

SikaTack[®] Ultrafast II

*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.*

Chemical base		1-C polyurethane
Color		Black
Cure mechanism		Moisture-curing
Density (uncured)		9.6 lbs/gal
VOC		0.02 lbs/gal (2.2 g/l)
Non-sag properties		Very Good
Application temperature	product surface air	175°F (79°C) 15° – 170°F (-10° - 77°C) 15° – 120°F (-10° - 49°C)
Heating Time		60 minutes
Skin time ¹⁾		15 minutes
Open time ¹⁾		10 minutes
Shore A-hardness(ASTM D 2240)		60
Tensile strength (ASTM D 412)		800 psi
Elongation at break (ASTM D 412)		400%
Tensile lap-shear strength (ASTM D 1002)		500 psi
Safe Drive-Away Time (cars)		according to FMVSS 212 / 208 see chart 1
Shelf life (storage below 77°F (25°C))	cartridge	9 months

¹⁾ 73°F (23°C) / 50% r.h.

Description

SikaTack[®] Ultrafast II is a hot-applied, fast curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts engineered to conform to the strength of OEM requirements. SikaTack[®] Ultrafast II exceeds all federal requirements for FMVSS 212 / 208.

Store cartridge below 77°F. Avoid contact with alcohol, and alcohol-containing solvents during cure. SikaTack[®] Ultrafast II 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 at tsmh@us.sika.com.

Product Benefits

- 1 hour Safe Drive Away Time when used in accordance with Sika's Instructions
- Non-conductive
- One-component
- Short cut-off string
- Black primerless to glass
- Cost effective
- Can be applied at surface/air temperatures as low as 15°F

Areas of Application

SikaTack[®] Ultrafast II 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.

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, label and Safety Data Sheet which are available at <http://usa.sika.com/> or on request at tsmh@us.sika.com. Nothing contained in any Sika 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 Data Sheet, label and Safety Data Sheet prior to product use.

Industry



Cure Mechanism

SikaTack® Ultrafast II cures by reaction with atmospheric moisture.

Safe Drive Away Time

Rel. Hum.	Temperature (°F)					
	>15	>25	>35	>55	>72	>95-120
>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® Ultrafast II

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 scrapes 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 SIKAS® 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 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. The AGR Technician 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@us.sika.com.

Application

Place cartridge in a Sika approved oven for a minimum of 1 hour. Product can be heated for a total of 10 hours (either consecutively or in shorter periods adding up to a total of 10 hours.) Remove SikaTack® Ultrafast II from heating device, puncture seal, attach appropriately cut nozzle (e.g. "V" notch) and apply adhesive. For more detailed adhesive application and windshield installation instructions, refer to Sika's Installation Instructions for Hot-Applied Adhesives.

Because of the fast curing properties of Ultrafast II, The windshield must be installed within 10 minutes of application.

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 SIKAS INSTALLATION GUIDELINES AND MSDS.**

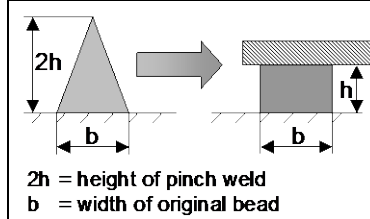


Figure 1: Recommended bead configuration

Tooling & Finishing

Tooling and finishing must be carried out within the skin time of the adhesive. We recommend the use of Sika® Slick. Other finishing agents or lubricants must be tested for suitability/compatibility.

Removal

Uncured SikaTack® Ultrafast II may be removed from tools and equipment with mineral spirits or another suitable solvent. Strictly follow solvent manufacturer's warnings and instructions for use. 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. Do not use solvents on skin!

Limitations

THIS PRODUCT IS FOR USE ONLY BY TRAINED APPLICATORS.

- Do not use this product without review of all Sika installation guidelines, Product Data Sheet and Safety Data Sheet. These can be obtained at www.sikausa.com.
- Once opened, cartridges should be used the same day.
- Avoid contact with alcohol, and alcohol-containing solvents during cure.
- Never apply over clear coat paint.

- Always use in conjunction with Sika® Aktivator PRO.
- Do not apply to rusty surfaces.
- If stored above 77°F, the shelf life could be reduced.
- Wind chill does not affect product properties.

WARNING: IRRITANT, SENSITIZER.
WARNING: Contains Polyisocyanate Prepolymer (Mixture). Causes eye irritation. May cause skin/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged contact. May be harmful if swallowed. Use only in well ventilated areas. **Deliberate misuse by inhalation of vapors may be harmful or fatal. Strictly follow all usage, handling and storage instructions.**

HMIS

Health	2
Flammability	1
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

For more information, consult Safety Data Sheet and Product Data Sheet, contact technical services at tsmh@us.sika.com or www.sikausa.com.

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

- Safety Data Sheets
- Product Data Sheet
- AGR Technician Training Manual

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 Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to

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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
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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® Ultrafast II must not be stored above 77°F. Unopened cartridges have a shelf life of 9 months in cool, dry conditions. If stored above 77°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 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.

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