BUILDING TRUST

PRODUCT DATA SHEET

SikaTack® Ultrafast US

Fast black-primerless, warm applied direct glazing adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-C polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.20 kg/l (10.0 lb/gal)
Non-sag properties		Very good
Application temperature	product ambient	70 – 90 °C (158 – 194 °F) 5 – 40 °C (41 – 104 °F)
Skin time (CQP019-1)		15 minutes [A]
Open time (CQP526-1)		10 minutes [A]
Curing speed (CQP049-1)		(see diagram 1)
Shrinkage (CQP014-1)		2 %
Shore A hardness (CQP023-1 / ISO 48-4)		65
Tensile strength (ASTM D412)		7 MPa (1000 psi)
Elongation at break (ASTM D412)		450 %
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4 MPa (580 psi)
Service temperature (CQP509-1 / CQP513-1)		-50 – 90 °C (-58 – 194 °F)
Shelf life	Cartridges Drums	9 months [B] 6 months [B]

CQP = Corporate Quality Procedure

[A] 23 °C (73 °F)/ 50 % r. h.

[B] storage below 25 °C (77 °F)

DESCRIPTION

SikaTack® Ultrafast US is an elastic 1-component polyurethane direct glazing adhesive with very good working characteristics in terms of cut off string and non-sag properties.

PRODUCT BENEFITS

- Very good application properties
- High initial green strength
- Compatible with Black-Primerless and All Black installation process
- Very short cut-off string
- Short tack free and cure times

AREAS OF APPLICATION

SikaTack® Ultrafast US is suitable for direct glazing applications in various markets as well as general purpose high strength elastic bonding.

Seek manufacturer's advice and perform tests on original substrates before using SikaTack® Ultrafast US on materials prone to stress cracking.

SikaTack® Ultrafast US is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

SikaTack® Ultrafast US 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 (see diagram 1).

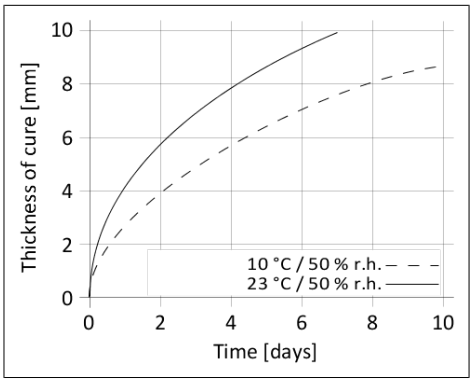

Diagram 1: Curing speed SikaTack® Ultrafast US

CHEMICAL RESISTANCE

SikaTack® Ultrafast US 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.
Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.
Glass without ceramic coatings need proper UV protection.

Application

SikaTack® Ultrafast US can be processed at climate conditions between 5 °C and 40 °C (41 °F and 104 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and climate is between 15 °C and 25 °C (59 °F and 77 °F).

SikaTack® Ultrafast US needs to be heated up to the recommended temperature range prior to application. This usually takes 60 minutes in a Sika approved cartridge oven. The product can be heated for a total of 10 hours (either consecutively or in shorter periods adding up to a total of 10 hours).
To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

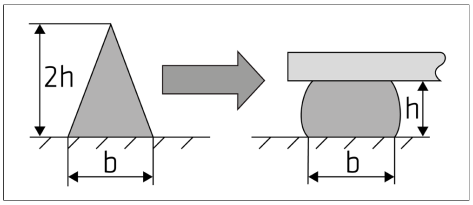

Figure 1: Recommended bead configuration

SikaTack® Ultrafast US can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment.
The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install glass after the adhesive has built a skin.
For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured SikaTack® Ultrafast US 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 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
- Sika Pre-treatment Chart
  For 1-component Polyurethanes
- General Guideline
  Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Drum	200 liter

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 or by contacting SIKA's Technical Service Department via email at 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.
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