



Safe Drive Away Time Charts

INDUSTRY

The fastest, most reliable and cost effective adhesive system available.

Based on temperature and humidity, the enclosed charts indicate when Sika urethanes reach FMVSS 208/212 windshield retention requirements for both dual airbag and non-dual airbag automobiles.

Follow Sika technical installation instructions and product recommendations.

Required Cleaners and Primers

Sika®-Aktivator: used to clean all glass surfaces.

Sika®-Primer 206 G+P: used to cover all bare metal surfaces and provide a UV barrier on glass without a frit band.

Sika®-Primer 215: used on all PVC and EPDM surfaces that must bond to urethane.

**Additional technical information, MSDS's or Surface Preparation Guidelines are available through SikaFax:
740-375-0063**



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Hot-Applied High-Modulus Adhesive

SikaTack®-Plus HM (rates non-conductive)

Relative Humidity	Temperature					
	>15°F	>25°F	>35°F	>55°F	>72°F	>95°F
<i>Without Airbag</i>						
> 100%	NR	2hr	2hr	1hr	0.5hr	0.5hr
> 75%	NR	2hr	2hr	1hr	0.5hr	0.5hr
> 40%	NR	NR	2hr	2hr	1hr	0.5hr
> 20%	NR	NR	NR	2hr	2hr	1hr
> 0%	NR	NR	NR	NR	NR	NR
<i>With Passenger Airbag</i>						
> 100%	NR	24 hr	24 hr	8 hr	4 hr	4 hr
> 75%	NR	24 hr	24 hr	8 hr	4 hr	4 hr
> 40%	NR	NR	24 hr	24 hr	8 hr	4 hr
> 20%	NR	NR	NR	24 hr	24 hr	8 hr
> 0%	NR	NR	NR	NR	NR	NR

NR = Not Recommended

