

# TITAN™ 800EM

## High Modulus and High Decking

### Carlite Approved Automotive Adhesive

#### Product Data Sheet

#### Description

TITAN 800EM is a one component polyurethane adhesive formulated for autoglass installations. Performance characteristics meet or exceed all one component original equipment specifications including FMVSS 212/208 and 216. This high performance adhesive provides you with exceptional decking features and Carlite approval, giving you a user-friendly installation with OEM proven confidence.

Features	Benefits
High Decking	Support glass without dams or blocks
Excellent adhesion	Safer installation
Exceeds FMVSS 212/208 & 216 strength requirements	Maintains or exceeds OEM requirements
Excellent cut-off	Easy to clean up, no mess

#### Instructions

1. Remove all exterior moldings, trim, and windshield following the vehicle manufacturer's instructions.
2. Using the full cut method, inspect the old urethane to insure a firm bond exists to the pinchweld. Firmly bonded urethane should be trimmed, leaving a level bed around the entire pinchweld approximately 1/16" to 1/8" thick.
3. If old urethane demonstrates any signs of peeling, or if butyl tape, silicone, or rust is apparent, remove all material down to the pinchweld.
4. Prime pinchweld scratch marks and repaired rust areas with TITAN WIP40 Pinchweld Primer; allow 20 minutes to dry. (See TITAN WIP40 product data sheet for complete instructions.)

5. Clean replacement windshield thoroughly with TITAN 604 Glass cleaner.
6. Prime the glass with TITAN GP60 Glass Primer. Use a fresh applicator each time the primer is applied. Allow 20 minutes to dry (See TITAN GP60 product data sheets for application instructions.)
7. Wipe moldings and encapsulated parts with TITAN 604 Glass Cleaner and prime with TITAN GP60 Glass Primer. Use a fresh applicator each time the primer is applied. (NOTE: For metal encapsulations use TITAN WIP40 Pinchweld Primer.)
8. Where required, select and install appropriate dam tape and blocking materials.
9. Apply a 1/2" to 5/8" high bead of TITAN 800EM urethane adhesive around the entire perimeter of the pinchweld. Apply directly on top of the freshly trimmed existing bed of urethane.
10. Make sure glass primer is dry. Install clean, primed glass into opening, using light hand pressure to assure complete contact with wet TITAN adhesive. Replace moldings and accessories. Clean up with TITAN 605 Citra-Thane Cleaner.

#### Health & Safety

Users must follow individual product data sheet and Material Safety Data Sheets (M.S.D.S.) for health and safety precautions. Always use protective eyewear.

ADCO Products, Inc. P.O. Box 457, 4401 Page Avenue Michigan Center, MI 49254 (800)248-4010 (517)764-6697 Fax



#### The ADCO Products, Inc. Limited Warranty

We warrant our products to meet our published physical properties at the time of sale when tested according to our standards. Under this limited warranty, we will provide, at no charge, product in containers to replace any product proven to be defective when applied and tested according to our written instructions.

User shall determine the suitability of the product for its intended use and assume all risk and liability. **WE SHALL NOT BE LIABLE FOR ANY INJURY, LOSS OR DAMAGE, BEYOND PRODUCT REPLACEMENT DESCRIBED IN THIS LIMITED WARRANTY, AND IN NO EVENT SHALL WE BE LIABLE FOR ANY SPECIAL, INCIDENTAL, CONSEQUENTIAL OR PUNITIVE DAMAGES.**

Any and all claims that a product is defective must be made in writing within thirty (30) days after discovery of the defect and in no event more than one (1) year after the original shipment of the product by us. Failure to timely notify us of any claim constitutes an irrevocable waiver of such claim regardless of the circumstances. **THIS LIMITED WARRANTY IS THE USER'S SOLE REMEDY AND IS IN LIEU OF ANY AND ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.**

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Technical Data	
<b>Physical Properties</b>	
Base Polymer	Polyurethane
Color	Black
Tack Free time	Approx. 25 minutes @ 73°F/23°C /50% RH
Type of curing	Moisture
Shore A Hardness	60
Tensile strength	>700 psi
VOC Content	80 g/l (0.67 lb./gal)
Lap shear strength	>500 psi
<b>Application Properties</b>	
Application Temperature:	40°F to 113°F (5°C to 45°C)
Storage:	40°F to 90°F (5°C to 33°C)
Shelf Life:	9 months in unopened container, when stored at 77°F/50% RH
NOTE: The foregoing information is published as general information only. The listed properties and performance characteristics are approximate values and are not part of the product specification.	

TITAN 800EM Safe Drive Away Chart Without Passenger Airbag					
Safe Drive-Away Strength: 50 psi					
Minimum installation temperature: 40° F					
Minimum installation humidity: 10%					
No special procedures required to achieve times stated below.					
	90% RH	75% RH	50% RH	25% RH	10% RH
85° F	2 hrs	3 hrs	4 hrs	5 hrs	10 hrs
70° F	3 hrs	4 hrs	4 hrs	5 hrs	14 hrs
55° F	4 hrs	4 hrs	5 hrs	8 hrs	24 hrs
40° F	6 hrs	8 hrs	9 hrs	12 hrs	TITAN 700HV
25° F	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV
10° F	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV

TITAN 800EM Safe Drive Away Chart With Passenger Airbag					
Safe Drive-Away Strength: 150 psi					
Minimum installation temperature: 40° F					
Minimum installation humidity: 10%					
No special procedures required to achieve times stated below.					
	90% RH	75% RH	50% RH	25% RH	10% RH
85° F	5 hrs	5 hrs	7 hrs	9 hrs	14 hrs
70° F	6 hrs	8 hrs	8 hrs	9 hrs	24 hrs
55° F	8 hrs	8 hrs	8 hrs	12 hrs	TITAN 700HV
40° F	12 hrs	24 hrs	24 hrs	24 hrs	TITAN 700HV
25° F	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV
10° F	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV	TITAN 700HV

**Availability/Cost**

Availability and cost can be obtained from your local ADCO Products, Inc. representative or ADCO Products, Inc. distributor.

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