Version 02/2015 (05/2019)

## SikaTack<sup>®</sup> Mach-30 Autoglass Replacement Adhesive

Technical Data	Chemical Base	One-component polyurethane				
	Colour (CQP1 001-1)	Black				
	Cure Mechanism	Moisture-curing				
	Density (uncured) (CQP 006-4)	1.2 kg/L				
	Non-Sag Properties	Very Good				
	Application Temperature Product	10°C to 49°C				
	Surface	-18°C to 77°C				
	Air	-18°C to 49°C				
	Skin Time <sup>2 /3</sup> (CQP 019-1)	10 min.				
	Open Time <sup>2</sup> (CQP 526-1)	8 min.				
	Shore A Hardness (CQP 023-1/ISO 868)	65				
	Tensile Strength (CQP 036-1/ISO 37)	7.58 MPa				
	Elongation at Break (CQP 036-1/ISO 37)	300%				
	Tensile Lap-Shear Strength (CQP 046-1)	5.0 MPa				
	Safe Drive-Away Time <sup>3</sup> (cars) according to FMVSS 212/208	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 <sup>3</sup> Open Time corresponds to Working Time.					
Description	SikaTack <sup>®</sup> Mach-30 is a one-component, cold-applied, fast-curing, high-viscosit polyurethane adhesive designed for use in replacing direct glazed automotive glass part: Engineered to perform to the strength of OEM requirements, SikaTack <sup>®</sup> Mach-30 exceed all Federal requirements for FMVS 212/208. SikaTack <sup>®</sup> Mach-30 is manufactured in accordance with the ISO 9001/14001 Qualit Assurance System.					
Product Benefits	<ul> <li>30-minute Safe Drive-Away Time in most conditions when used in accordance with Sika's installation instructions;</li> <li>Non-conductive;</li> <li>"All-in-One" modulus;</li> <li>Black primerless to glass;</li> <li>Can be used at temperatures ranging from -18°C to 50°C.</li> </ul>					
Areas of Application	on SikaTack <sup>®</sup> Mach-30 has been designed for use in repla automotive glass parts. This product is suitable for experienced professional use applications other than vehicle glass replacement, tests actual conditions must be performed to ensure adhesio	rs only. If this product is used fo with actual substrates and unde				
Cure Mechanism	SikaTack <sup>®</sup> Mach-30 cures by reaction to atmospheric moisture.					
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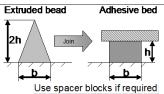
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Packaging

Safe Drive-Away	Relative	Temperature (°C)				
Time	Humidity	> -18°C	> 0°C	> 10°C	18 - 50°C	
	> 90%	30 min	30 min	30 min	30 min	
	> 70%	30 min	30 min	30 min	30 min	
	> 40%	30 min	30 min	30 min	30 min	
	> 20%	30 min	30 min	30 min	30 min	
	> 0%	30 min	30 min	30 min	30 min	
	Chart 1: Safe Drive-Away Time Table for SikaTack® Mach-30					

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 Product performs best when stored between 10 and Extruded bead 25°C; shelf life may be reduced if stored at above 25°C. Puncture seal, attach appropriately-cut nozzle (e.g. 2h "V" notch -- See Figure 1) and apply in accordance with instructions outlined in the Sika AGR Technician's Training Manual.



Removal Uncured SikaTack\*-Mach-30 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!

Figure 1: Recommended Bead Configuration

Further Information Copy of the following publication is available upon request: • Safety Data Sheet Sika AGR Technician's Training Manual

600 mL sausages and 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 For information and advice on the safe handling, storage and disposal of chemical products, Information 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.



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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