

SikaTitan-258

Primerless windscreen adhesive

Technical product data

Chemical base		1-C polyurethane
Color	(CQP ¹ 001-1)	Black
Cure mechanism		Moisture-curing
Density (uncured)	(CQP 006-4)	1.1 kg / l approx.
Non-sag properties	(CQP 061-1)	Good
Application temperature		5°C ~ 40°C (40°F ~105°F)
Skin time ²	(CQP 019-1)	40 min. approx.
Open time ²	(CQP 526-1)	30 min. approx.
Curing speed	(CQP 049-1)	(see diagram 1)
Shore A hardness	(CQP 023-1 / ISO 868)	51 approx.
Tensile strength	(CQP 036-1 / ISO 37)	5 N/mm ² approx.
Elongation at break	(CQP 036-1 / ISO 37)	650% approx.
Tensile lap-shear strength	(CQP 046-1 / ISO 4587)	2.5 N/mm ² approx.
Safe Drive-Away Time ² (cars)	with double side airbag	6 hours
according to FMVSS 212 / 208 (CQP 511-1)	without airbag	2 hours
Shelf life (storage below 25°C)	(CQP 016-1)	9 months

¹ – CQP (Corporate quality procedure), ² - 23°C / 50% RH

Industry

Description

SikaTitan-258 is a primerless to windscreen, one-component direct glazing adhesive. It is easy to apply and has a paste-like consistency. On exposure to atmospheric moisture it cures to a durable elastomer. SikaTitan-258 provides a long tack-free time and ensures a safe application even under warm conditions.

Note:

Primerless application requires the glass to be prepared with a non-antistatic glass cleaner. Also the bonding surfaces must be free of contamination prior to the application of the adhesive.

SikaTitan-258 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- Primerless to glass.
- One-component formulation.
- Cold application.
- Good application properties such as bead stability / good non-sag properties.
- Short cut-off string.
- Tested according FMVSS 212/208 (with double-side airbags ,no seatbelts).

Areas of application

SikaTitan-258 is suitable for direct-glazing applications in the Automotive Glass Replacement business. With its good performance and application properties it is suitable for mobile as well as in-house installations.

This product is to be used by professional experienced fitters only. If this product is used for other applications than Automotive Glass Replacement, trials must be carried out prior to use.



Cure mechanism

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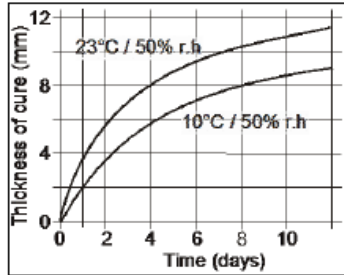


Diagram 1: Curing speed SikaTitan® 258

Chemical Resistance

SikaTitan-258 is resistant to fresh water, seawater, limewater, sewage effluent, diluted acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids and caustic solutions or solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Removal of old glass

Remove damaged glass in accordance with the vehicle manufacturer's instructions.

Surface preparation

Surfaces must be clean, dry and free from dust and grease. The bond faces must be prepared with a non-antistatic glass cleaner. Bonding surface must be free of contaminants before application of the product. Windshields without ceramic coatings need additional UV protection.

Application

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge or the unipack adapter.

It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive be applied in the form of a triangular bead (see fig. 1 below).

The substrate temperature must be between 5°C and 35°C.

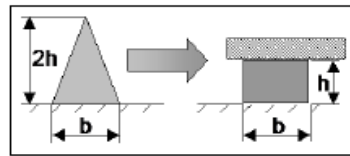


Figure 1: Compressing adhesive bead to final size

Removal

Uncured SikaTitan-258 may be removed from tools with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleaner and water.

Do not use solvents!

Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Instruction for use SikaTitan Products

Packaging Information

Unipack	400 mL x 20 pc / box
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Value Bases

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.

Legal Note

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. All rights reserved.



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