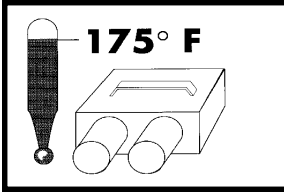
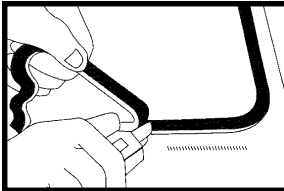


# Installation Instructions for Hot-Applied Adhesives -

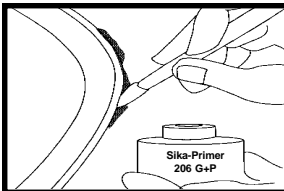
SikaTack®-Plus Booster, SikaTack®-Ultrafast, SikaTack®-Ultrafast II, SikaTack®-Plus HM



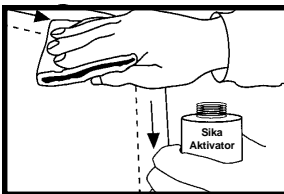
1. Insert cartridge into the SikaTack oven and allow to heat for 1 hour. The adhesive may be warmed and allowed to cool several times and may be left in the oven for up to 10 hours. Using a black marker, indicate the time the cartridge was inserted in the oven on the plunger.



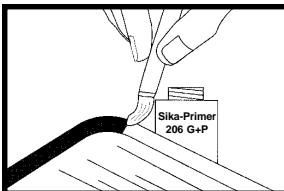
2. Remove the windshield and trim following the vehicle manufacturer's instructions. If the adhesive bond is sound, bonded firmly and not peeling from the pinch weld, trim down to 1-2 mm (1/16"-1/8"). If the old urethane is not sound but loose, or if the pinch weld has an excess of butyl tape or silicone, remove all material down to the pinch weld. Check replacement windshield for fit and mark correct position with adhesive tape.



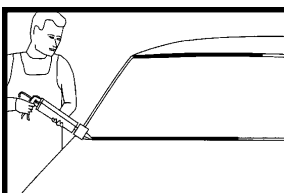
3. Use Sika-Primer 206 G+P to touch up bright metal scratches and nicks on the pinch weld. Drying time 10 minutes. Sika-Primer 206 G+P will minimize the formation of rust on unrusted metal. If metal is rusted, rust must be removed before priming.



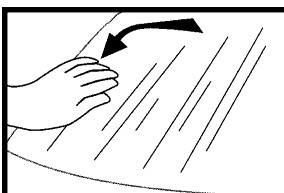
4. Apply Sika-Aktivator to bonding area on clean glass sparingly with lint-free cloth/paper towel and wipe off. Turn cloth several times to avoid transferring dirt, oil, etc. from one area to another. Drying time 10 minutes. Install windshield within 2 hours.



5. If no ceramic band (frit) is present and there is no trim to cover the adhesive, apply Sika-Primer 206 G+P (black) to glass as a U.V. block. Drying time 10 minutes.



6. Remove preheated cartridge from oven using a safety glove. Completely puncture the seal on the top of the cartridge. Remove end cap if present. If using SikaTack-Plus Booster, screw booster unit on the top of the cartridge. Attach the V-cut nozzle and apply triangular bead of adhesive (1/4"-5/16" wide x 5/16"-3/4" high) directly to the glass or pinch weld. Start on the passenger side. No butyl tape, foam dam or spacers are needed.



7. Install glass and align to correct position. Glass must be installed within specified open time of adhesive (refer to tech data sheet). Press gently around edge of windshield to set at proper level and insure good contact with adhesive. Replace trim.



8. Remove any excess adhesive with a poly stick. Clean up with a non-alcohol based adhesive remover.



INDUSTRY