

PRODUCT HIGHLIGHTS

4502

Urethane Windshield Adhesive

DESCRIPTION:

Urethane Windshield Adhesive is a one part moisture curing urethane adhesive designed to provide a strong bond to all windshield and backlight replacements. This product exhibits excellent adhesion to glass and pinchweld surfaces designed for use in a close cut-out method or tape installation. Urethane Windshield Adhesive passes FMVSS 208, 212, and 216 strength requirements.

PRODUCTS:

4502 Urethane Windshield Adhesive, 11 oz. cartridge (310 ml), 12/case



SURFACE PREP:

Clean with glass cleaner. Use Acry Solvent (TDS316) to clean bonding surface around perimeter of glass.



MIX RATIO:

Ready to use.



DRIVE AWAY TIME (50% RELATIVE HUMIDITY):

150 PSI Lap Shear (with passenger air bag)	50 PSI Lap Shear (with passenger air bag)
70°F (21°C) 6.5 hours	3.5 hours
50°F (10°) 13 hours	8 hours

*See next page for more detailed product application. See website for this document in other languages.
Vea la página siguiente para un uso más detallado del producto. Vea el Web site para este documento en español.
Voir la prochaine page pour une application plus détaillée de produit. Voir le site Web pour ce document en français.*

PRODUCT DATA

4502

Urethane Windshield Adhesive

SURFACE PREPARATION:

Clean with glass cleaner. Use Acry Solvent (TDS316) to clean bonding surface around perimeter of glass.

APPLICATION:

CLOSE CUT-OUT METHOD

1. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth.
2. Apply Transtar Acry Solvent (TDS316) to clean bonding surface around perimeter of glass. Allow 5 minutes to flash and dry off.
3. Apply a thin coat of Pinchweld Primer over black ceramic band (frit). Allow to dry.
4. Remove the old windshield cutting as close to the glass as possible.
5. Trim away high spots off the original adhesive. Clean the remainder of original adhesive with a dry brush or compressed air.

Note: Transtar urethanes are primerless to the original urethane. Use Pinchweld Primer on any exposed bare or painted metal.

6. Gun a bead of #4502 Urethane Windshield Adhesive directly on the existing bed of urethane.
7. Install windshield, applying even pressure on the bond line to assure uniform contact with the adhesive.
8. Apply additional adhesive if required. Tool urethane around the edge and replace the molding.
9. Clean up with Transtar Acry Solvent (TDS316).

FULL CUT-OUT METHOD

1. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth.
2. Wipe with a thin coat of Acry Solvent (TDS316) to the bonding surface around the edge of the windshield. Allow 5 minutes dry time.
3. Remove all but a 1/16" - 1/8" layer of the original adhesive from the pinchweld. Clean the old urethane with Acry Solvent (TDS316).
4. Apply butyl tape to the inside edge of the pinchweld, pressing to assure complete contact with the surface before removing the release liner.
5. Apply a bead of #4502 Urethane Windshield Adhesive behind the tape. The bead should be slightly higher than the profile of the dam tape.
6. Install the windshield making sure to apply even pressure on the bond line to ensure contact with the adhesive.
7. Additional urethane can be applied if necessary. Tool urethane around the edge of the windshield and replace the molding.
8. Use Acry Solvent (TDS316) to clean excess urethane.

TECHNICAL TIPS:

For maximum adhesion protection, windshields that have a black ceramic band will require priming with Pinchweld Primer.



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TECHNICAL DATA:

BASE POLYMER:	Polyurethane
APPEARANCE:	Black color
% SOLIDS:	100% Solids
SHELF LIFE:	1 year
TENSILE STRENGTH:	>600 psi
LAP SHEAR STRENGTH:	>500 psi
CURE THROUGH TIME:	24 - 36 hours @ 70°F (21°C) and 65% relative humidity
TACK FREE TIME:	40 minutes @ 70°F (21°C) and 50% relative humidity
HARDNESS:	Shore A 50 - 55
APPLICATION TEMPERATURE:	For best results 40°F - 110°F (4° - 43°C)
PACKAGING:	11 oz. (310 ml) fiber cartridge
ELONGATION AT BREAK:	300% at 72°F (22°C)

REGULATORY:

Category: Adhesive 4502	Individual Component
VOC Actual	0.5#/gal (60 g/l)
VOC Regulatory	0.5#/gal (60 g/l)
Weight % of Volatiles	5%
Weight % of Water	0
Weight % of Exempt Compounds	0
Volume % of Exempt Compounds	0
Density of Material	10.0

ADVANTAGES:

- Passes FMVSS 208, 212 and 216 strength requirements
- Cost effective
- Non sag formula
- Contains no isocyanates

COMPETITION:

3M 08067
CAR/Bernardo Ecenarro URKI-SEAL 4000
Car System 138.535/138.536
Dominion SS 9006
Duramix 4208
Kent 39897
Rubberseal RS223
Würth 10545