

PRODUCT DATA SHEET

SikaFast®-1640

No-mix acrylate rear mirror adhesive kit

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaFast®-1640 Gel	SikaFast®-1640 Activator
Chemical base	Modified urethane-acrylate	Monomeric methacrylate
Colour (CQP001-1)	Light yellow	Light green
	Color mixed	Light yellow
Cure mechanism	Polymerization	
Density	1.08 kg/l	1.08 kg/l
Consistency	Thixotropic gel	Liquid
Application temperature	5 – 35 °C	
Handling time	20 seconds ^A	
Curing time	80 % of final strength 12 hours ^A	
Shore D hardness (CQP023-1 / ISO 48-4)	65 – 70	
Tensile lap-shear strength (CQP046-6 / ISO 4587)	18 MPa	
Service temperature (CQP513-1)	-55 – 120 °C	
Shelf life (CQP016-1)	12 months ^B	

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.^{B)} Stored at temperature below 25 °C and not exposed to direct sun light**DESCRIPTION**

SikaFast®-1640 is a toughened and impact resistant no-mix acrylate based on 2-components. It is suitable to bond glass, ceramic, metal and a combination of these materials.

SikaFast®-1640 Gel must be used in combination with SikaFast®-1640 Activator.

PRODUCT BENEFITS

- Ideal to bond rear mirror brackets to wind-screens
- 100 % reactive substance, no solvents
- Very fast curing to handling strength

AREAS OF APPLICATION

SikaFast®-1640 is ideally suited to bond rear mirror brackets to vehicle windscreens. It is suitable to bond glass, ceramics and metals as well as combinations of these materials. It may also be used for magnetic materials (ferrites).

This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

SikaFast®-1640 is a no-mix acrylate system that cures by radical chain polymerization when SikaFast®-1640 Gel and SikaFast®-1640 Activator are brought into contact.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct a project related testing.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly, for example with an IPA wipe.

Due to the diversity of materials, preliminary tests with original substrates are necessary.

Application

Mark the area where the adhesive has to be applied for correct alignment. Apply plenty of the SikaFast®-1640 Activator with the brush which is part of the closure of the bottle to one of the bonding surfaces. On glass to metal applications, the SikaFast®-1640 Activator is applied on the glass side.

The SikaFast®-1640 Activator is free of solvents and must be liquid when joining the two parts. It therefore must not dry off.

Apply a thin layer of the SikaFast®-1640 Gel onto the other substrate.

Join the part with the activated glass surface and hold with light pressure for about 20 seconds. Excess adhesive must be removed immediately (latest within 40 seconds from joining) with a clean cloth.

The adhesive reaches about 50 % of the final strength after 15 to 20 minutes.

Optimum temperature for the bonding process is between 15 °C and 25 °C. The influence of the reactivity by temperature changes has to be respected.

Avoid bonding on glass surfaces that were exposed to direct sun light (hot surface). Due to the limited gap filling capability of SikaFast®-1640 the bond faces must have compatible contours. The bonded area must not exceed 10 cm², due to higher risk of stress-cracking.

Removal

Uncured excess of SikaFast®-1640 can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it can only be removed mechanically.

Hands and exposed skin shall be washed immediately using Sika® Cleaner-350H towels 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

PACKAGING INFORMATION

SikaFast®-1640 Gel

Squeeze Bottle	50 g
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SikaFast®-1640 Activator

Bottle	10 ml
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BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet 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 Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and end use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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SIKA IRELAND LIMITED

Ballymun Industrial Estate
Ballymun
Dublin 11, Ireland
Tel: +353 1 862 0709
Web: www.sika.ie
Twitter: @SikaIreland

