BUILDING TRUST

PRODUCT DATA SHEET

SikaTack® ELITE

DESIGNED FOR POWERCURE – HIGH SPEED PERFORMANCE IN ALMOST EVERY CLIMATE

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.3 kg/l
Non-sag properties		Very good
Application temperature	product	5 – 35 °C
	ambient	-10 – 35 °C
Open time (CQP526-1)		8 minutes [A]
Curing speed (CQP049-1)		See table 1
Shore A hardness (CQP023-1 / ISO 7619-1)		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)		5 MPa
Shear modulus (CQP081-1)		All-in-one
Safe Drive Away Time (cars) according FMVSS 212 (CQP511-1)	with airbag	30 minutes [B/C]
	without airbag	30 minutes [B/C]
Cured to OEM level (CQP046-1 / ISO 4587)		60 minutes [A]
Insulation resistance (CQP079-2 / DIN IEC 60167)		Low conductive
Shelf life (CQP016-1)		9 months [D]

CQP = Corporate Quality Procedure

[A] 23 °C / 50 % r. h.

[B] Details about SDAT contact Sika

[C] -10 – 35 °C

[D] storage below 25 °C

DESCRIPTION

SikaTack® ELITE provides 30 minutes Safe Drive Away Time and cures to OEM Level within just 60 minutes. SikaTack® ELITE is made for Sika's PowerCure System and is applied using the PowerCure Dispenser. It can be used all year round and is ideal for mobile or in-house applications. It has been tested according FMVSS 212 with 95th percentile dummies.

PRODUCT BENEFITS

- 30 min Safe Drive Away Time
- Tested according FMVSS 212 using 95th percentile dummies
- Compatible with all car makes thanks Sika's all-in-one modulus technology
- Cures almost independently of climate
- Cured to OEM Level within 60 minutes
- Best in-class application properties
- Automotive OEM quality

AREAS OF APPLICATION

SikaTack® ELITE is suitable for experienced 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® ELITE cures by reaction with the accelerator.

Time [min]	Strength [MPa]
60 min	1.5
120 min	3.0

Table 1: Lap shear strength (CQP 046-1) at 23 °C / 50 % r.h.

CHEMICAL RESISTANCE

SikaTack® ELITE 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 Sika's All Black installation process. Further information on the application and use of Pre-treatments, can be found in the corresponding Product Data Sheet.
Windshields without ceramic coatings need proper UV protection.

Application

Setup the PowerCure Dispenser according the PowerCure User Manual. If the application is discontinued for more than 2 minutes, the mixer needs to be replaced.
Consider the viscosity 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).

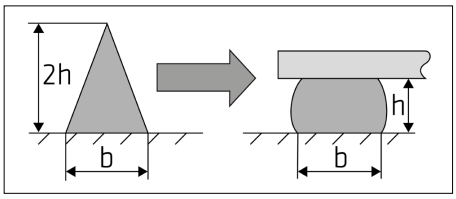

Figure 1: Compressing adhesive bead to final size

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 product has built a skin.

Removal

Uncured SikaTack® ELITE 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 cleaning towels 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
- All Black installation process chart
- PowerCure User Manual
- PowerCure Quick Reference Guide

PACKAGING INFORMATION

PowerCure Pack	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

The information, and, in particular, the recommendations relating to the application and enduse 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 in accordance with Sika's recommendations. 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 written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Sika Italia S.p.A.
Via Luigi Einaudi 6
20068 Peschiera Borromeo (MI)
industry@it.sika.com
Tel. +39 02 54778111
Fax +39 02 54778409
www.sika.it