

SikaTITAN-P2G™

Technical Product Data (typical values)

Chemical base	1-C polyurethane	
Color	Black	
Cure mechanism	Moisture-curing	
Density (uncured)	9.6 lb/gal	
Non-sag properties	Good	
Tack free time ¹	40 minutes	
Open time ¹	18 minutes	
Shore A-hardness	58	
Elongation at Break	> 500%	
Tensile strength	650 psi	
Lap shear strength	325 psi	
Application Temperature	Product	50°F - 110°F
	Surface	40°F - 170°F
	Air	40°F - 170°F
Shelf life (storage below 75°F (24°C))	9 months	

¹⁾ 73°F (23°C) / 50% r.h.

Industry

Description

SikaTITAN-P2G™ is a primerless to glass, one component, non-conductive, cold-applied, fast-curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Engineered to perform to the strength of OEM requirements, SikaTITAN-P2G™ passes all federal requirements for FMVSS 212 / 208.

Store cartridge below 75°F. Avoid contact with alcohol, and alcohol-containing solvents during cure. SikaTITAN-P2G™ is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program. Additional information can be obtained at www.sikausa.com or by contacting the Technical Service Department of Sika Corporation via e-mail (tsmh@sika-corp.com).

Product Benefits

- Primerless to glass*
- Good Decking
- Non-conductive
- One component formulation
- Fast curing speed
- Good cut-off string
- Cost effective
- Safe Drive Away Time in as little as two hours when used on vehicles without a passenger side airbag, four hours with passenger airbag.
- Passes FMVSS 212/208

Areas of Application

SikaTITAN-P2G™ is designed for use in replacing polyurethane direct-glazed automotive glass parts.

* Glass Contamination:

While most glass parts introduced into the AGR market require only glass cleaner when bonding with SikaTITAN-P2G™, some parts require additional preparation to remove non-traditional contamination (i.e. silicone oils, mold release agents, etc). Based on the type and severity of the non-traditional contamination, Sika offers several solutions for treatment, including the use of Sika Cleaner S, an organic solvent based material designed specifically to remove non-traditional contamination. For additional information, please refer to the SikaTITAN® AGR Technician Training Manual available at www.sikausa.com or call 1-800-688-7452.



Cure Mechanism

SikaTITAN-P2G™ cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the reaction proceeds more slowly extending Safe Drive Away Time.

Method of Application

Surfaces must be clean, sound, dry and free from all traces of dust and grease. All corrosion must be removed and all bare metal scrapes and scratches must be prepared in accordance with Sika's Corrosion Treatment recommendations. For preparation of all bonding surfaces it is required to read and understand the instructions given in the SikaTITAN® AGR Technician Training Manual. The SikaTITAN® AGR Technician Training Manual as well as additional information can be obtained at www.sikausa.com or by contacting the Technical Service Department of Sika Corporation via e-mail at tsmh@sika-corp.com. THIS PRODUCT IS TO BE USED BY TRAINED INSTALLERS ONLY. DO NOT USE WITHOUT THOROUGH REVIEW OF THE SIKATITAN® AGR TECHNICIAN TRAINING MANUAL, PRODUCT DATA SHEETS AND MSDS, WHICH CAN ALL BE OBTAINED AT WWW.SIKAUSA.COM. IF NOT USED AS DIRECTED, PRODUCT MAY NOT PERFORM AS INTENDED AND PERSONAL INJURY OR DAMAGE MAY RESULT FROM FAILURE OF PRODUCT TO PROPERLY ADHERE TO GLASS.

Safe Drive Away Time

Rel. Hum	Temperature (°F)			
	>40	>55	>70	>85
Without Airbags (hours)				
>90%	3 hr	3 hr	2 hr	2 hr
>75%	3 hr	3 hr	2 hr	2 hr
>50%	3 hr	3 hr	3 hr	2 hr
>20%	3 hr	3 hr	3 hr	3 hr
With Passenger Airbags (hours)				
>90%	10 hr	10 hr	6 hr	4 hr
>75%	10 hr	10 hr	8 hr	6 hr
>50%	10 hr	10 hr	8 hr	8 hr
>20%	10 hr	10 hr	10 hr	10 hr

Chart 1: Safe Drive Away Table for SikaTITAN-P2G™

Further information available at:
www.sikausa.com

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Madison Heights, MI 48071
USA
Tel. 248 577 0020
Fax 248 577 0810

Surface preparation

Surfaces must be clean, sound, dry and free from all traces of dust and grease. All corrosion must be removed and all bare metal scrapes and scratches must be prepared in accordance with Sika's Corrosion Treatment recommendations. For preparation of all bonding surfaces it is required to read and understand the instructions given in the SikaTITAN® AGR Technician Training Manual. The SikaTITAN® AGR Technician Training Manual as well as additional information can be obtained at www.sikausa.com or by contacting the Technical Service Department of Sika Corporation via e-mail at tsmh@sika-corp.com.

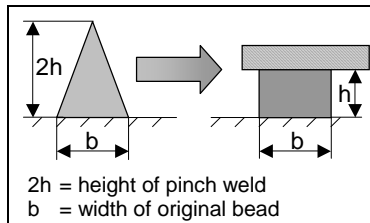


Figure1: Recommended bead configuration

Removal

Uncured SikaTITAN-P2G™ can be removed from tools and equipment with mineral spirits or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. **Strictly follow solvent manufacturer's instructions for use and warnings. Do not use solvents on skin!**

Limitations

- THIS PRODUCT IS FOR USE BY TRAINED APPLICATORS ONLY
- Product performs best when stored between 50 - 75°F. Wind chill does not directly affect product properties.
- Never apply over clear coat paint.
- Do not apply to rusty surfaces.
- Contact of uncured adhesive with alcohol containing substances will prevent proper cure.
- Once opened, contents of cartridges should be used up the

same day or protected for later use; otherwise the contents will harden and be rendered useless.

WARNING: IRRITANT, SENSITIZER.

Contains Polyisocyanate Prepolymer (Mixture), Polyvinyl Chloride (PVC) (CAS: 9002-86-2) and Stoddard Solvent (CAS: 8052-41-3). Causes skin/eye/respiratory irritation. Harmful if swallowed. May cause respiratory sensitization.

Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. **Intentional misuse by deliberate concentration and inhalation of vapors may be harmful or fatal.**

WARNING: This product contains a chemical known to the State of California to cause cancer and birth defects or other reproductive harm.

HMIS

Health	*2
Flammability	0
Reactivity	0
Personal Protection	C

First Aid

Eyes – Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin** – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation** – Remove to fresh air. **Ingestion** – Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further Information

Copies of the following publications are available on our website www.sikausa.com.

- Material Safety Data Sheet
- Product Data Sheet

In case of emergency call:
Chemtrec: 800-424-9300
International: 703-527-3887



For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

**-KEEP OUT OF REACH OF CHILDREN
-NOT FOR INTERNAL CONSUMPTION
-FOR INDUSTRIAL USE ONLY
-KEEP CONTAINER TIGHTLY CLOSED**

Packaging Information

Cartridge	300 ml
Unipac	300 ml, 600 ml

Handling and Storage

Avoid direct contact. Wear personal protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.

Clean Up

Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, sweep up spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable local, state, and federal regulations.

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Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at www.sikausa.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as

set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at:
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