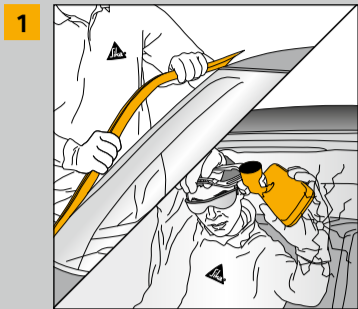


# ALL BLACK PROCESS

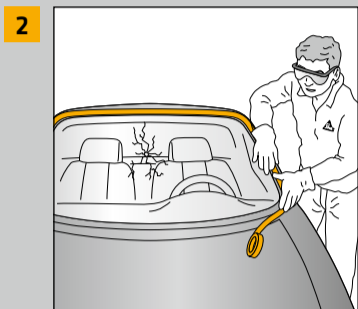
## SikaTack® ELITE AND SikaTack® PRO



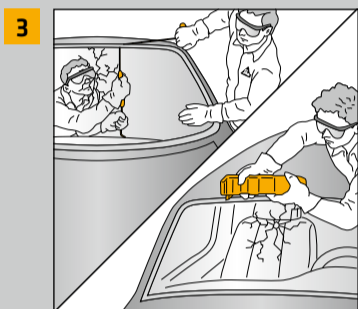
DESIGN  
AWARD  
2016



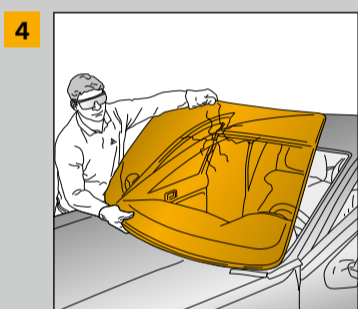
- 1 Remove all decorative trims



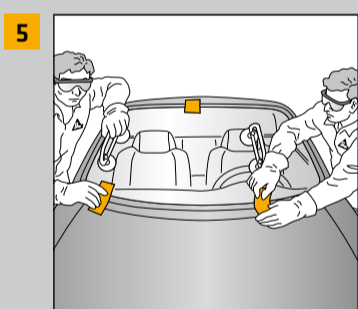
- 2 Cover the aperture with masking tape



- 3 Cut out damaged windshield using Sika SmartCut, electrical knife, cutting wire, cold knife etc.



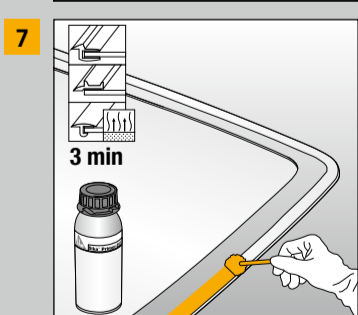
- 4 Remove damaged windshield



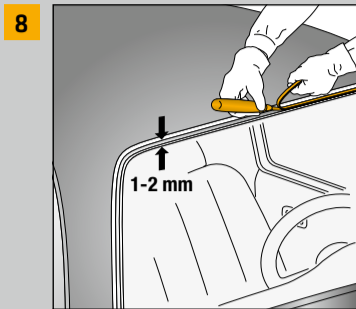
- 5 Dry fit new windshield



- 6 Clean the new windshield with Sika® Cleaner G+P



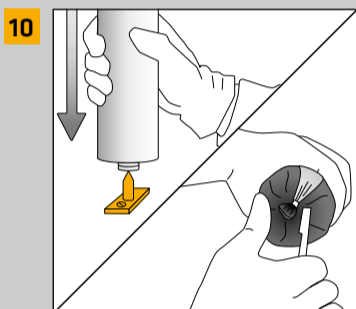
- 7 Prime the bonding surface of the glass using Sika® Primer-207



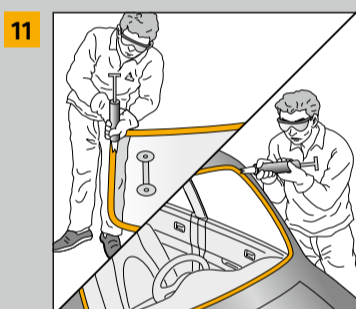
- 8 Trim back the remaining adhesive bead to 1-2 mm



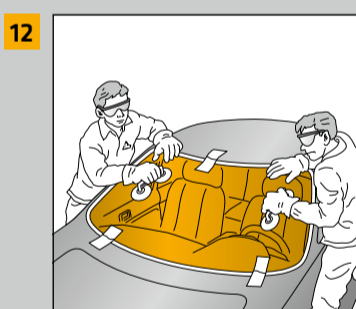
- 9 Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas, contact your body shop or refer to the car manufacturer's specification



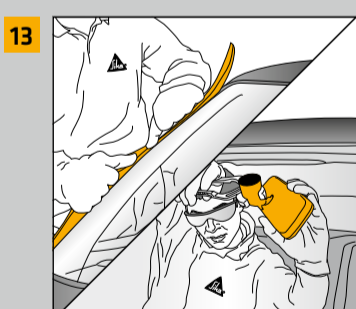
- 10 Open the cartridge or the unipack



- 11 Apply a triangular bead of adhesive either to the glass or the aperture



- 12 Place the windshield in position within the open time of the adhesive



- 13 Refit trims and mouldings



ADHESIVES	SikaTack® ELITE designed for PowerCure	SikaTack® PRO
-----------	---	---------------

Technology		
Accelerated Polyurethane	✓	
One Component Polyurethane		✓
Properties		
Cold Applied	✓	✓
SDAT	30 min	30 min
SDAT Test Standard	95 <sup>th</sup> percentile FMVSS212	95 <sup>th</sup> percentile FMVSS212
Cured to OEM Level (23°C/50% r.h.)	60 min	--
Working Time (23°C/50% r.h.)	10 min	8 min
All-in-One Modulus	✓	✓

BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass <sup>a</sup>	●
Bare Metal Scratch < 5 cm <sup>2</sup>	●
Bare Metal 5 cm <sup>2</sup> to 150 cm <sup>2</sup>	●●
Intact OEM Paint <sup>d</sup>	●
Repair Paint (after complete curing of paint) <sup>b, d</sup>	●
PVC/RIM Encapsulation <sup>b</sup>	●
Fresh Cut Bead <sup>d</sup>	Optional / ●
Pre-applied Adhesive System <sup>b</sup>	●
Polycarbonate <sup>c</sup>	●
PMMA <sup>c</sup>	●

● = Sika® Primer-207

Windshields without ceramic coatings need proper UV protection.

- a) Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® Cleaner PCA
- b) Scuff surface
- c) Coating must be removed prior to use, scuff surface
- d) Alternatively Sika® Aktivator-309 P can be used. For SikaTack® ELITE the use of Sika® Aktivator-309 P is recommended as pinchweld treatment

Our most current General Sales Conditions shall apply.  
Please consult the most current local Product Data Sheet prior to any use.

[www.sika.com/aftermarket](http://www.sika.com/aftermarket)

BUILDING TRUST

