

PRODUCT DATA SHEET

SikaTack® MAX 30 (Purform®)

Premium choice for Auto Glass Professionals

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)	1.33 kg/l
Non-sag properties	Excellent
Application temperature	product ambient
	5 – 35 °C -5 – 35 °C
Skin time (CQP019-1)	12 minutes ^A
Open time (CQP526-1)	8 minutes ^A
Shore A hardness (CQP023-1 / ISO 48-4)	60
Tensile strength (CQP036-1 / ISO 527)	6 MPa
Elongation at break (CQP036-1 / ISO 527)	550 %
Tear propagation resistance (CQP045-1 / ISO 34)	20 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)	4 MPa
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)	30 minutes ^{B/C}
Service temperature (CQP509-1 / CQP513-1)	-40 – 80 °C
Shelf life	9 months ^D

CQP = Corporate Quality Procedure

A) 23 °C / 50 %

C) -5 – 35 °C

B) details about MDAT contact Sika

D) storage below 25 °C

DESCRIPTION

SikaTack® MAX 30 (Purform®) is based on Purform®, an industry-leading polyurethane with less than 0.1 % monomeric diisocyanate for better health protection and occupational safety.

SikaTack® MAX 30 (Purform®) is a cold-applied automotive glass adhesive with OEM strength for vehicle glass replacement, allowing the vehicle to be put back into service after just 30 minutes (MDAT – Minimum Drive-Away Time).

The product can be used year-round and is ideal for both mobile service and workshop operations.

SikaTack® MAX 30 (Purform®) is tested according to FMVSS 212 and features the same chemistry used by vehicle manufacturers—ensuring the adhesive possesses the correct strength.

PRODUCT BENEFITS

- Less than 0.1 % monomeric diisocyanate for better health protection and occupational safety
- 30 minutes Minimum Drive Away Time, acc. FMVSS 212
- Supports fast, robust ADAS calibration
- Best in class application properties
- Automotive OEM quality
- Compatible with Sika's Clear Aktivator Process and Sika's All Black Primer Process
- Compatible with all car brands thanks to Sika's all-in-one modulus technology
- Improved decking properties

AREAS OF APPLICATION

SikaTack® MAX 30 (Purform®) is developed for the professional replacement of automotive glass and should only be used by trained and experienced technicians.

The product is specifically designed for bonding automotive glass in vehicles and is suitable for both workshop and mobile service operations.

If used for purposes other than automotive glass replacement, it is recommended to conduct preliminary testing to ensure sufficient adhesion and compatibility with the relevant materials.

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CURE MECHANISM

SikaTack® MAX 30 (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).

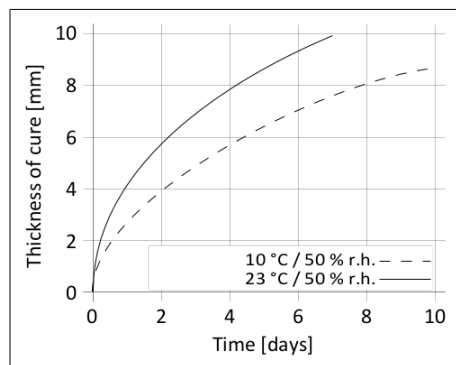


Diagram 1: Curing speed for SikaTack® MAX 30 (Purform®)

CHEMICAL RESISTANCE

SikaTack® MAX 30 (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 Clear Aktivator or All Black 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® MAX 30 (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).

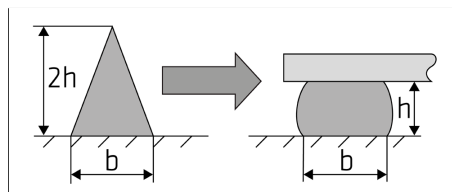


Figure 1: Recommended bead configuration

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

Removal Uncured SikaTack® MAX 30 (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 guideline 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
- Clear Aktivator Process Auto Glass Replacement Installation Guideline
- All Black Primer Process Auto Glass Replacement Installation Guideline
- Brochure: Auto Glass Replacement Safety Without Compromise
- General Guideline for vehicle glass replacement

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	400 ml
	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.