

**Product Data Sheet**

Provisional (11/2018)

## SikaTack® DRIVE (60 Min) Autoglass Replacement Adhesive

**Technical Data**

Chemical Base	One-component polyurethane	
Colour (CQP <sup>1</sup> 001-1)	Black	
Cure Mechanism	Moisture-curing	
Density (uncured)	1.3 kg/L	
Non-Sag Properties	Excellent	
Application Temperature	Product	5 °C to 35 °C
	Air	5 °C to 35 °C
Skin Time (CQP 019-1)	15 min. <sup>A</sup>	
Open Time <sup>2</sup> (CQP 526-1)	10 min. <sup>A</sup>	
Curing Speed (CQP049-1)	See diagram 1	
Shore A Hardness (CQP 023-1/ISO 868)	60	
Tensile Strength (CQP 036-1/ISO 37)	7 MPa	
Elongation at Break (CQP 036-1/ISO 37)	300%	
Tear Propagation Resistance (CQP045-1 /ISO 34)	10 N/mm	
Tensile Lap-Shear Strength (CQP 046-1 /ISO 4587)	4 MPa	
Shear Modulus (CQP081-1)	All-in-One	
Safe Drive-Away Time (cars) according to FMVSS 212/208 (CQP511-1)	With Airbag - 60 minutes <sup>B/C</sup> Without Airbag - 30 minutes <sup>B/C</sup>	
Insulation Resistance (CQP079-2 / DIN IEC 60167)	Low Conductive	
Shelf Life (Stored below 25°C) (CQP 016-1)	12 months <sup>D</sup>	
<small>CQP = Corporate Quality Procedures; <sup>A</sup> 23 °C and 50% Relative Humidity <sup>B</sup> Contact Sika for SDAT details  <sup>C</sup> 5 °C / 80 % R.H. - 40 °C / 20 % R.H. <sup>D</sup> Storage below 25 °C</small>		

**Description** SikaTack® DRIVE (60 min) is a windshield adhesive with superior application properties. It offers a 60 minutes Safe Drive Away Time (SDAT). It has been tested according FMVSS 212 with 95th percentile dummies.

- Product Benefits**
- 60 minutes Safe Drive-Away Time;
  - Tested according to FMVSS 212 using 95th percentile crash test dummies;
  - Compatible with Black-Primerless and All-Black installation process;
  - Compatible with all car makes, thanks to Sika's "All-in-One" modulus technology;
  - Solvent-free;
  - Automotive OEM quality.

**Areas of Application** SikaTack® DRIVE (60 min) 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® DRIVE (60 min) cures by reaction to atmospheric moisture. At low temperatures, the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

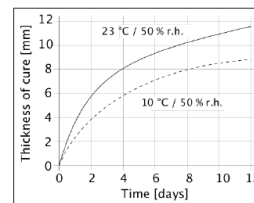


Diagram 1: Curing speed SikaTack® DRIVE (60min)



**Chemical Resistance** SikaTack® DRIVE (60min) is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

**Surface Preparation** Surfaces must be sound, clean, dry and free from grease, oil, dust and contaminants. The bond faces must be treated according to Sika's Black-Primerless or All-Black installation processes. Further information on the application and use of Pre-treatment products can be found in the corresponding Product Data Sheet of each product. Windshields without ceramic coatings need proper UV protection.

**Application** It is recommended to apply SikaTack® DRIVE (60min) with a battery-operated or air-powered piston-type application gun. Allow for the increase in viscosity at low temperatures. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline, it is recommended to apply the adhesive in the form of a triangular bead (see figure 1). The open time is significantly shorter in hot and humid climates. The windshield must always be installed within the open time. Never install a windshield after the product has formed a skin.

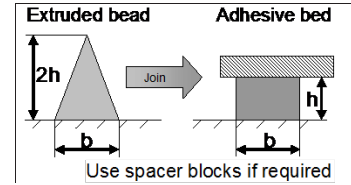


Figure 1: Recommended Bead Configuration

**Removal** Uncured SikaTack® DRIVE (60min) 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*
- *Black-Primerless Installation Process Chart*
- *All-Black Installation Process Chart*

**Packaging** 600 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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