

**Product Data Sheet**

Version 02/2015 (04/2015)

# SikaTack® Mach-60

## Autoglass Replacement Adhesive

**Technical Data**

Chemical Base	One-component polyurethane	
Colour (CQP <sup>1</sup> 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)	12 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)	6.89 MPa	
Elongation at Break (CQP 036-1/ISO 37)	300%	
Tensile Lap-Shear Strength (CQP 046-1)	4.48 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	
<small><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.</small>		

**Description**

SikaTack® Mach-60 is a one-component, cold-applied, fast-curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Engineered to perform to the strength of OEM requirements, SikaTack® Mach-60 exceeds all Federal requirements for FMVSS 212/208.

SikaTack® Mach-60 is manufactured in accordance with the ISO 9001/14001 Quality Assurance System.

**Product Benefits**

- 1-hour Safe Drive-Away Time -- when used in accordance with Sika's installation instructions;
- Non-conductive;
- "All-in-One" modulus;
- Black primerless to glass;
- Can be used at temperatures ranging from -18°C to 50°C.

**Areas of Application**

SikaTack® Mach-60 has been designed for use in replacing polyurethane direct-glazed automotive glass parts.

This product is suitable for experienced professional users only. If this product is used for applications other than vehicle glass replacement, tests with actual substrates and under actual conditions must be performed to ensure adhesion and material compatibility.

**Cure Mechanism**

SikaTack® Mach-60 cures by reaction to atmospheric moisture.



## Safe Drive-Away Time

Relative Humidity	Temperature (°C)					
	> -18°C	> 0°C	> 10°C	> 20°C	> 30°C	32 - 50°C
> 90%	60 min	60 min	60 min	60 min	60 min	60 min
> 70%	60 min	60 min	60 min	60 min	60 min	60 min
> 40%	60 min	60 min	60 min	60 min	60 min	60 min
> 20%	60 min	60 min	60 min	60 min	60 min	60 min
> 0%	60 min	60 min	60 min	60 min	60 min	60 min

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

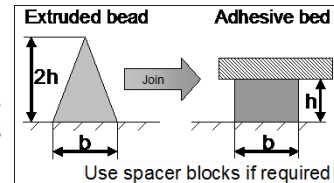


Figure 1: Recommended Bead Configuration

## Removal

Uncured SikaTack®-Mach-60 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!

**Further Information** Copy of the following publication is available upon request:

- *Safety Data Sheet*
- *Sika AGR Technician's Training Manual*

## Packaging

465 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 Information

For information and advice on the safe handling, storage and disposal of chemical products, 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](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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