

**28031 – black,
310ml****Ljepilo za vjetrobrane**

WINDSHIELD ADHESIVE

CODE

NAME

PROPERTIES

Windshield adhesive is a fast curing, one component, high viscosity, moisture curing polyurethane adhesive, primarily used for automotive direct glazing with and without airbag.

DIRECTIONS FOR USE

Remove windshield following manufacturer's instructions.

For windshields without external protection, or with black ceramic coating with light transmission at $400\div 500\text{nm} > 0,1\%$ (laminated) and $> 0,2\%$ (tempered), Windshield adhesive must be used in conjunction with Primer (28021). For direct glazing of windcreens with external protection, or windscreen with black ceramic coating with light transmission at $400\div 500\text{nm} < 0,1\%$ (laminated) or $< 0,2\%$ (tempered), Windshield adhesive may be used with only Primer (28021).

Please refer to the relevant Technical data sheet for detailed instructions on use of Primer (28021).

Body preparation

A. *Fast method*: trim back remaining adhesive bead in the windshield body flange to a thickness of $4\div 5\text{mm}$. Apply Primer (28021) on the cured adhesive bead with a clean, lint-free cloth. Let dry 10 min. Do not use solvents or „antisilicone“. If necessary use water prior the application of Primer (28021).

B. *Standard method or first instalation*: completely remove old adhesive. Paint over any damage caused to the paint using a phosphating agent. Rinse with water and let dry. Clean the bond line with a lint free cloth moistened with Primer (28021)

Winshield preparation

The substrates must be clean, dry, free from dust, grease and any contaminating agent that could affect bonding, clean off the bond area with alcohol solvents or MEK. Let dry 10 min. Apply a thin and even layer of Primer (28021) (see above – shake well before use). Let dry 10 min at 23°C 50% r.h.

Application of adhesive with triangular nozzle

A. *Fast method*: apply the adhesive on the vehicle body taking care to fill all empty spaces left by old adhesive.

B. *Standard method or first installation*: apply adhesive on windshield.

The thickness of the adhesive and the section of the nozzle may vary according to needs. For more informations please consult the constructor advices.

Windshield installation

Position the windshield within $10\div 15$ min. Apply light pressure all around perimete of glass to ensure good contact with the adhesive bead. Refit trims and mouldings. Remove any excess of adhesive before it is hardened.

TECHNICAL INFORMATION		
Characteristics	Measures	Variance
Colour	Black	//
Consistency	Pasty, thixotropic	//
Density, uncured	1,20 approx.	//
Tack free time (23°C, 50% r.h.)	25 – 40 min	//
Cure rate (23°C, 50% r.h.)	> 4mm	//
Hardness Shore A	60 approx	//
Shear strenght	3,4 MPa	//
Drive-away time (23°C, 50% r.h.)	2 h min airbag 3 h with airbag	//
Shelf life	12 months from production date stored in cool, dry place at T< 25°C	
Packaging	Tube 310 ml	

SAFETY MEASURES

Look at Technical data sheet.

ADR CLACIFICATION

Look at Technical data sheet.

RESPONSIBILITY STATEMENT

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL USE BY QUALIFIED PERSONNEL