

SPECIFICATIONS

Prepared on:
March 30, 2007



Updated on:
March 30, 2007

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Product name: APP AUTO-GLASS / APP AUTO-GLASS KIT

A unary, polyurethane bonding-sealing compound characterised by very high viscosity. The product is used for fixing car windshields.

The adhesive has the following safety certificates:

- FMVSS 212 - collision-safe, car equipped with double airbags, after 6 hours at a temperature of 21°C.
- FMVSS 216 - roof crushing.

Container:	310 ml - cartouche containing adhesive, 30 ml, 250 ml and 1.0 l - aluminium bottles containing the K primer, 30 ml - bottle containing remover.
Product and additives:	APP AUTO-GLASS - glass adhesive, The K primer - primer for glass adhesive, GR 1001 - remover.
Basic components:	<ul style="list-style-type: none">• APP AUTO-GLASS - high-viscosity polyurethane adhesive resistant to ageing, which turns to elastomer state in contact with moisture contained in the air.• The K primer - polyisocyanate polymer, carbon black, solvent.• GR 1001 - ethanol with activating additives.
Colour:	Black.
Density at 20°C:	~ 1.19.
Consistence:	Tixotropic paste.
Shore hardness A:	>55 (ISO 868-3 sec.).
Shearing stress:	>500 psi (Ford SAE J 1529).
<u>Usage:</u>	<ul style="list-style-type: none">• for fixing car windshields in automotive industry, with air-guns or robots,• for secondary fixing of car windshields when they are replaced.

The above information complies with current knowledge on our products and their possible applications.

This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

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Base

Proper base types:

The K primer - primer for glass adhesive.
Old glass adhesive left on car body flange.

Base preparation:



Leave a 1-2 mm layer of old adhesive when replacing windshield.
The surfaces to be bonded need to be dry, clean, and degreased with GR 1001 remover.
In the areas where the adhesive is to be applied, wash the windshield with GR 1001 remover and cover it with K primer.

Application

Remove the bottom cover of the aluminium cartouche, and then puncture its threaded end.

Place the cartouche in a manually operated or pneumatic squeezer for sealing compounds.

Screw the plastic nozzle of the glass adhesive onto the threaded end of the cartouche.

The application speed drops at the end of the allowable storage period.

Spread APP AUTO-GLASS onto the dried K primer within 10-15 minutes after its application, or onto the old glass adhesive left on the flange of the car body window opening. The windshield must be fixed and pressed against the window opening flange within approximately 30 minutes after spreading the adhesive, that is before skinning time.

Application temperature: from +5°C to +35°C.

Caution!

Do not apply onto silicones or in the presence of cross linking silicones.

Contact of the preparation with MS polymers, alcohols and solvents during cross linking should be avoided .

The compound is suitable for use within 24 hours after opening the cartouche.

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Drying:



Hardening of the APP AUTO-GLASS adhesive starts immediately after applying, and depends on the temperature and humidity of the air.

At the temperature of +23°C and relative humidity of 50%:

- skinning: 40-60 minutes.
- through crosslinking rate: 3.5 mm / 24 hours.

D.A.T.

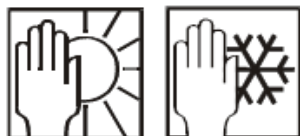
The D.A.T. (drive-away-time) after fixing the windshield:

- 4 hours for car without airbags,
- 6 hours for car with airbags.

Equipment cleaning:

Before hardening: xylene, MEK, acetone, or nitrocellulose solvent.
After hardening: mechanical cleaning.

Storage:



Store in original, closed containers in a dry and well-ventilated room.
Storage temperature: from +5°C to +35°C.
Protect against freezing.

Industrial safety regulations:



For professional use only.
See: information on product labels and/or in Hazardous Material Safety Data Sheet.
Users should observe all industrial safety regulations applicable in their countries.

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