



SIKA SAFE-DRIVE-AWAY-TIME (SDAT) CHARTS

Sika offers a full line of Auto Glass Replacement (AGR) Adhesives to meet every customer's SDAT needs. All SDAT Charts are determined by the ambient temperature and relative humidity at the location of the windshield replacement.

COLD-APPLIED

SikaTack® MACH 30

All-in-One Modulus and Non-Conductive

Rel. Hum.	Temperature (°F)			
	>0	>32	>50	65-120
>90%	30	30	30	30
>70%	30	30	30	30
>40%	30	30	30	30
>20%	30	30	30	45
>0%	30	30	30	45

*Minutes

SikaTack® MACH 60

All-in-One Modulus and Non-Conductive

Rel. Hum.	Temperature (°F)			
	>0	>32	>50	65-120
>90%	1	1	1	1
>70%	1	1	1	1
>40%	1	1	1	1
>20%	1	1	1	1
>0%	1	1	1	1

*Hours

Sikaflex® 220+

Rel. Hum.	Temperature (°F)				
	>25	>40	>50	>72	95-110
>90%	NR	16	12	8	8
>70%	NR	16	12	8	8
>40%	NR	NR	16	8	8
>20%	NR	NR	NR	16	8
>0%	NR	NR	NR	NR	NR

*Hours

COLD-APPLIED, PRIMERLESS

Sikaflex® P2G PLUS

Rel. Hum.	Temperature (°F)			
	>40	>55	>70	85-110
>90%	3	3	3	3
>75%	3	3	3	3
>50%	3	3	3	3
>0%	3	3	3	3

*Hours

Sikaflex® P2G

Rel. Hum.	Temperature (°F)			
	>40	>55	>70	85-110
>90%	6	6	6	4
>75%	6	6	6	6
>50%	6	6	6	6
>0%	6	6	6	6

*Hours

HOT-APPLIED

SikaTack® ASAP+

All-in-One Modulus and Non-Conductive

Rel. Hum.	Temperature (°F)			
	>0	>32	>50	65-120
>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

*Minutes

SikaTack® Ultrafast II

All-in-One Modulus and Non-Conductive

Rel. Hum.	Temperature (°F)			
	>15	>32	>50	65-120
>90%	1	1	1	1
>70%	1	1	1	1
>40%	1	1	1	1
>20%	1	1	1	1
>0%	1	1	1	1

*Hours

For additional information regarding each product, please review the Product Data Sheet (PDS), Safety Data Sheet (SDS), and the Sika AGR Technician Training Manual (TTM). To obtain these documents, or other information, call **1-800-688-7452**, or visit: **www.sikaindustry.com**

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