

SikaTack[®]-Drive

The Application Champion in Automotive Glass Replacement

Technical Product Data

Chemical Base	1-C polyurethane
Colour (CQP ¹⁾ 001-1)	Black
Cure Mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.25 kg/L approx.
Stability (non-sag properties)	Very good
Application Temperature	5°C - 35°C
Tack-Free Time ²⁾ (CQP 019-1)	15 min. approx.
Open Time ²⁾ (CQP 526-1)	10 min. approx.
Curing Speed (CQP 049-1)	(see diagram)
Shore A Hardness (CQP 023-1 / ISO 868)	70 approx.
Tensile Strength (CQP 036-1 / ISO 37)	8 N/mm ² approx.
Elongation at Break (CQP 036-1 / ISO 37)	250% approx.
Tear Propagation Strength (CQP 045-1 / ISO 34)	10 N/mm approx.
Tensile Lap-Shear Strength for a 4 mm applied thickness (CQP 046-1 / ISO 4587)	6 N/mm ² approx.
Safe Drive-Away Time ³⁾ (cars) according to US safety standards FMVSS 212/208	with double airbags without airbags 2 hours without seat belts 30 minutes
Volume Resistivity (CQP 079-2 / ASTM D 257-99)	10 ⁹ Ω cm approx.
Shelf Life (stored below 25°C) (CQP 016-0)	9 months

¹⁾ CQP = Corporate Quality Procedures

²⁾ 23°C / 50% r.h.

³⁾ +5°C/60% r.h. to +35°C/10% r.h.

Description

SikaTack[®]-Drive is a cold-applied windshield adhesive which exhibits excellent technical characteristics, such as black primerless application, compatibility with glass-mounted aerials, and non-conductivity. It is easy to apply and offers quality combined with safety. It is suitable for glass replacements on all passenger cars, with or without airbags. SikaTack[®]-Drive can be used all year round and provides a 2-hour Safe Drive Away Time in a wide climatic range (see Safe Drive-Away Time Chart).

SikaTack[®]-Drive is manufactured in accordance with the ISO 9001 / 14001 quality assurance system.

Product Benefits

- Black primerless
- Short cut-off string
- Very good non-sag properties
- Easy and clean application
- Sika "All-in-One"[®] Modulus
- Suitable for cars with integral antennas
- Short Safe Drive-Away Time, according to US safety standards FMVSS 212/208 (with and without seat belts, and passenger side airbags).
- Prevents contact-corrosion for aluminum-bodied vehicles
- Solvent-free

Areas of Application

SikaTack[®]-Drive has been specially designed for the Automotive Glass Replacement (AGR) business.

SikaTack[®]-Drive is ideal for mobile or in-house applications.

This product is suitable for professional experienced AGR specialists only. To ensure adhesion and material compatibility, perform tests with actual substrates and conditions.

Industry



Cure Mechanism

SikaTack®-Drive cures by reaction with atmospheric moisture. At low temperatures, the absolute water content of the air is lower and the curing reaction proceeds more slowly (see diagram 1).

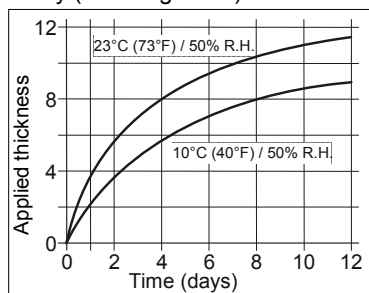


Diagram 1: Cure progression for SikaTack®-Drive

Chemical Resistance

SikaTack®-Drive is: resistant to water and proprietary aqueous cleaning agents (including windshield cleaners containing alcohol); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions or paint thinners.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Removal of old glass

Remove damaged glass, in accordance with the vehicle manufacturer's instructions.

Surface preparation

Surfaces must be clean, dry and free from all traces of dust and grease. The bond faces must be treated with a cleaning and activating agent or primed with the appropriate primer as follows:

Glass with uniform and continuous opaque, mineral based ceramic frit (valid for passenger cars only)	Sika® Aktivator PRO
Old polyurethane direct glazing adhesive (cut face)	Sika® Aktivator PRO
Metal with paint primer or with partial new painting (<25% of total bonding area)	Sika® Aktivator PRO
Metal with paint primer or with partial new painting (>=25% of total bonding area)	Sika® Aktivator PRO Sika® Primer-206 G+P

Glass without black ceramic border or cover trim (valid for passenger cars only)	Sika® Aktivator PRO Sika® Primer-206 G+P
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Detailed information on the application and use of activating agents, etc. can be found in the individual Product Data Sheet for the products concerned. The information provided here is intended for general guidance only. Specific advice on your intended application is available on request.

Application

Cartridges: Pierce cartridge membrane.

Sausages: Place sausage in the application gun and snip off the closure clip.

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge. If using sausages, attach nozzle with adapter to the sausage.

It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive bed, we recommend that the adhesive be applied in the form of a triangular bead (see Fig. 1).

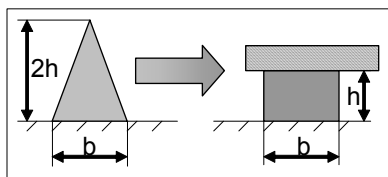


Fig 1: Compressing adhesive bead to final size

The glass must be installed within 10 minutes of starting to apply the adhesive.

In combination with Sika® Aktivator PRO, the substrate temperature must be between 5°C and 35°C. The optimum temperature for substrate and adhesive is between 10°C and 30°C.

Clean up

Uncured SikaTack®-Drive may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Hand Cleaner or a suitable industrial hand cleanser and water. Do not use solvents!

Packaging Information

Sausage	600 mL
Cartridge	300 mL

Further Information

Copies of the following publications are available on request:
- Material Safety Data Sheet

Value Bases

All technical data stated in this Product Data Sheet and laboratory test-based. Current measured values may vary due to factors beyond our influences.

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.

All Product Data Sheets and Material Safety Data Sheets are also available on our web site at: www.sika.ca.

Legal Notes

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.

Further information available at:
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