

Technical Data Sheet

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.

MIXING



By Volume: Ready to use

FLASH TIMES/DRY TIMES



Tack free time:	40 minutes		
Drive away time:		150 PSI Lap Shear (w/passenger airbag)	50 PSI Lap Shear (w/passenger airbag)
	70°F (21°C)	6.5 hours	3.5 hours
	50°F (10°C)	13 hours	8 hours
Cure through time:	24-36 hours		

SURFACE PREPARATION



Cleaning: Clean with glass cleaner. Use Acry Solvent 9783/9784 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 9783/9784 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 9783/9784.

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 9783 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 9783/9784.
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 9783/9784 to clean excess urethane.

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

LIMITATIONS & PRECAUTIONS

- For use only by professional, trained painters. Not for sale to or use by the general public.
- Before use, read and follow all TDS, label and SDS precautions.

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PRODUCT SPECIFICATIONS

Color: Black	Shelf Life: 1 year
RTU Solids: 100%	Size: 10.5 fl oz metal cartridge (310 ml)
Tensile Strength: >600 psi	Lap Shear Strength: >500 psi
Hardness: Shore A 50-55	Elongation at Break: 300% at 72°F (22°C)

REGULATORY

Category: Adhesive			
VOC Actual	0.55#/gal (66 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	0.58#/gal (70 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	<10%	Density of Material #/gal	10.8
Weight % of Water	0		