

SikaTack[®] MACH 60

Auto Glass Replacement Adhesive

Typical Product Data

Chemical base	1-C polyurethane
Color (CQP ³ 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	10 lb/gal
Non-sag properties	Very Good
Application temperature	product surface air 50° - 120°F (10° - 49°C) 0° - 170°F (-18° - 77°C) 0° - 120°F (-18° - 49°C)
Skin time ¹⁾ (CQP 019-1)	12 minutes
Open time ^{1) 2)} (CQP 526-1)	8 minutes
Shore A-hardness (CQP 023-1 / ISO 868)	65
Tensile strength (CQP 036-1 / ISO 37)	1000 psi
Elongation at break (CQP 036-1 / ISO 37)	300%
Tensile lap-shear strength (CQP 046-1)	650 psi
Safe Drive-Away Time (cars)	according to FMVSS 212 / 208 see chart 1
Shelf life (storage below 77°F (25°C)) (CQP 016-1)	9 months

¹⁾ 73°F (23°C) / 50% r.h.

²⁾ Open time corresponds to working time

³⁾ CQP – Sika Corporate Quality Procedure

Description

SikaTack[®] MACH 60 is a one component cold-applied, fast-curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Engineered to perform to the strength of OEM requirements, SikaTack[®] MACH 60 exceeds all federal requirements for FMVSS 212 / 208.

SikaTack[®] MACH 60 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- 1 hour Safe Drive Away Time. When used in accordance with Sika's Instructions.
- Non-conductive
- "All-In-One" Modulus
- Black primerless to glass
- Can be used from 0°F - 120°F

Areas of Application

SikaTack[®] MACH 60 is designed for use in replacing polyurethane direct-glazed automotive glass parts.

This product is suitable for experienced professional users only. If product is used for applications other than auto glass replacement tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available at <http://usa.sika.com/> or on request at tsmh@us.sika.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

Cure Mechanism

SikaTack[®] MACH 60 cures by reaction with atmospheric moisture.

Safe Drive Away Time

Rel. Hum.	Temperature (°F)					
	>0	>32	>50	>65	>80	>90- <120
>90%	1	1	1	1	1	1
>70%	1	1	1	1	1	1
>40%	1	1	1	1	1	1
>20%	1	1	1	1	1	1
>0%	1	1	1	1	1	1

Chart 1: Safe Drive Away Table for SikaTack[®] MACH 60

Method of Application

Surface Preparation

Surfaces must be clean, sound, dry and free from all traces of dust and grease. All corrosion must be removed and all bare metal scrapes and scratches must be prepared in accordance with Sika's Corrosion Treatment recommendations. Prepare bond area of glass with Sika[®] Aktivator PRO. **THIS PRODUCT MUST BE USED WITH SIKA[®] AKTIVATOR PRO TO LIMIT DISPLACEMENT OF GLASS IN THE EVENT OF A CRASH. IF NOT USED AS DIRECTED, PRODUCT MAY NOT PERFORM AS INTENDED AND PERSONAL INJURY OR DAMAGE MAY RESULT FROM FAILURE OF PRODUCT TO PROPERLY ADHERE TO GLASS.** For preparation of all bonding surfaces it is required to read and understand the instructions given in the Sika AGR Technician Training Manual additional information can be obtained at www.sikausa.com or by contacting Technical Service Department of Sika Corporation via e-mail at tsmh@us.sika.com.

Application

Product performs best when stored between 50 - 77°F. Shelf life could be reduced if stored above 77°F. Puncture seal, attach appropriately cut nozzle (e.g. "V" notch) and apply adhesive. For complete instructions, refer to the Sika AGR Technician Training Manual. (See Figure 1)

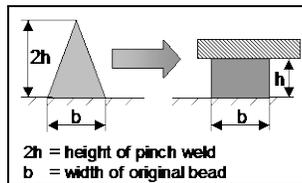


Figure 1: Recommended Bead Configuration

Removal

Uncured SikaTack[®] MACH 60 can be removed from tools and equipment with mineral spirits or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Strictly follow solvent manufacturer's instructions for use and warnings. Do not use solvents on skin!

Limitations

THIS PRODUCT IS FOR USE ONLY BY TRAINED APPLICATORS.

- Do not use this product without review of all Sika installation guidelines, Product Data Sheet and Safety Data Sheet.
- Once opened, cartridges should be used the same day or protected for later use or the contents will harden and be rendered useless.
- Avoid contact with alcohol, and alcohol-containing solvents during cure.
- Never apply directly over clear coat paint.
- Always use in conjunction with Sika[®] Aktivator PRO.
- Do not apply to rusty surfaces.

Further Information

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety related data. Read the current actual Safety Data Sheet before using the product. In case of emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Copies of the following publications are available on our website www.sikausa.com:

- Safety Data Sheets
- AGR Technician Training Manual

**-KEEP OUT OF REACH OF CHILDREN
-NOT FOR INTERNAL CONSUMPTION
-FOR INDUSTRIAL USE ONLY
-KEEP CONTAINER TIGHTLY CLOSED
-FOR PROFESSIONAL USE ONLY**

Packaging Information

Cartridge	300 ml
Unipack	465 ml

Basis of Product Data

All technical data stated in this Product Data Sheet are based on laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

Legal Notes

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available at <http://usa.sika.com/> or on request at tsmh@us.sika.com. Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.



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