 °C to 45 °C
	Surface	5 °C to 50 °C
	Air	5 °C to 45 °C
Skin Time ² (CQP 019-1)	30 min.	
Open Time ² (CQP 526-1)	15 min.	
Shore A Hardness (CQP 023-1/ISO 868)	65	
Tensile Strength (CQP 036-1/ISO 37)	750 psi	
Elongation at Break (CQP 036-1/ISO 37)	400 %	
Lap-Shear Strength (CQP 046-1/ISO 4587)	400 psi	
Safe Drive-Away Time	See chart	
Shelf Life (Stored below 24 °C) (CQP 016-1)	9 months	
<small>¹ CQP = Sika Corporate Quality Procedure ² 23°C and 50% Relative Humidity</small>		

Description

Sikaflex® P2G PLUS is a primerless-to-glass, one-component, cold-applied, fast-curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Engineered to meet all OEM strength requirements, Sikaflex® P2G PLUS passes all FMVSS 212/208 requirements. Sikaflex® P2G PLUS is manufactured in accordance with the ISO 9001/14001 quality assurance system.

Product Benefits

- Primerless to glass
- 3-hour SDAT
- Excellent decking
- One-component formulation
- Fast curing speed
- Excellent cut-off string
- Cost-effective
- Exceeds FMVSS 212/208

Areas of Application

Sikaflex® P2G PLUS is designed for use in replacing polyurethane direct-glazed automotive glass parts. This product is suitable for professional, experienced AGR specialists only.

Cure Mechanism

Sikaflex® P2G PLUS cures by reaction with atmospheric moisture. At low temperatures, the water content of the air is lower and the curing reaction proceeds more slowly thus extending the Safe Drive-Away Time.

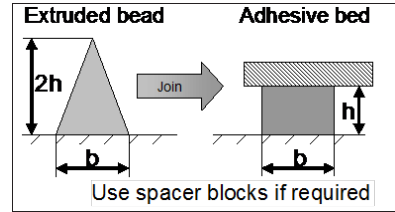
Surface Preparation

To prevent potential bond-strength issues, it is essential that all surfaces be clean, dry, sound and free from all traces of traditional and non-traditional contamination. This is best achieved by using Sika® PowerClean Aid pads in conjunction with a compatible glass cleaner such as Sika® CleanGlass. All corrosion must be removed and all bare metal scrapes and scratches prepared in accordance with Sika's Corrosion Treatment recommendations. Refer to Sika's AGR Technician Training Manual.



Application

Cut off the tip of the nozzle to obtain a v-shaped bead, or in accordance with the vehicle manufacturer's recommendations, and screw onto the cartridge or the unipac adaptor. It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive, we recommend that the adhesive be applied in the form of a triangular bead.



Removal

Uncured Sikaflex® P2G PLUS can be removed from tools and equipment with mineral spirits or other suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Strictly follow solvent manufacturer's instructions for use and warnings. Do not use solvents on skin!

Safe Drive-Away Time

Relative Humidity	Temperature (°C)			
	> 5 °C	> 15 °C	> 20 °C	> 30 - 45 °C
With Airbags (Hours)				
> 90%	3	3	3	3
> 75%	3	3	3	3
> 50%	3	3	3	3
> 20%	3	3	3	3

Packaging

300 ml cartridges

Further Information

Copy of the following publication is available upon request: Safety Data Sheet.

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 Material 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.

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.



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