BUILDING TRUST

PRODUCT DATA SHEET

SikaTack® TRANSPORT (Purform®)

Low monomer adhesive for commercial vehicle glass replacement

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane (Purform®)
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.31 kg/l
Non-sag properties (CQP061-1)		Very good
Application temperature	product, ambient	5 - 35 °C
Skin time (CQP019-1)		22 minutes [A]
Open time (CQP526-1)		18 minutes [A]
Curing speed (CQP049-1)		See diagramm 1
Shore A hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (CQP036-1 / ISO 527)		7 MPa
Elongation at break (CQP036-1 / ISO 527)		300 %
Tear propagation resistance (CQP045-1 / ISO 34)		10 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4.5 MPa
Minimum Drive Away Time for supported glass	< 40 kg < 75 kg	2 hours [B] 4 hours [B]
Service temperature (CQP509-1 / CQP513-1)		-40 - 90 °C
Shelf life		12 months [C]

CQP = Corporate Quality Procedure [A] 23 °C / 50 % r.h. [B] details about MDAT contact Sika [C] stored below 25 °C

DESCRIPTION

SikaTack® TRANSPORT (Purform®) is based on Purform®, an industry-leading polyurethane with less than 0.1 % monomeric diisocyanate for better health protection and occupational safety.

SikaTack® TRANSPORT (Purform®) is a cold-applied adhesive specially designed for glass replacement and gap filling application for buses, coaches and trucks. It provides a good weathering stability and is therefore suitable for open joints.

PRODUCT BENEFITS

- Less than 0.1 % monomeric diisocyanate for better health protection and occupational safety
- Short Minimum Drive Away Time for commercial vehicles
- Suitable for bonding and gap filling
- Exhibits good weathering stability
- Best in class application properties
- Compatible with Sika's All Black Primer Installation Process
- Ideal product for glass replacement on commercial vehicles

AREAS OF APPLICATION

SikaTack® TRANSPORT (Purform®) has been specially designed as an all-in-one solution for the windshield replacement of commercial vehicles such as buses and trucks. Thanks to its weathering stability it can be used for both bonding and gap filling. It is ideal for mobile and in-house installations.

This product 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.

CURE MECHANISM

SikaTack® TRANSPORT (Purform®) 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).

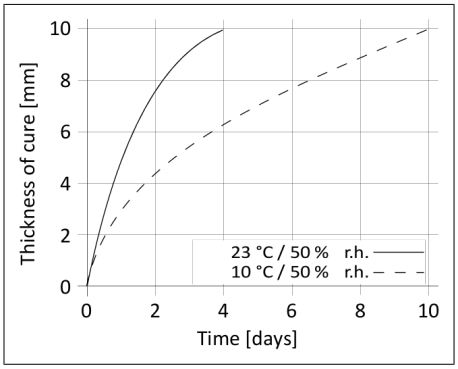


Diagram 1: Curing speed SikaTack® TRANSPORT (Purform®)

CHEMICAL RESISTANCE

SikaTack® TRANSPORT (Purform®) 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 treated according Sika's All Black Primer installation process. Further information on the application and use of Pre-treatments, can be found in the corresponding Product Data Sheet.
Windshields without ceramic coatings need proper UV protection.

Application

It is recommended to apply SikaTack® TRANSPORT (Purform®) 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 form of a triangular bead (see figure 1).

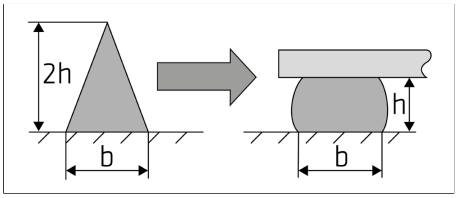


Figure 1: Recommended bead configuration

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the adhesive has built a skin.

Removal

Uncured SikaTack® TRANSPORT (Purform®) 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 such as Sika® Cleaner-350H or 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
- All Black Primer Process Auto Glass Replacement Installation Guideline

PACKAGING INFORMATION

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.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

Sika Danmark A/S
Hirsemarken 5
3520 Farum
Tlf. +45 48 18 85 85
www.sika.dk