



AUTO GLASS REPLACEMENT FOCUS ON PERFORMANCE

BUILDING TRUST



LEADING SOLUTIONS

Designed and tested for maximum efficiency

Sika is a Tier 1 supplier and development partner to the global automotive industry. Together with our customers, we help create the automobiles of tomorrow. Sika aftermarket solutions have been driving the automotive industry worldwide for more than 30 years. Our intelligent products combine state-of-the-art technology with user-oriented application properties which make it easy to get started right away.

THE LEADING BRAND FOR WINDSHIELD ADHESIVES

Based on our competencies as a leading OEM supplier we provide a comprehensive portfolio for sealing and bonding, noise damping and protective coating applications in car body repair. Innovation, performance, reliability and ease of use make Sika products the number one choice of auto glass and body shop professionals all around the world.

TRUST A POWERFUL GROUP

Sika is a Swiss-based specialty chemicals company with more than 100 years of experience. For Sika, innovation has always been the driving force in its quest to become the global leader. It all started more than 25 years ago, when we started supplying BMW with the Black-Primerless adhesive system. Over the years, we went on to develop relationships with almost all vehicle manufacturers globally.

In 2014, Sika was applying for more than 70 patents. Our products are used in 50 % of all vehicles produced. Sika is a global player, but highly focused on having people in the market who speak the local language and who know about your business; we currently cover 93 countries.

At the time of writing, more than

300 MILLION

windshields have been replaced using Sika adhesives

Over

30 MILLION

headlights, sunroofs and spoilers are bonded with Sika adhesives annually

1 OUT OF 3

windshields worldwide is replaced using Sika adhesive

Local Sika presence in over

93 countries

50 %

of vehicles produced worldwide use Sika technology

Sika technology saves

80 MILLION

liters of fuel annually (240 million kg of CO₂)

Sika supplies more than

400 MILLION

acoustic damping parts per year



CUSTOMER SAFETY IS OUR MISSION

The windshield is an integral part of a vehicle's safety system. Its role is to stay in place and keep occupants inside the vehicle in case of an accident. It not only serves as the backboard for the inflating passenger airbag; today's vehicles are also stiffened by the bonded windshield. It is vital that the windshield stays attached to the car body even in a rollover accident. If a windshield is not installed properly, it can come loose in a collision and separate from the car body flange, causing serious injuries. Reliable and easy to use adhesive systems from Sika make the difference and ensure the highest safety standards for every one of your installations.

INNOVATION IS OUR PASSION

We are focused on the three core values that have made us number one in the global markets: **INNOVATION, SIMPLICITY AND SAFETY**. Our aim is to simplify the professional application process with reliable and fast curing adhesive systems and short safe drive-away times that maximize the safety of vehicle owners and passengers.

Making visions come true

INNOVATION

Sika adhesive solutions continue to lead as best-in-class. We do more than just respond to the needs of our professional customers; we also take future requirements of the automotive industry into account. This enables us to launch powerful innovations while focusing on you and your customers' needs.

From professionals, for professionals

SIMPLICITY

Your daily work inspires our development efforts. That's why we closely collaborate with auto glass technicians and vehicle body experts in order to find intelligent solutions that meet your requirements perfectly, making Sika products easy to use, straight out of the box.

Always more than required

SAFETY

We are serious about taking no shortcuts when it comes to protecting vehicle drivers and passengers. Sika applies the highest safety standards and outperforms international requirements.

MORE THAN 60 CRASH TESTS

NO SHORTCUTS TO SAFETY

FROM TECHNICIANS, FOR TECHNICIANS

EASY HANDLING

SAVE TIME. INCREASE PRODUCTIVITY

SAFETY WITHOUT COMPROMISE

Advanced Sika SDAT Standard

Sika is the one and only adhesive manufacturer worldwide using a 95th percentile crash test dummy. Due to the use of a heavier dummy, our tests can cover a higher percentage of people worldwide. **WITH SIKA, YOU ARE ON THE HIGH ROAD TO SAFETY.**

Sika is the pioneer in Safe Drive-Away Time (SDAT): we continuously monitor market developments, simulating and modeling our solutions in order to provide the safest conditions for vehicle drivers and occupants in every situation. Meeting the requirements of national and international law is not enough for Sika. We always want to go one step further. We always test our Sika Safe Drive-Away Time under more severe conditions than the FMVSS 212 standard requires. This makes your auto glass business, and your customer's life, a bit safer than safe.

OUTPERFORMING REQUIREMENTS

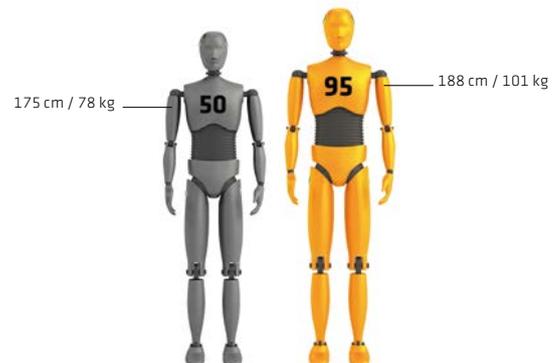
Optimizing is our business, not only with regard to our total competence but also in terms of our testing standards. The 1976 FMVSS 212 standard utilizes a 50th percentile dummy, which is designed to represent about half of the adult male population. When Sika introduced our first crash standards, the US and some other countries did not have laws requiring vehicle passengers to wear seats belt. These days use of seat belts is enforced by law.



At Sika we decided to improve our testing standard and started to utilize a taller and heavier 95th percentile dummy, covering significantly more people and therefore more of your potential customers. In addition, we started to belt our crash test dummies. The combination of the 95th percentile dummy with seat belts is as critical as our old standard but comes much closer to reality.

SIKA'S TESTING CONDITIONS

	Former Sika SDAT standard	NEW Sika SDAT standard
Dummy:	50 th percentile dummy	95 th percentile dummy
Use of seat belt:	Sika used unbelted dummies in order to cover countries without seat belt laws	Use of belted dummies, as seat belt use is now mandatory
Crash test:	In line with FMVSS 212	In line with FMVSS 212



POWERCURE



PERFORM WITH THE ULTIMATE TECHNOLOGY

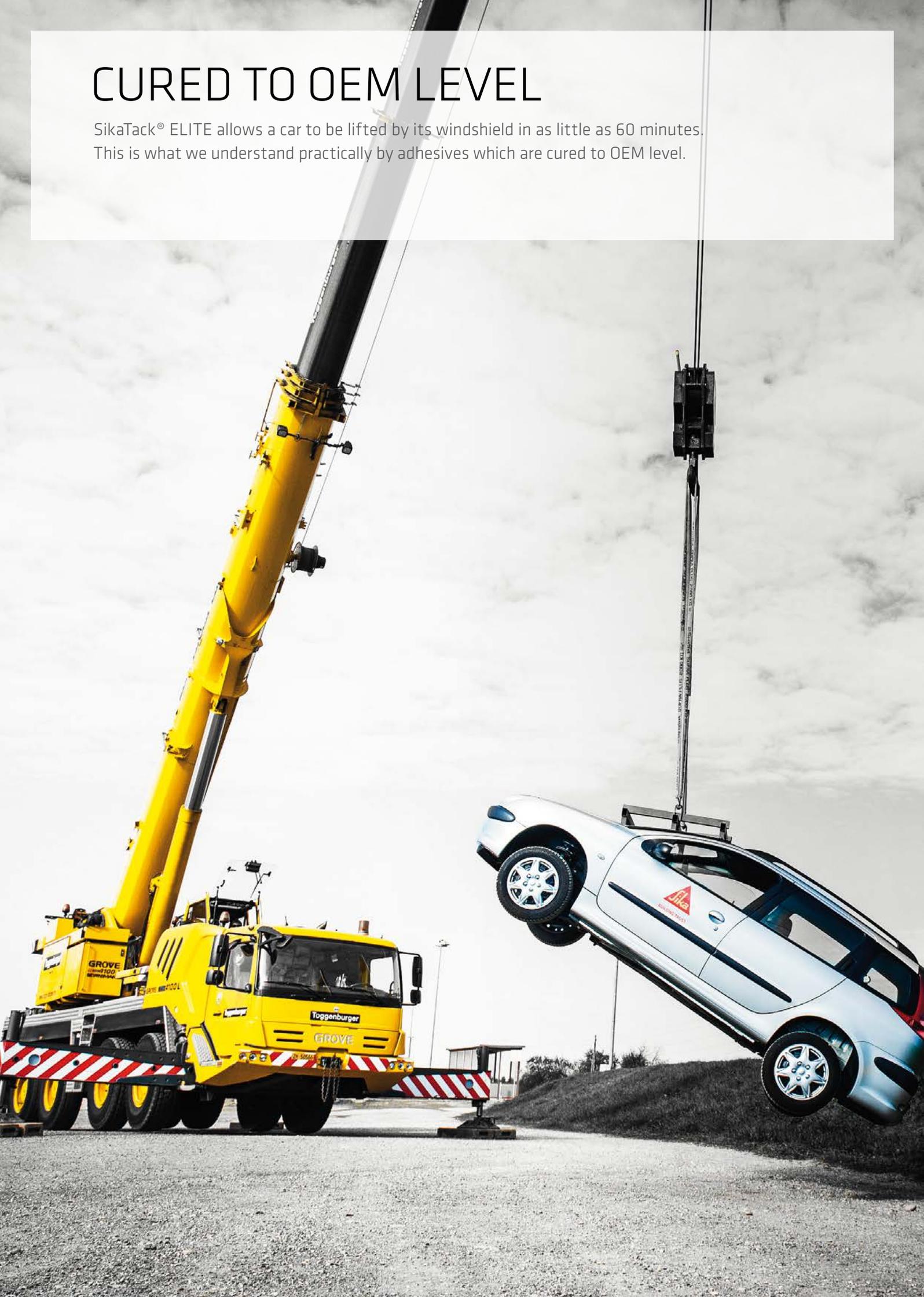
PowerCure is the latest technology for accelerated curing adhesives. For the first time here, Sika is taking a total solution approach. We believe reaching the next level of technology is only possible if the system reflects the reality an auto glass technician has to deal with every day. PowerCure has been developed together with auto glass technicians from the very beginning; it is designed for both mobile and shop environments and has proven its reliability under the harshest conditions.

PowerCure adhesives reach a new level of performance at an unmatched level of comfort. For the first time here, we have developed a total solution for vehicle glass replacement, and this has allowed us to question each little step, from mounting a unipack to the actual extrusion of the adhesive. The PowerCure system is probably the first ever to be developed together with auto glass professionals from the very beginning.

- Simple as a one-component
- Minimized waste, maximized yield of adhesive
- Ergonomic design
- Fastest unit replacement on the market
- Long working time but quick curing

CURED TO OEM LEVEL

SikaTack® ELITE allows a car to be lifted by its windshield in as little as 60 minutes. This is what we understand practically by adhesives which are cured to OEM level.



PERFORMANCE BEYOND SDAT

Having just a short Safe Drive-Away Time (SDAT) is not the definition of a safe system! Vehicle manufacturers apply stricter standards for releasing a vehicle back into operation than the average auto glass shop. Up until now, no system has been able to reach car manufacturers' (OEM) performance requirements quickly enough and easily enough to be used by independent auto glass companies.

PowerCure ADHESIVES ARE DIFFERENT!



CURED TO OEM LEVEL

PowerCure adhesives cure independently of the climate from the inside of the bead. They cure within minutes to the strength level specified by vehicle manufacturers. PowerCure adhesives reinforce the car's body structure to the original level within just 60 minutes, whereas one-component products can require up to several weeks depending on the climate. Rapid deployment of structural integrity is one of the key reasons why some vehicle manufacturers require their service centers to use accelerated or two-component adhesives. There are further benefits to using PowerCure adhesives too:

- comebacks can be repaired quickly without risk of soiling car interiors
- sensors can be calibrated quickly and without any concerns
- insurance and subcontracted work will meet all OEM standards

and you could even lift a vehicle by the windshield just 60 minutes after installation.

ADHESIVE FOR VEHICLE GLASS REPLACEMENT

Product	SikaTack® ELITE designed for PowerCure
Technology	Accelerated polyurethane adhesive
Safe Drive-Away Time (SDAT)	30 min
SDAT temperature conditions	-10°C to 40°C
Cured to OEM level	60 min
Open time (23°C/50 % r.h.)	10 min
Application temperature	Cold-applied
All-in-one modulus	✓



THE HIGHEST PRECISION IN YOUR HANDS

The PowerCure adhesive system delivers the precision and performance of high-end pump systems found at vehicle manufacturer's production lines. It combines high flexibility, ergonomic and easy handling, and minimizes waste in a clear and focused design. The use of a single, brushless motor mechanically couples extrusion, dosing and dynamic mixing, and allows controlling of extrusion speed on the go without compromise. Providing the fastest curing adhesives at unmatched comfort level, PowerCure is the total solution for smaller sealing and bonding applications.



PACKAGING



Based on the unipack: PowerCure packaging is based on the unipack, the most efficient packaging solution for windshield adhesives. The packaging is designed to minimize wastage and to allow very simple mounting and replacement.

MIXER



Dynamic & efficient: The mixer is designed to fit an ordinary application nozzle. The specially shaped v-cut supports the application of the adhesive at a convenient angle to the glass and cuts material consumption by up to 8 %.



«FROM THE VERY BEGINNING WE ANALYZED WORKING AND HANDLING PROCEDURES OF APPLICATORS IN THE FIELD. EVERY LITTLE STEP WAS QUESTIONED AND CONSTANTLY CHALLENGED. WE AIMED TO MAKE USING PowerCure AS SIMPLE AS USING A SINGLE COMPONENT PRODUCT. IN MANY ASPECTS IT'S EVEN SIMPLER AND FASTER.»

David Tobler, Head Automotive Aftermarket



PowerCure DISPENSER

Single motor design: The PowerCure Dispenser matches the precision of pump and dosing systems found on vehicle manufacturers' production lines. The use of a single, brush-less motor mechanically couples extrusion, dosing and dynamic mixing. This allows users to control extrusion speed on the go without compromise.



sika.com

AUTO GLASS PRODUCT RANGE

From Sika cleaning products to premium adhesives, we ensure an efficient process right from the beginning. Auto glass professionals benefit from an excellent workflow with well-matched products.

ADHESIVES	SikaTack® ELITE Designed for PowerCure	SikaTack® PRO	SikaTack® DRIVE
Technology			
Accelerated polyurethane	✓		
One-component polyurethane		✓	✓
Pre-treatment process			
Black Primerless		✓	✓
All Black	✓	✓	✓
Properties			
Cold-applied	✓	✓	✓
SDAT	30 min	30 min	60 min
SDAT test standard	95 th percentile FMVSS 212	95 th percentile FMVSS 212	95 th percentile FMVSS 212
Cured to OEM level	60 min	--	--
Working time	10 min	8 min	12 min
All-in-one modulus	✓	✓	✓

PRE-TREATMENT PROCEDURES	Black-Primerless process	All-Black process
Float glass and ceramic coated glass	●	●
Bare metal scratches < 5 cm ²	● ●	●
Bare metal scratches 5 cm ² to 150 cm ²	● ● ●	● ●
Intact OEM and aftermarket paint*	● ●	●
PVC and RIM encapsulation	● ●	●
Trimmed residual bead	●	optional/ ●
Pre-applied adhesive system	●	optional/ ●
PMMA/PC**	● ●	●

- Sika® Aktivator PRO
- Sika® Primer-207

*after complete curing of the paint

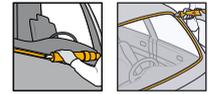
**additional UV protection required

For details check installation process charts (available separately)

AUTO GLASS ADHESIVES

SikaTack® ELITE

High-speed Performance in Every Climate



SikaTack® ELITE is an advanced windshield adhesive, specifically developed and engineered for our innovative PowerCure system technology. The quick curing of SikaTack® ELITE enables you to meet OEM requirements in less than 60 minutes! The

Safe Drive-Away Time is already reached just 30 minutes after installation. Boost your business with a potentially record-breaking performance.



THATCHAM APPROVAL
SikaTack® ELITE is a Thatcham-approved repair product.

YOUR BENEFITS

- True 30 min Safe Drive-Away Time, tested under the new 95th percentile FMVSS 212 standard
- Cures to OEM level within 60 min
- Meets all OEM requirements, including Volvo, VW, Audi, etc.
- Fast curing
- Curing independent of climate conditions
- Very short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus

SikaTack® ELITE requires the PowerCure Dispenser as well as the PowerCure Mixer Nozzle. For pre-treatment, SikaTack® ELITE requires the Sika All-Black bonding process.

AVAILABLE ITEMS

- Box with 14 × 600 ml PowerCure Pack Item No. 496374

PowerCure System

The PowerCure adhesive system delivers the precision and performance of high-end pump systems found in vehicle manufacturers' production lines. It combines high levels of flexibility, and ergonomic and easy handling, and minimizes waste in a clear and focused design.



Further Information and Video Tutorials

SikaTack® PRO

Premium Choice for Auto Glass Professionals



Our innovative windshield adhesive has been tested under the most severe conditions. With our all-in-one technology, SikaTack® PRO is a perfect fit for all car makes and models, and delivers high value for money.

YOUR BENEFITS

- True 30 min Safe Drive-Away Time, tested under the new 95th percentile FMVSS 212 standard
- Safe Drive-Away Time valid for all climates, ranging from -10 to 35°C
- Very short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

- | | |
|---|-----------------|
| ■ Box with 12 × 300 ml cartridge, black | Item No. 496038 |
| ■ Box with 12 × 400 ml unipack, black | Item No. 496039 |
| ■ Box with 20 × 600 ml unipack, black | Item No. 496037 |

SikaTack® DRIVE

The Application Champion



SikaTack® DRIVE is a windshield adhesive with superior application properties: it is the application champion on the market. SikaTack® DRIVE offers a true 60 min Safe Drive-Away Time for climates ranging from 5°C to 35°C. With Sika's all-in-one modulus technology, it is a great choice for all car makes and models.

YOUR BENEFITS

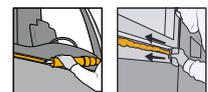
- True 60 min Safe Drive-Away Time
- Short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus technology
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

- | | |
|---|-----------------|
| ■ Box with 12 × 300 ml cartridge, black | Item No. 401648 |
| ■ Box with 12 × 400 ml unipack, black | Item No. 97234 |
| ■ Box with 20 × 600 ml unipack, black | Item No. 97233 |

SikaTack® MOVE Transportation

All-in-one Solution for Bus and Coach Glass Replacement



SikaTack® MOVE Transportation is a windshield adhesive with excellent weathering stability. It is ideally suited for the replacement of bus and coach glass where it can be used for bonding as well as sealing application. SikaTack®

MOVE Transportation offers a 2-hour Safe Drive-Away Time for supported windshields.

YOUR BENEFITS

- 2-hour Safe Drive-Away Time for supported bus and coach glass*
- Excellent weathering stability; useful for exterior joint sealing
- Compatible with Sika's Black-Primerless and All-Black bonding process

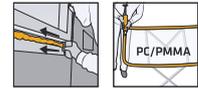
AVAILABLE ITEMS

- | | |
|---------------------------------------|----------------|
| ■ Box with 20 × 600 ml unipack, black | Item No. 89696 |
|---------------------------------------|----------------|

*special advice on Safe Drive-Away Time for heavy bus and coach glass is available upon request.

Sikaflex®-223

Weathering-resistant Joint Sealant



for open joints. In the automotive aftermarket, it can be used for the bonding of plastic windshields when the bond line is protected from UV light.

Sikaflex®-223 is a multi-purpose joint sealant with excellent adhesion on aluminum, GRP, stainless steel, 2-c coatings and organic glass (polycarbonate and PMMA). Due to its excellent weathering resistance, it is well suited

YOUR BENEFITS

- Excellent weathering stability; useful for sealing exterior joints
- Repair solution for plastic windshields (bond line needs UV protection)*
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

- | | |
|---|-----------------|
| ■ Box with 12 × 300 ml cartridge, black | Item No. 525949 |
| ■ Box with 20 × 600 ml unipack, black | Item No. 514643 |
| ■ Box with 12 × 300 ml cartridge, white | Item No. 525948 |
| ■ Box with 20 × 600 ml unipack, white | Item No. 514644 |

* protection of bond line by a black frit or external protection, e.g. with Sika® UV Shielding Tape.

SikaFast®-1640

Rear Mirror Bonding Kit



SikaFast®-1640 is designed for bonding rear mirror brackets to vehicle windshields. It is suitable for bonding glass, ceramics and metals as well as a combination of these materials. The rear mirror can be installed just minutes after the bracket has been bonded.

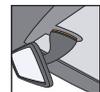
YOUR BENEFITS

- Ideal for bonding rear mirror brackets to windshields
- Very fast curing to handling strength
- Easy to use
- 100 % reactive substance, no solvents

AVAILABLE ITEMS

- | | |
|--|-----------------|
| ■ Box with 25 × 50 g + 10 ml kit, light yellow | Item No. 517865 |
|--|-----------------|

SikaFast®-5211NT



SikaFast®-5211 NT is a fast curing, flexible structural adhesive designed to replace mechanical fixings such as rivets, screws or welding. It is suitable for high strength fastening of concealed joints and exhibits excellent adhesion on different types of substrates including top coats, plastics, glass, wood, etc. Suitable for bonding of complex rear mirror brackets.

YOUR BENEFITS

- Adhesion to a wide range of substrates
- Low odor
- Fast strength development

AVAILABLE ITEMS

- | | |
|-------------------------------------|-----------------|
| ■ Box with 12 × 10 ml syringe, grey | Item No. 466659 |
| ■ Box with 12 × 250 ml, grey | Item No. 413411 |

AUTO GLASS CLEANING AND PRE-TREATMENT

Sika® Cleaner PCA

Contamination Remover



A smart cleaning foam usually used in combination with Sika® Cleaner G+P, designed specifically for removing contamination that cannot be sufficiently removed with standard cleaners or without scratching the surface. See the effect before the treatment is even finished!

We recommend using Sika® Cleaner PCA as part of the windshield pre-treatment process. It can be used in combination with the Black-Primerless and All-Black bonding process.

YOUR BENEFITS

- Easy to use
- Highly reliable
- Multipurpose product
- Removes many kinds of contamination such as green snake contamination, fingerprints, tape residues, etc.
- Can be used for primer application

AVAILABLE ITEMS

- | | |
|---------------------------------|-----------------|
| ■ Box with 168 pads, light grey | Item No. 492763 |
| ■ Box with 48 pads, light grey | Item No. 529100 |

Sika® Cleaner G+P

High-quality Glass and Plastic Cleaner



This alcohol-based solution for cleaning glass and non-porous surfaces is used to clean windshields and remove finger marks and residues. It leaves no residue on the surface, thus ensuring easy use and there is no need to re-polish the windshield.

YOUR BENEFITS

- Streak-free drying
- Quick drying
- Non-freezing winter version available

AVAILABLE ITEMS

- | | |
|--|-----------------|
| ■ Box with 12 × 500 ml trigger spray, light blue | Item No. 527420 |
| ■ Box with 251 bottle, light blue | Item No. 527421 |
| ■ Box with 4 × 5 l concentrate 1:4, light blue | Item No. 527422 |

Sika® Aktivator PRO

The all-season Glass Activator for Black-Primerless Bonding



This unique pre-treatment agent is specially designed to provide adhesion on automotive glass replacement substrates. Thanks to the single wipe application, Sika® Aktivator PRO simplifies the work activities, increases performance and boosts quality.

YOUR BENEFITS

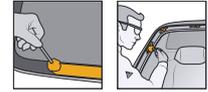
- Single wipe application
- 3 min flash-off time
- All-season technology

AVAILABLE ITEMS

- | | |
|---------------------------------------|-----------------|
| ■ Box with 24 × 30 ml can, colorless | Item No. 161886 |
| ■ Box with 8 × 100 ml can, colorless | Item No. 161887 |
| ■ Box with 6 × 250 ml can, colorless | Item No. 154884 |
| ■ Box with 4 × 1000 ml can, colorless | Item No. 154885 |

Sika® Primer-207

The All-Black Pre-treatment Solution for Auto Glass Replacement



This multipurpose glass and paint primer is specially designed for auto glass replacement. Sika® Primer-207 offers excellent adhesion performance as a one-step primer for float glass and ceramic-coated glass as well

as OEM and aftermarket paints, PVC, PMMA, ABS and a number of other plastic materials. It is also useful as a corrosion protection primer for the AGR business.

Sika® Primer-207 is used as part of the Black-Primerless and All-Black bonding process for auto glass replacement.

YOUR BENEFITS

- Quick drying: only takes 3 min, all year round
- One product: simplifies work procedures and inventories
- One solution for all typical AGR substrates

AVAILABLE ITEMS

- | | | |
|----------------------------------|----------|--------|
| ■ Box with 24 × 30 ml can, black | Item No. | 417300 |
| ■ Box with 8 × 100 ml can, black | Item No. | 417301 |
| ■ Box with 6 × 250 ml can, black | Item No. | 417302 |

Sika® Remover-208

Cleaning Agent for Surface Preparation and Removal of Uncured Adhesives



Sika® Remover-208 is used to remove uncured traces of Sikaflex® and SikaTack® products from tools and equipment. It is also suitable as a cleaner for non-porous and painted substrates prior to bonding.

AVAILABLE ITEMS

- | | | |
|---|----------|--------|
| ■ Box with 4 × 1000 ml can, colorless | Item No. | 34288 |
| ■ Box with 12 × 400 ml aerosol, colorless | Item No. | 135750 |

AUTO GLASS ACCESSORIES

From intelligent repair sets to easy-to-use applicator guns, our versatile accessories help you complete your Sika toolkit and increase the productivity of your working processes.

Sika® Gun HD



The Sika® Gun HD is a heavy duty, lightweight manual caulking gun for cartridges with a high gear ratio for easy, one-handed application. It is ideal for the manual application of Sika windshield adhesives.

YOUR BENEFITS

- High gear ratio for easy, one-handed use
- Durable lightweight design (600 g)

AVAILABLE ITEMS

- Box with Sika® Gun HD Item No. 452901

Sika® Application Gun



The Sika® Application Gun is the ideal dispenser for one-component windshield adhesives. It is based on the Milwaukee C18PCG but comes with a clear barrel and improved extrusion plunger, increasing the adhesive yield of unipacks.

Box contents: Sika® Application Gun, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

- Box with 220V EU/UK CTR300 version Item No. 425589
- Box with 220V EU/UK UP600 version Item No. 425591

PowerCure Dispenser



The PowerCure Dispenser is required to extrude PowerCure adhesives such as SikaTack® ELITE.

Box contents: Sika PowerCure Dispenser, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

- Box with 220V EU/CH 2Ah Item No. 483561
- Box with 220V EU/UK 2Ah Item No. 489272

Sika® Nozzle Cut



Specially designed for fast and easy V-shape cutting of adhesive cartridge nozzles.

AVAILABLE ITEMS

- Box with Sika® Nozzle Cut

Item No. 92729

Sika® Cleaner-350 H

Hand Wipes



For the easy removal of fresh, uncured polyurethane or primer from your hands. Gentle cleansing for your skin and other surfaces.

AVAILABLE ITEMS

- Box with 6 x 70 pc bucket

Item No. 523490

PowerCure Mixer Nozzles



PowerCure adhesives such as SikaTack® ELITE require the use of PowerCure mixing nozzles.

AVAILABLE ITEMS

- Box with 50 units V-cut mixers
- Box with 40 units round mixer nozzles

Item No. 483560

Item No. 496783

PowerCure Spare Parts



Spare parts for the PowerCure Dispenser are available to order online at: www.sika.com/powercure.

There is a range of spare parts available for small repairs on-site as well as the corresponding instructions.

AVAILABLE ITEMS

- Box with Li-Ion battery 18V 2Ah
- Box with spare cover, grey
- Box with hand pad, black
- Box with mixer cap, red
- Box with tooth rack cover, red

Item No. 494106

Item No. 494111

Item No. 494112

Item No. 494109

Item No. 494118



OUTSTANDING SERVICE THANKS TO PowerCure

“On the commercial vehicle segment, the PowerCure solution from Sika allowed the introduction of a new, faster service level and to react more flexibly on customer appointments.”

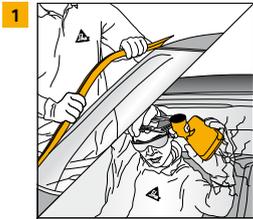
Nils Villwock – junited®AUTOGLAS Scheessel – Verden
www.autoglas-villwock.de

POWERCURE

TIPS AND TRICKS



BLACK-PRIMERLESS PROCESS AUTO GLASS REPLACEMENT



- Remove all decorative trims



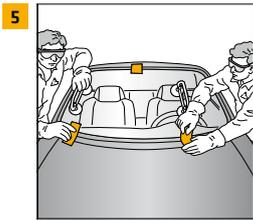
- Cover the aperture with masking tape



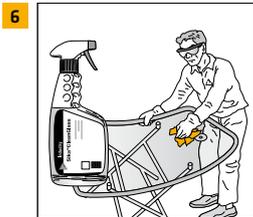
- Cut out damaged windshield using an electrical knife, cutting wire, cold knife etc.



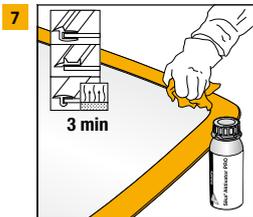
- Remove damaged windshield



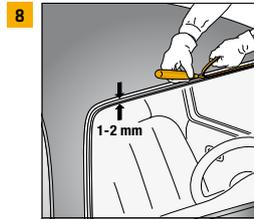
- Dry fit new windshield



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



- Activate the bonding surface of the glass using Sika® Aktivator PRO



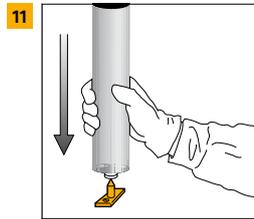
- Trim back the remaining adhesive bead to 1-2 mm



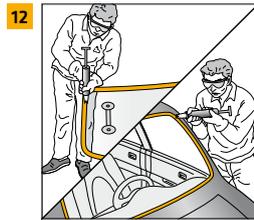
- Clean the aperture using Sika® Cleaner G+P and activate the remaining bead with Sika® Aktivator PRO



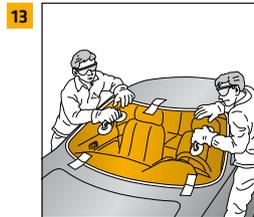
- Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification



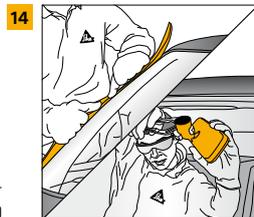
- Open the cartridge or the unipack



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



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



- Refit trims and mouldings



BONDING SURFACE

Float Glass and Ceramic coated Glass*
Bare Metal Scratch < 5 cm²
Bare Metal 5 cm² to 150 cm²
Intact OEM Paint
Repair Paint (after complete curing of paint)
PVC/RIM Encapsulation
Fresh Cut Bead
Pre-applied adhesive system
Polycarbonate**
PMMA**

● = Sika® Primer-207 ● = Sika® Aktivator PRO

BLACK PRIMERLESS PROCESS

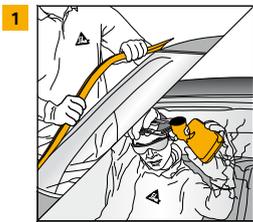
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5 cm ²	● ●
Bare Metal 5 cm ² to 150 cm ²	● ● ●
Intact OEM Paint	● ●
Repair Paint (after complete curing of paint)	● ●
PVC/RIM Encapsulation	● ●
Fresh Cut Bead	●
Pre-applied adhesive system	●
Polycarbonate**	● ●
PMMA**	● ●

* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

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

ALL BLACK PROCESS AUTO GLASS REPLACEMENT



- Remove all decorative trims



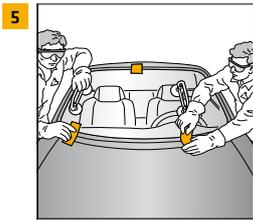
- Cover the aperture with masking tape



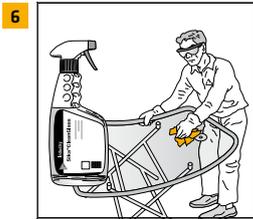
- Cut out damaged windshield using an electrical knife, cutting wire, cold knife etc.



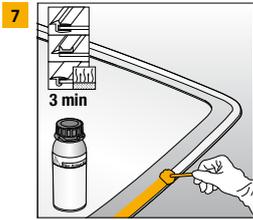
- Remove damaged windshield



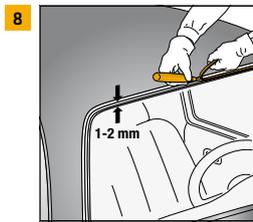
- Dry fit new windshield



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



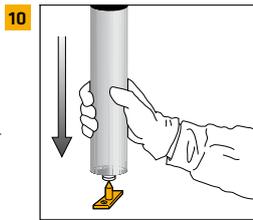
- Prime the bonding surface of the glass using Sika® Primer-207



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



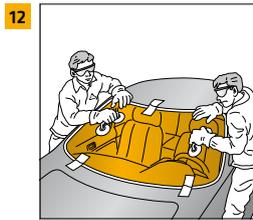
- Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification



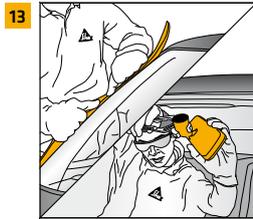
- Open the cartridge or the unipack



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



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



- Refit trims and mouldings



BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5 cm ²	●
Bare Metal 5 cm ² to 150 cm ²	●●
Intact OEM Paint	●
Repair Paint (after complete curing of paint)	●
PVC/RIM Encapsulation	●
Fresh Cut Bead	Optional / ●
Pre-applied adhesive system	Optional / ●
Polycarbonate**	●
PMMA**	●

● = Sika® Primer-207

* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

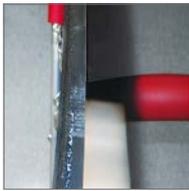
** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

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

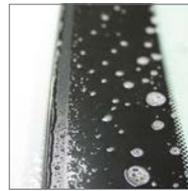
CONTAMINATION REMOVAL

In general, Sika® Cleaner G+P is ideal for removing traditional forms of surface contamination such as dirt, dust and skin oils that are commonly found on auto glass parts. However, it has been Sika's experience that many parts contain so-called non-

traditional contaminants that require additional treatment. The nature and quantity of such non-traditional contaminants can vary significantly. Generally, the source of this contamination is the manufacturing process itself.



- Mould release agents associated with encapsulated parts (where trim is bonded to the part)

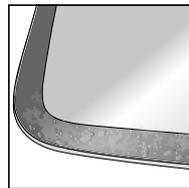


- Silicone residue from a vacuum tube laminating process which is used for the lamination process of laminated safety glass

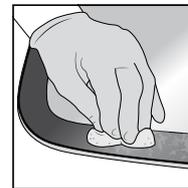
Recommended Procedure



- 1st step:**
Wet glass



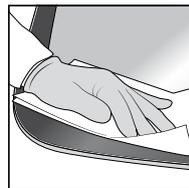
- 2nd step:**
Check contamination



- 3rd step:**
Use fresh unit Sika® Cleaner PCA. Start cleaning ceramic frit



- 4th step:**
Immediate detection of removal effect visible



- 5th step:**
Dry with paper towel

BONDING PLASTIC WINDSHIELDS (PMMA AND PC)

Plastic windshields can be found on vehicles such as:

- Construction machines
- Special purpose vehicles (police, army, etc.)
- Lightweight construction vehicles
- Roof modules on some vehicles

Typical materials used are PMMA (polymethacrylate) and PC (polycarbonate). In the manufacturing process, many poly-

carbonate sheets are coated with a scratch-resistant surface. Unlike standard float glass, plastic windshields have a much higher thermal expansion coefficient, resulting in greater movement (expansion and contraction of the window). In addition, plastic windshields do not have ceramic coating on the glass, nor any other integrated UV protection for the bond line. For these reasons, the following procedures must be followed when bonding plastic windshields.

Permanent glazing

If the coating is unknown, it is recommended to test the surface before bonding (contact Sika for support); otherwise, use the following procedure:

Step 1	Abrade the bonding area with an abrasive pad (e.g. from Sika Abrasives) or sand paper	Remove scratch-resistant coating on the bonding area
Step 2	Remove dust and clean surface with Sika® Cleaner G+P	Clean surface from dust
Step 3	Apply Sika® Primer-207, flash off for 10 minutes	Create suitable surface for bonding
Step 4	Apply Sikaflex®-223. Layer thickness as per table below	Bonding

Adhesive Thickness

LARGEST WINDSHIELD LENGTH	TRIANGULAR BEAD REQUIRED		ADHESIVE BEAD DIMENSION*	
				
L (m)	H (mm)	B (mm)	D (mm)	B (mm)
0.5	8	6	4	6
1.0	8	8	4	8
1.5	12	10	6	10
2.0	16	12	8	12
Over 2.0 Meter			contact Sika	

* important: confirm to minimal adhesives thickness, D.

UV protection

To ensure a durable bond, the bond line of transparent windshields must be protected against UV light. Possible solutions are:

- Suitable print color
- Protective metal or opaque plastic trims
- Sika® UV Shielding Tape

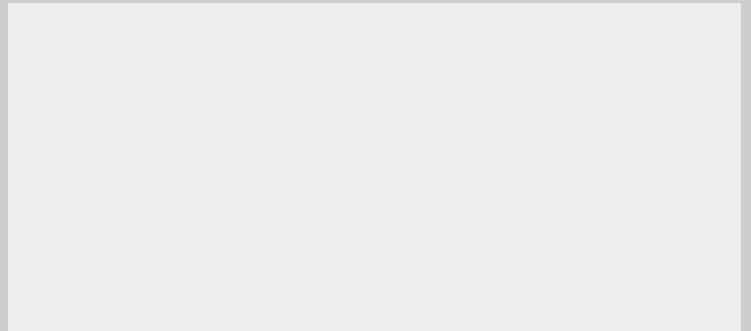
Without UV protection, Sika® Primer-207 will eventually wear off on the plastic windshield. The exact point at which this will result in a failure depends largely on the weather, the quality of the synthetic material and the general load.

GLOBAL BUT LOCAL PARTNERSHIP



WHO WE ARE

Sika AG, Switzerland, is a globally active specialty chemicals company. Sika supplies the building and construction industry as well as manufacturing industries (automotive, bus, truck, rail, solar and wind power plants, facades). Sika is a leader in processing materials used in sealing, bonding, damping, reinforcing and protecting loadbearing structures. Sika's product lines feature high quality concrete admixtures, specialty mortars, sealants and adhesives, damping and reinforcing materials, structural strengthening systems, industrial flooring as well as roofing and waterproofing systems.



FOR MORE INFORMATION

www.sika.com/aftermarket
www.sika.com/powercure

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



SIKA SERVICES AG
Tueffenwies 16
CH-8048 Zurich
Switzerland

CONTACT
Phone: +41 58 436 40 40
Fax: +41 58 436 55 30
www.sika.com

BUILDING TRUST

