

# Sikaflex®-220+

## Safe Drive-Away Time Charts

The charts below are to be used to determine how much time is required before windshields installed with Sikaflex®-220+ meet FMVSS 208/212 Windshield Retention Requirements. Be sure to select the correct chart, based on whether or not the car is equipped with airbags.

Also, refer to the temperature and humidity conditions to which the vehicle will be exposed to determine the correct Safe Drive-Away Time. All Sika Certified Technical Training Manual Installation instructions and product recommendations provided by Sika are to be respected.

<b>Sikaflex®-220+ - WITHOUT Passenger Airbag</b>										
Relative Humidity	Temperature									
	>-10°C	>-5°C	>0°C	>5°C	>10°C	>15°C	>20°C	>25°C	>30°C	>35°C - 43°C
<b>* For applications in this temperature range, we recommend the use of SikaTack® Drive or SikaTack® MOVE<sup>IT</sup></b>										
≥ 90%	24 hrs	24 hrs	24 hrs	4 hrs	3 hrs	3 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 80%	24 hrs	24 hrs	24 hrs	4 hrs	3 hrs	3 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 70%	24 hrs	24 hrs	24 hrs	4 hrs	3 hrs	3 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 60%	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 50%	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 40%	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	2 hrs	2 hrs	2 hrs	2 hrs
≥ 30%	*	*	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	4 hrs	2 hrs
≥ 20%	*	*	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	4 hrs	2 hrs
≥ 10%	*	*	*	24 hrs	24 hrs	24 hrs	4 hrs	4 hrs	4 hrs	2 hrs
≥ 0%	*	*	*	*	*	*	4 hrs	4 hrs	4 hrs	4 hrs

<b>Sikaflex®-220+ - WITH Passenger Airbag</b>										
Relative Humidity	Temperature									
	>-10°C	>-5°C	>0°C	>5°C	>5°C	>10°C	>15°C	>20°C	>25°C	>30°C - 43°C
<b>* For applications in this temperature range, we recommend the use of SikaTack® Drive or SikaTack® MOVE<sup>IT</sup></b>										
≥ 90%	*	*	*	16 hrs	12 hrs	12 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 80%	*	*	*	16 hrs	12 hrs	12 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 70%	*	*	*	16 hrs	12 hrs	12 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 60%	*	*	*	*	16 hrs	16 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 50%	*	*	*	*	16 hrs	16 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 40%	*	*	*	*	16 hrs	16 hrs	8 hrs	8 hrs	8 hrs	8 hrs
≥ 30%	*	*	*	*	*	*	16 hrs	16 hrs	16 hrs	8 hrs
≥ 20%	*	*	*	*	*	*	16 hrs	16 hrs	16 hrs	8 hrs
≥ 10%	*	*	*	*	*	*	16 hrs	16 hrs	16 hrs	8 hrs
≥ 0%	*	*	*	*	*	*	*	*	*	*