

## PRODUCT DATA SHEET

## SikaTack® PRO

Premium choice for Auto Glass Professionals

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.3 kg/l
Non-sag properties		Excellent
Application temperature	product ambient	5 – 35 °C -10 – 35 °C
Skin time (CQP019-1)		10 minutes <sup>A</sup>
Open time (CQP526-1)		8 minutes <sup>A</sup>
Curing speed (CQP049-1)		(see diagram)
Shore A hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (CQP036-1 / ISO 527)		7 MPa
Elongation at break (CQP036-1 / ISO 527)		300 %
Tear propagation resistance (CQP045-1 / ISO 34)		10 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4.5 MPa
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)	with airbag	30 minutes <sup>B/C</sup>
Insulation resistance (CQP079-2 / DIN IEC 60167)		Low conductive
Shelf life (CQP016-1)		9 months <sup>D</sup>

CQP = Corporate Quality Procedure

C) -10 – 35 °C

A) 23 °C / 50 % r. h.

D) storage below 25 °C

B) Details about MDAT contact Sika

## DESCRIPTION

SikaTack® PRO is a cold applied Automotive Glass Replacement adhesive offering 30 minutes Minimum Drive-Away Time (MDAT). It can be used all year round and is ideal for mobile or in-house applications.

SikaTack® PRO has been tested according FMVSS 212 with 95<sup>th</sup> percentile dummies.

## PRODUCT BENEFITS

- 30 minutes Minimum Drive Away Time, acc. FMVSS 212 / 95th percentile dummies
- Supports fast, robust ADAS calibration
- Best in class application properties
- Automotive OEM quality
- Compatible with Sika's Activator or Black Primer process
- Compatible with all car makes thanks to Sika's all-in-one modulus technology
- Increased decking

## AREAS OF APPLICATION

SikaTack® PRO is suitable for experienced professional users only.

This product and related process information is designed for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

## CURE MECHANISM

SikaTack® PRO cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

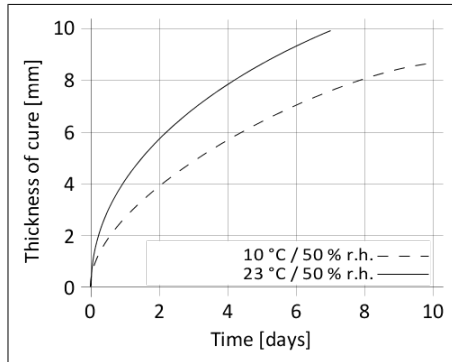


Diagram 1: Curing speed for SikaTack® PRO

## CHEMICAL RESISTANCE

SikaTack® PRO 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.

## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

The bond faces must be treated according to Sika's Activator or Black Primer process. Further information on the application and use of Pre-treatments, can be found in the corresponding Product Data Sheet. Glass without ceramic coatings need proper UV protection.

## Application

It is recommended to apply SikaTack® PRO with a powerful battery operated application gun.

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

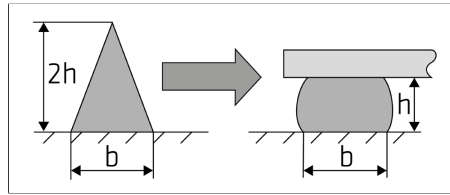


Figure 1: Recommended bead configuration

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the adhesive has built a skin.

## Removal

Uncured SikaTack® PRO can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika's Activator or Black Primer process

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	400 ml
	600 ml

## BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

## PRODUCT DATA SHEET

SikaTack® PRO  
Version 04.01 (10 - 2022), en\_DK  
012002210153008000

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