

# TECHNICAL DATA SHEET

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12.02.2021



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## Product name: polyurethane adhesive for automotive glass fast APP Auto Glass GTX. APP No. 040531.

One-component polyurethane adhesive sealant with very high viscosity and short setting time for gluing front and side windows of cars. The adhesive achieved crashworthiness FMVSS 212 for cars equipped with dual airbags after 2 hours at +23°C and 50% RH.

Packaging: 310 ml - aluminum cartridge with adhesive.

Product and additives: APP Auto Glass GTX - fast glue for glass,  
Primer KM - glass adhesive primer.

Main ingredients: APP Auto Glass GTX - ageing resistant polyurethane adhesive of high viscosity and short binding time, transforming into elastomer state under the influence of atmospheric moisture.

Color: black.

Density at 20°C: 1.24±0.02.

Consistency: Thixotropic paste.

Shore A hardness: ~ 57 after 14 days (internal method IT-20 after ISO 868 - 3 s).

Shear resistance: > 3.5 MPa (>500 psi) for 7d at +23°C and 50% RH (Ford SAE J 1529).

Modulus at break: ~ 7.5 MPa (ISO 37).

Elongation to breakage: > 700 % (ISO 37).

Tear resistance:  
~ 30 N/mm.

Resistance to temp: -40°C do +90°C (after hardening).

Resistance to water and salt spray: excellent.

Application

- For bonding raw glass and ceramic screen printed glass.
- For bonding car windshields in the automotive industry using air guns or robots.
- For secondary bonding of automotive windscreens during replacement.
- For the bonding of side windows.

The above information is based on currently available data and knowledge on the product and its use. The information does not purport to be a description of product in terms of its quality, suitability for use in some conditions, nor does it guarantee any particular features. User shall follow instructions provided on labels and MSDS. Producer is not responsible for consequences and work effects that were influenced with factors beyond his control.

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## Substrate

Suitable substrates: APP Primer KM glass adhesive primer.  
Old glass adhesive on the body flange.

## Substrate preparation:

When replacing glass, leave 1-2 mm layer of old adhesive.  
The surfaces to be glued must be dry, clean, and degreased with a remover.

The windshield in the area of gluing must be degreased with remover, acetone or heptane, and covered with APP Primer KM.

## Use

Remove the bottom cover of the aluminum cartouche and then pierce its threaded end.

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

Place the cartouche in a manual or pneumatic sealant extruder.

The extrusion rate decreases at the end of the allowable storage period.

Apply APP Auto Glass GTX onto the dried primer.

APP Primer KM after 10-15 minutes of its application, or on old glass adhesive located on the flange of the car body window opening. The glass must be installed and pressed against the window opening flange within approximately 25 minutes after spreading the adhesive, i.e. before skin formation (skinning).

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

## Caution!

During curing, avoid any contact with uncured MS polymers, PU, or silicone hybrid sealants, as well as with alcohols or ammonia. Not suitable for substrates such as PE, PP, Teflon. Avoid contact with oils, plasticizers, or other products such as bitumen, asphalt, silicone, etc.

Shelf life of the compound after opening the cartridge is 24 hours.

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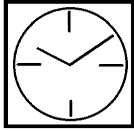


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### Drying



Curing of APP Auto Glass GTX adhesive starts immediately after application and depends on temperature and humidity of the air.

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

- Skinning: 25-40 minutes,
- Crosslinking speed: > 3.5 mm / 24 hours.

### D.A.T.

D.A.T. "drive-away-time" after windshield bonding.

"drive-away-time" at +23°C and 50% RH:

- 120 minutes for a car with two airbags.

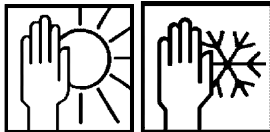
At lower temperatures between +5°C and +15°C, a double drying time must be observed.

### Cleaning of the equipment

Before curing: xylene, MEK (methyl ethyl ketone), acetone, or nitrocellulose solvent.

After curing: mechanical cleaning.

### Storage



Store in original, closed containers in dry and well ventilated spaces.  
Storage temperature: from +5°C to +25°C.

Protect against freezing.

### Safety and health regulations

For professional use only.

See text on product labels or safety data sheet.

Users must comply with the health and safety regulations in force in their country.

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