

**Product Data Sheet**

Version 10/2010 (05/2011)

## Sika® Titan P2G+™ Windshield 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 5°C to 45°C Surface 5°C to 75°C Air 5°C to 75°C
Tack-Free Time <sup>1</sup>	30 min.
Open Time <sup>1</sup>	15 min.
Shore A Hardness	65 approx.
Tensile Strength	750 psi
Elongation at Break	> 400%
Lap-Shear Strength	400 psi
Safe Drive-Away Time	See chart
Shelf Life (Stored below 25°C)	9 months
<small><sup>1</sup> 23°C and 50% Relative Humidity</small>	

**Description** Sika® Titan P2G+™ is a primerless-to-glass, one-component, non-conductive, 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, Sika® Titan P2G+™ passes all FMVSS 212/208 requirements. Sika® Titan P2G+™ is manufactured in accordance with the ISO 9001/14001 quality assurance system.

- Product Benefits**
- Primerless to glass (see Surface Preparation)
  - Excellent non-sag characteristics
  - Non-conductive
  - One-component formulation
  - Fast curing speed
  - Good cut-off string
  - Cost-effective
  - Short Safe Drive-Away Time
  - Exceeds FMVSS 212/208

**Areas of Application** Sika® Titan P2G+™ is designed for use in replacing polyurethane direct-glazed automotive glass parts. This product is suitable for professional, experienced AGR specialists only.

**Cure Mechanism** Sika® Titan P2G+™ 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.



**Method of Application**

**Removal of Old Glass:** Remove damaged glass in accordance with vehicle manufacturer's instructions. **Surface Preparation:** Surfaces must be 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. Contact our Technical Services Department if you require any additional help. **IMPORTANT NOTE:** While most glass parts introduced into the AGR market require only glass cleaner when bonding with Sika® Titan P2G+™, some parts require additional preparation to remove non-traditional contamination (i.e. silicone oils, mould release agents, etc.). Based on the type and severity of the non-traditional contamination, Sika offers several solutions for treatment, including the use of Sika® Cleaner S (II), an organic, water-based, micro-abrasive cleaner designed specifically to remove non-traditional contaminants. For additional information, refer to the Sika® Cleaner S (II) Product Data Sheet.

**Tooling and Finishing:** Tooling and finishing must be carried out within the tack-free time. We recommend the use of Sika® Slick; other finishing agents or lubricants must first be tested for compatibility.

**Safe Drive-Away Time**

Relative Humidity	Temperature (°C)			
	> 5°C	> 10°C	> 20°C	> 30°C
<b>Without Airbags (Hours)</b>				
> 90%	1	1	1	1
> 75%	1	1	1	1
> 50%	1	1	1	1
> 20%	1	1	1	1
<b>With Airbags (Hours)</b>				
> 90%	3	3	3	3
> 75%	3	3	3	3
> 50%	4	3	3	3
> 20%	5	5	5	5

Chart 1: Safe Drive-Away Time Table for Sika® Titan P2G+™

**Removal**

Uncured Sika® Titan P2G+™ 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  
600 ml sausages

**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. All Product Data Sheets and Material Safety Data Sheets are available on our website at: [www.sika.ca](http://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](http://www.sika.ca).

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