

Sikaflex®-220+

Fast Curing Windshield Adhesive

Properties:

Color:	Black
Weight/Gallon (ASTM D 475):	10.1 lbs./gal.
Cure system:	Moisture curing
Tack-free time*:	30 minutes
Rate of cure*:	3/16" per 24 hours
Hardness* (Shore A):	50-55
Elongation at break (ASTM D 412):	500-600%
Tensile strength (ASTM D 412):	1000-1200 psi
Lap shear strength (ASTM D 1002):	550-650 psi
Application temperature:	40°F to 110°F
Service temperature range:	-40°F to 200°F

* =temperature 73°F/50% R.H.

** = refers to ambient temperature of substrates For optimum application, Sikaflex®-220+ should be conditioned to 70°-80°F before use.

Description:

Sikaflex®-220+ is a fast curing flexible high performance polyurethane based adhesive for bonding windshields to vehicle bodyshells (direct glazing) and glass to metal or wood. Sikaflex®-220+ is manufactured under strict quality control to the highest Sika standards.

Advantages Offered by Sikaflex®-220+:

- Fast curing speed
- One-part formulation
- Excellent resistance to weathering and aging (tested under tropical conditions)
- Paintable once fully cured
- Non-corrosive
- Adheres well to a wide range of substrates
- High mechanical performance
- Sikaflex®-220+ offers Safe Drive Away Time in as little as two hours when used on vehicles without a passenger side airbag, eight hours with passenger airbag.
- Sikaflex®-220+ passes FMVSS 208/212 in its most severe interpretation with dual airbags and unrestrained dummies.

How to Use:

For complete instructions, refer to the Sika Autoglass Technician Training Manual. This product is to be used by trained installers only. Do not use without review of all Sika installation guidelines and MSDS. This product must be used with Sika Aktivator to prevent displacement of glass in the event of a crash. If not used as directed, the product may not properly adhere to glass and personal injury or property damage may result.

Surface Preparation:

Surfaces must be clean, sound, dry and free from all traces of dust and grease. Prepare the perimeter of the glass where it will make contact with the adhesive with Sika® Aktivator according to procedures outlined in the Sika Autoglass Technician Training Manual.

Industry



Storage:

Sikaflex®-220+ should not be stored at temperatures in excess of 75°F. Properly stored in cool, dry conditions, the unopened cartridges have a shelf life of 9 months.

Important Considerations:

- Once opened, contents of cartridges should be used up the same day or protected for later use, otherwise the contents will harden and be rendered useless.
- Do not use on polyethylene, polypropylene, silicone, PTFE, and certain plasticized resins (consult our Technical Services Department for advice).
- When working in low temperature conditions, allow cartridge to reach room temperature (DO NOT USE A SIKATACK-ULTRASTOVEN to heat. Product performance properties will be adversely affected.)
- Always use a piston type cartridge gun (hand operated or pneumatic) to apply adhesive.
- Avoid contact with alcohol, and alcohol-containing solvents during cure.

WARNING:

Irritant; Sensitizer:

Contains polyisocyanate prepolymer, xylene. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact and inhaling vapors. Repeating or prolonged exposure to Xylene may cause headaches, dizziness or other respiratory sensitization effects; and may cause liver or kidney effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case PELs are exceeded, use an appropriate, properly fitted NIOSH/MSHA approved respirator.

First Aid:

Respiratory - Remove to fresh air. Skin - Wash skin thoroughly with soap and water.

Remove contaminated clothing.

Eye - Rinse for 15 minutes.

Ingestion - In all cases if symptoms persist contact physician immediately. Do not induce vomiting.

Spill Cleanup:

Limitations:

- Never apply Sikaflex® -220+ over clear coat paint.
- Do not apply product to materials stored below 55°F.
- Always use in conjunction with Sika® Glass Prep Pads.
- Do not apply to rusty surfaces.
- Contact of uncured adhesive with alcohol containing substances will prevent proper cure.

Sikaflex® 220+

Relative Humidity	Temperature					
	>15°F	>25°F	>40°F	>50°F	>72°F	>95°F-110°F
<i>Without Airbag</i>						
>90%	24 hr	24 hr	4 hr	3 hr	2 hr	2 hr
>70%	24 hr	24 hr	4 hr	3 hr	2 hr	2 hr
>40%	NR	24 hr	24 hr	4 hr	2 hr	2 hr
>10%	NR	NR	24 hr	24 hr	4 hr	2 hr
>0%	NR	NR	NR	NR	4 hr	4 hr
<i>With Passenger Airbag</i>						
>90%	NR	NR	16 hr	12 hr	8 hr	8 hr
>70%	NR	NR	16 hr	12 hr	8 hr	8 hr
>40%	NR	NR	NR	16 hr	8 hr	8 hr
>10%	NR	NR	NR	NR	16 hr	8 hr
>0%	NR	NR	NR	NR	NR	NR

NR = Not Recommended

IN CASE OF EMERGENCY CALL CHEMTREC, 1-800-424-9300
INTERNATIONAL CHEMTREC, 1-703-527-3887

Consult Material Safety Data Sheets, Technical Data Sheets and Surface Preparation Guidelines available through SikaFax: 877-663-9727 or Visit our website at <http://www.sikaindustry.com>

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KEEP OUT OF REACH OF CHILDREN
KEEP CONTAINER TIGHTLY CLOSED

NOT FOR INTERNAL CONSUMPTION
FOR INDUSTRIAL USE ONLY

LIMITED WARRANTY: 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 Technical 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 IMPLIED OR EXPRESS 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 OR ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Manufactured by:

Sika Corporation

