

## PRODUCT DATA SHEET

# SikaTack® ULTIMATE

Primerless auto glass polyurethane adhesive

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

<b>Chemical base</b>	1-component polyurethane						
<b>Color (CQP001-1)</b>	Black						
<b>Cure mechanism</b>	Moisture-curing						
<b>Density (uncured)</b>	1.2 kg/l						
<b>Non-sag properties</b>	Very good						
<b>Application temperature</b>	<table> <tr> <td>product</td> <td>10 – 49 °C (50 – 120 °F)</td> </tr> <tr> <td>ambient</td> <td>-18 – 49 °C (0 – 120 °F)</td> </tr> <tr> <td>substrate</td> <td>-18 – 77 °C (0 – 170 °F)</td> </tr> </table>	product	10 – 49 °C (50 – 120 °F)	ambient	-18 – 49 °C (0 – 120 °F)	substrate	-18 – 77 °C (0 – 170 °F)
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ambient	-18 – 49 °C (0 – 120 °F)						
substrate	-18 – 77 °C (0 – 170 °F)						
<b>Skin time (CQP019-1)</b>	12 minutes <sup>A</sup>						
<b>Open time (CQP526-1)</b>	8 minutes <sup>A</sup>						
<b>Shore A hardness (CQP023-1 / ISO 48-4)</b>	60						
<b>Tensile strength (CQP036-1 / ISO 527)</b>	5 MPa (720 psi)						
<b>Elongation at break (CQP036-1 / ISO 527)</b>	600 %						
<b>Tensile lap-shear strength (CQP046-1 / ISO 4587)</b>	3 MPa (430 psi)						
<b>Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)</b>	See table 1						
<b>Service temperature (CQP509-1 / CQP513-1)</b>	-40 – 93 °C (-40 – 200 °F)						
<b>Shelf life</b>	6 months <sup>B</sup>						

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C (73 °F) / 50 % r.h.<sup>B</sup>) stored below 25 °C (77 °F)
**DESCRIPTION**

SikaTack® ULTIMATE is a cold-applied, fast curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. SikaTack® ULTIMATE does not require the use of a Sika® Aktivator or Sika® Primer pre-treatment product on glass or ceramic frit. When used as directed SikaTack® ULTIMATE is an appropriate adhesive for use in auto glass replacement applications.

**PRODUCT BENEFITS**

- No pre-treatment required for glass or frit
- 30 minute Minimum Drive Away Time (MDAT); tested according to FMVSS 212
- All-in-one modulus and non-conductive
- Optimized thixotropic properties such as de-cking and glass slip down
- Can be used from -18 – 49 °C (0 – 120 °F)

**AREAS OF APPLICATION**

SikaTack® ULTIMATE is suitable for experienced professional 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 ensuring adhesion and material compatibility.

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Version 01.01 (05 - 2024), en\_US

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## CURE MECHANISM

SikaTack® ULTIMATE cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower. More information can be found in the Minimum Drive Away Time table that follows.

Relative Humidity	Temperature (°C)			
	> -18 (0)	> 0 (32)	> 10 (50)	20 – 49 (68-120)
> 90 %	30	30	30	30
> 70 %	30	30	30	30
> 40 %	30	30	30	30
> 20 %	30	30	30	30
> 0 %	30	30	30	30

Table 1: Minimum Drive Away Time (minutes)

## CHEMICAL RESISTANCE

SikaTack® ULTIMATE 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 prepared with an Automotive grade glass cleaner. SikaTack® ULTIMATE is capable to bond on glass and ceramic frits without additional pre-treatment. Further information on the application and use of cleaning agent, can be found in the corresponding Product Data Sheet.

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 Sika AGR Technician Training Manual.

Windshields without ceramic coating need proper UV protection.

## Application

It is recommended to apply SikaTack® ULTIMATE with a powerful battery operated application gun.

Consider that the viscosity will 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 recommended to apply the adhesive in the form of a triangular bead (see figure 1).

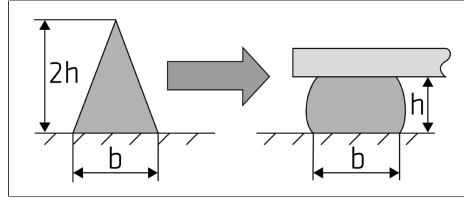


Figure 1: Recommended bead configuration

## Removal

Uncured SikaTack® ULTIMATE may 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 or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

## Application Limits

- Avoid contact with alcohol and alcohol containing solvents during cure.
- Do not apply over silicones or in the presence of curing silicones.
- Glass parts must always be installed within the open time. The open time is significantly shorter in hot and humid climates. Never install any glass part after the product has built a 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
- Product Data Sheets
- Sika AGR Technician Training Manual

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	465 ml 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.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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 the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **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.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

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