SikaTack® MOVE IT

Technical Product Data (typical values) *Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical base</td>
<td>1-C polyurethane</td>
</tr>
<tr>
<td>Color</td>
<td>Black</td>
</tr>
<tr>
<td>Cure mechanism</td>
<td>Moisture-curing</td>
</tr>
<tr>
<td>Density (uncured)</td>
<td>10 lb/gal</td>
</tr>
<tr>
<td>VOC (EPA Method 24)</td>
<td>0.05 lb/gal (6 g/l)</td>
</tr>
<tr>
<td>Non-sag properties</td>
<td>Very Good</td>
</tr>
<tr>
<td>Application temperature</td>
<td>50° - 120°F (10° - 49°C)</td>
</tr>
<tr>
<td></td>
<td>0° - 170°F (-18° - 77°C)</td>
</tr>
<tr>
<td></td>
<td>0° - 120°F (-18° - 49°C)</td>
</tr>
<tr>
<td>Tack free time</td>
<td>12 minutes</td>
</tr>
<tr>
<td>Open time</td>
<td>8 minutes</td>
</tr>
<tr>
<td>Shore A-hardness</td>
<td>65</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>1100 psi</td>
</tr>
<tr>
<td>Elongation at break</td>
<td>300%</td>
</tr>
<tr>
<td>Tensile lap-shear strength</td>
<td>725 psi</td>
</tr>
<tr>
<td>Safe Drive-Away Time (cars)</td>
<td>according to FMVSS 212 / 208 see chart 1</td>
</tr>
<tr>
<td>Shelf life (storage below 75°F)</td>
<td>9 months</td>
</tr>
</tbody>
</table>

1) 73°F (23°C) / 50% r.h.  
2) Open time corresponds to working time

Description
SikaTack® MOVE IT is a one component 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, SikaTack® MOVE IT exceeds all federal requirements even in the most severe interpretations for FMVSS 212 / 208. Store below 75°F. Avoid contact with alcohol, and alcohol-containing solvents during cure.

SikaTack® MOVE IT 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](http://www.sikausa.com) or by contacting the Technical Service Department of Sika Corporation via e-mail at tsmh@us.sika.com.

Product Benefits
- 1-hour Safe Drive Away Time
- Non-conductive
- "All-In-One" Modulus
- Passes FMVSS 212/208 (with dual airbags and unrestrained occupants)
- Easy to use
- One-component
- Short cut-off string
- Black primerless to glass
- Cost effective
- Can be used from 0°F - 120°F

Areas of Application
SikaTack® MOVE IT is designed for use in replacing polyurethane direct-glazed automotive glass parts.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.
Cure Mechanism
SikaTack® MOVE IT cures by reaction with atmospheric moisture.

Method of Application
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 scrages and scratches must be prepared in accordance with Sika’s Corrosion Treatment recommendations. Prepare bond area of glass with Sika®-Aktivator PRO. THIS PRODUCT MUST BE USED WITH SIKA®-AKTIVATOR PRO TO LIMIT DISPLACEMENT OF GLASS IN THE EVENT OF A CRASH. IF NOT USED AS DIRECTED, PRODUCT MAY NOT PERFORM AS INTENDED AND AS DIRECTED, PRODUCT MAY NOT MERELY RESULT FROM FAILURE OF PERSONAL INJURY OR DAMAGE MAY RESULT FROM FAILURE OF PRODUCT TO PROPERLY ADHERE TO GLASS. For preparation of all bonding surfaces it is required to read and understand the instructions given in the Sika AGR Technician Training Manual or by contacting the Technical Service Department of Sika Corporation via e-mail at tsmh@us.sika.com.

Application
Puncture seal, attach appropriately cut nozzle (e.g. “V” notch) and apply adhesive. For complete instructions, refer to the Sika AGR Technician Training Manual. THIS IS TO BE USED BY TRAINED INSTALLERS ONLY. DO NOT USE WITHOUT REVIEW OF ALL Sika INSTALLATION GUIDELINES, PRODUCT DATA SHEET AND MSDS.

Liquid Polyurethane Adhesive SikaTack® MOVE IT

>0% 1 1 1 1 1 1
>25% 30 30 30 30 30 30
>35% 30 30 30 30 30 30
>52% 30 30 30 30 30 30
>72% 30 30 30 30 30 30
>90% 30 30 30 30 30 30
With Passenger Airbags (hours)
>90% 1 1 1 1 1 1
>70% 1 1 1 1 1 1
>40% 1 1 1 1 1 1
>20% 1 1 1 1 1 1
>0% 1 1 1 1 1 1
Chart 1: Safe Drive Away Table for SikaTack® MOVE IT

For more detailed adhesive application and auto glass installation instructions, refer to Sika’s Installation Instructions for Cold-Applied Adhesives. For complete instructions, refer to the Sika AGR Technician Training Manual or by contacting the Technical Service Department of Sika Corporation via e-mail at tsmh@us.sika.com.

Removal
Uncured SikaTack® MOVE IT 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!

Further Information
In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887. For more information, consult Material Safety Data Sheet and Product Data Sheet, contact Sika Technical Services at tsmh@us.sika.com or visit www.sikausa.com.

Copies of the following publications are available on our website www.sikausa.com:
-Material Safety Data Sheets
-Product Data Sheet
-AGR Technician Training Manual

Further information available at: www.sikausa.com
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

<table>
<thead>
<tr>
<th>Cartridge</th>
<th>300 ml</th>
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</thead>
<tbody>
<tr>
<td>Unipac</td>
<td>600 ml</td>
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</table>

Value Basis
All technical data stated in this Product Data Sheet are based on laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Handling and Storage
SikaTack® MOVEIT must not be stored above 75°F. Unopened cartridges and unipacs have a shelf life of 9 months in cool, dry conditions. If stored above 75°F, the shelf life could be reduced from the stated 9 months. 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, remove spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable environmental regulations.

Limited Material Warranty
SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer’s sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.

Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika’s instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika’s control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at www.sikausa.com or by calling 201-933-8800.

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:
www.sikausa.com

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