BUILDING TRUST

PROVISIONAL PRODUCT DATA SHEET 2024-12-13

Sikaflex® P2G Premium

Primerless auto glass polyurethane adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.1 kg/l
Non-sag properties		Very good
Application temperature	Product	10 – 35 °C (50 – 95 °F)
	Ambient	4 – 43 °C (40 – 110 °F)
	Substrate	4 – 54 °C (40 – 130 °F)
Skin time (CQP019-1)		35 minutes [A]
Open time (CQP526-1)		15 minutes [A]
Shore A hardness (CQP023-1 / ISO 48-4)		65
Tensile strength (CQP036-1 / ISO 527)		6.5 MPa (940 psi)
Elongation at break (CQP036-1 / ISO 527)		600 %
Tensile lap-shear strength (CQP046-1 / ISO 4587)		5.0 MPa (720 psi)
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)		See table 1
Service temperature (CQP509-1 / CQP513-1)		-40 – 93 °C (-40 – 200 °F)
Shelf life		9 months [B]

CQP = Corporate Quality Procedure

A) 23 °C (73 °F) / 50 % r.h.

B) stored below 25 °C (77 °F)

DESCRIPTION

Sikaflex® P2G Premium is a cold-applied, fast curing, high-viscosity polyurethane adhesive designed for use in replacing direct glazed automotive glass parts. Sikaflex® P2G Premium does not require the use of a Sika® Aktivator or Sika® Primer pre-treatment product on glass or ceramic frit. When used as directed Sikaflex® P2G Premium is an appropriate adhesive for use in auto glass replacement applications.

PRODUCT BENEFITS

- No pre-treatment required for glass or frit
- 3 hour Minimum Drive Away Time (MDAT); tested according to FMVSS 212
- Can be used for non-conductive applications
- Can be used from 4 – 43 °C (40 – 110 °F)

AREAS OF APPLICATION

This product is suitable for experienced professional users only.

This product and related process information is designed for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

Sikaflex® P2G Premium cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower. More information can be found in the Minimum Drive Away Time table that follows.

Relative Humidity	Temperature > 4 °C (40 °F)	> 13 °C (55 °F)	> 21 °C (70 °F)	30 – 43 °C (85 – 110 °F)
> 90 %	3	3	3	3
> 70 %	3	3	3	3
> 40 %	3	3	3	3
> 20 %	3	3	3	3
> 0 %	3	3	3	3

Table 1: Minimum Drive Away Time (hours)

CHEMICAL RESISTANCE

Sikaflex® P2G Premium is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.
The bond faces must be prepared with an Automotive grade glass cleaner. Sikaflex® P2G Premium is capable to bond on glass and ceramic frits without additional pre-treatment. Further information on the application and use of cleaning agent, can be found in the corresponding Product Data Sheet.
All corrosion must be removed and all bare metal scrapes and scratches must be prepared in accordance with Sika's Corrosion Treatment recommendations. For preparation of all bonding surfaces it is required to read and understand the instructions given in the Sika AGR Technician Training Manual.
Windshields without ceramic coating need proper UV protection.

Application

It is recommended to apply Sikaflex® P2G Premium with a powerful battery operated application gun.
Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

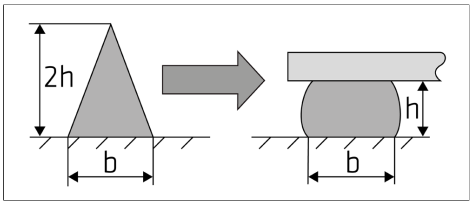

Figure 1: Recommended bead configuration

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the adhesive has built a skin.

Removal

Uncured Sikaflex® P2G Premium may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.
Hands and exposed skin have to be washed immediately using hand wipes or a suitable industrial hand cleaner and water.
Do not use solvents on skin.

Application Limits

- Avoid contact with alcohol and alcohol containing solvents during cure.
- Do not apply over silicones or in the presence of curing silicones.
- Glass parts must always be installed within the open time. The open time is significantly shorter in hot and humid climates. Never install any glass part after the product has built a 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
- Product Data Sheets
- Sika AGR Technician Training Manual

PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ENVIRONMENTAL, HEALTH AND SAFETY

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

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or 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 label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.
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