

PRODUCT DATA SHEET

Sikaflex® P2G

PRIMERLESS WINDSHIELD ADHESIVE

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1 component polyurethane	
Color (CQP001-1)	Black	
Cure mechanism	Moisture-curing	
Density	1.3 kg/l	
Non-sag properties	Excellent	
Application temperature	Product	10 – 35 °C (50 – 95 °F)
	Ambient	4 – 43 °C (40 – 110 °F)
	Substrate	4 – 54 °C (40 – 130 °F)
Skin time (CQP019-1)	30 minutes ^A	
Open time (CQP526-1)	15 minutes ^A	
Shore A hardness (CQP023-1 / ISO 7619-1)	65	
Tensile strength (CQP036-1 / ISO 527)	5 MPa (750 psi)	
Elongation at break (CQP036-1 / ISO 527)	400 %	
Tensile lap-shear strength (CQP046-1 / ISO 4587)	3 MPa (400 psi)	
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)	See Table 1	
Service temperature (CQP509-1 / CQP513-1)	-40 – 93 °C (-40 – 200 °F)	
Shelf life (CQP016-1)	9 months ^B	

CQP = Corporate Quality Procedure

^A 23 °C (73 °F) / 50 % r.h.^B Stored below 25 °C (77 °F)**DESCRIPTION**

Sikaflex® P2G is a primerless to glass, one component, cold-applied, fast curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. When used as directed Sikaflex® P2G meets or exceeds the strength requirements outlined in the direct glazing specifications of automobile manufacturers.

PRODUCT BENEFITS

- Primerless to glass
- 6 Hour Minimum Drive Away Time (MDAT); tested according to FMVSS 212
- Short cut-off string
- Cost effective

AREAS OF APPLICATION

Sikaflex® P2G has been specifically designed for the Automotive Glass Replacement business. It is ideal for mobile and in-shop installations.

This product is to be used by professional, experienced users only. Related process information in this PDS is specifically for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

Sikaflex® P2G cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the reaction proceeds more slowly. More information can be found in the Minimum Drive Away Time table that follows.

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

Table 1: Minimum Drive Away Time (hours)

CHEMICAL RESISTANCE

Sikaflex® P2G 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, sound, dry and free from all traces of traditional and non-traditional contamination. 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

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge or the unipack adapter.

It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive be applied in the form of a triangular bead (see fig. 1).

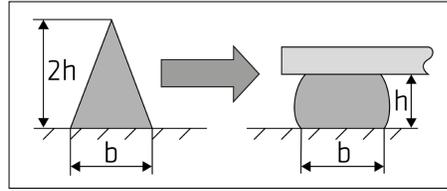


Figure 1: Compressing adhesive bead to final size

Removal

Uncured Sikaflex® P2G 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!

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

Please contact your local Sika Technical Services Department to request advice on specific applications. Copies of the following publications are available on our website www.sikaindustry.com:

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

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	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

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