

**Product Data Sheet**

Version 02/2012 (06/2012)

**SikaTack® ASAP+****Hot-Applied Automotive Glass Replacement Adhesive****Technical Data**

Chemical Base		One-component polyurethane
Colour		Black
Cure Mechanism		Moisture-curing
Density (uncured)		1.15 kg/L approx.
Non-Sag Properties		Excellent
Application Temperature	Product	75°C to 90°C
	Surface	-18°C to 77°C
	Air	-18°C to 49°C
Cut-Off String		Very good
Tack-Free Time <sup>1</sup>		12 min.
Open/Working Time <sup>1</sup>		7 min.
Shore A Hardness		65
Tensile Strength		7 N/mm <sup>2</sup>
Elongation at Break		300%
Lap-Shear Strength		5 N/mm <sup>2</sup>
Safe Drive-Away Time		See chart
Shelf Life (Stored below 24°C)		9 months
<sup>1</sup> 23°C and 50% Relative Humidity		

**Description**

SikaTack® ASAP+ is an all-in-one modulus, hot-applied, fast-curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Engineered to conform to the OEM strength requirements, SikaTack® ASAP+ exceeds all USA Federal requirements even in the most severe interpretations of FMVSS 212/208. Store below 24°C. SikaTack® ASAP+ is manufactured in accordance with ISO 9001/14001 quality assurance system.

**Product Benefits**

- Safe Drive-Away Time of as little as 45 minutes for dual-airbag vehicles;
- All-in-one modulus;
- Non-conductive;
- Exceeds FMVSS 212/208 (with dual air-bags);
- One-component formulation;
- Short cut-off string;
- Black primer-less to glass (see Surface Preparation);
- Cost-effective;
- Can be applied at temperatures as low as -18°C.

**Areas of Application**

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

**Cure Mechanism** SikaTack® ASAP+ cures by reaction with atmospheric moisture.

**Safe Drive-Away Time**

Chart 1: Safe Drive-Away Time Table for SikaTack® ASAP+						
Relative Humidity	Temperature (°C)					
	> -15°C	> 0°C	> 5°C	> 15°C	> 25°C	> 35°C < 50°C
Without Airbags (Minutes)						
> 90%	30	30	30	30	30	30
> 70%	30	30	30	30	30	30
> 40%	30	30	30	30	30	30
> 20%	30	30	30	30	30	30
> 0%	30	30	30	30	30	30
With Airbags (Minutes)						
> 90%	45	45	60	60	60	60
> 70%	45	45	60	60	60	60
> 40%	45	45	60	60	60	60
> 20%	45	45	60	60	60	60
> 0%	45	45	60	60	60	60

**Limitations**

This product is for use by trained installers only. Do not use without reviewing all Sika installation guidelines and the MSDS. This product **must** be used with Sika® Aktivator PRO to prevent the windshield from being dislodged in the event of a crash. If not used as directed, product may not perform as intended and personal injury or property damage may result. **Because of the fast curing properties of SikaTack® ASAP+, the windshield must be installed within 8 minutes of adhesive application.** At lower temperatures (-15°C to 5°C), Open Time is 5 minutes. Once opened, cartridges should be used up the same day. Avoid contact with alcohol and alcohol-containing solvents during cure. Never apply directly over clear-coat paint or on rusty surfaces. If stored above 24°C, shelf life may be reduced.

**Surface Preparation**

Surfaces must be clean, sound, dry and free from all traces of dust and grease. Clean edges of glass with Sika® Aktivator PRO (allow at least 3 minutes to dry). In the case of glass supplied without a ceramic frit, paint edges with Sika® Primer-206 G+P. Allow primer to dry for 30 minutes.

**Application**

Place cartridge in Sika-approved oven for a minimum of 1 hour. Product can be heated for a total of 10 hours (either consecutively or cumulatively). (Discard any unused adhesive after 10 hours.) Remove SikaTack® ASAP+ from heating device, puncture seal, attach appropriately-cut nozzle (e.g. "V"-notch) and apply adhesive.

**Removal**

Uncured SikaTack® ASAP+ 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. Do not use solvents on skin!

**Packaging**

300 ml cartridges

**Further Information**

Copy of the following publication is available upon request: Material 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. Product Data Sheets and Material Safety Data Sheets are available from your local representative.

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)**

An ISO 9001 certified company  
Pointe-Claire : ISO 14001 certified EMS

