AUTOMOTIVE AFTERMARKET PRODUCT CATALOGUE

BUILDING TRUST

LEADING SOLUTIONS

Designed and tested for maximum efficiency

SIKA IS A TIER 1 SUPPLIER AND DEVELOPMENT PARTNER TO THE AUTOMOTIVE INDUSTRY.
Together with our customers, we help create the automobiles of tomorrow. Sika aftermarket solutions have been driving the automotive industry worldwide for more than 30 years. Our intelligent products combine state-of-the-art technology with user-oriented application properties that make it easy to get started right away.

THE LEADING BRAND FOR WINDSCREEN ADHESIVES
Since the early 1980s, Sika has been a series supplier and development partner to the automotive OEM industry. The knowledge we have acquired throughout this partnership also flows into the products we offer for the automotive aftermarket business. Over the years we have continuously strengthened our expertise and have become the leading brand for windscreen adhesives. Based on our competencies as a leading OEM supplier, we provide a comprehensive portfolio for sealing and bonding, noise damping and protective coating applications in the car body repair market. Innovation, performance, reliability and ease of use make Sika products the number one choice for automotive glass and body shop professionals all around the world.

TRUST A POWERFUL GROUP
Sika is a Swiss-based specialty chemicals company with more than 100 years of experience. For Sika, innovation has always been the driving force in its quest to become the global market leader. It all began 25 years ago, when we started supplying BMW with the black primerless adhesive system. Over the years we went on to develop relationships with almost all international vehicle manufacturers.

Sika products are used in 50% of all vehicles produced. Sika is a global player, but is completely focused on having people in the market who speak the local language and who know about your business. We currently operate in 93 countries.

At the time of writing, more than
300 MILLION
windscreens have been replaced using Sika adhesives

Over
30 MILLION
headlights, sunroofs and spoilers are bonded using Sika adhesives every year

1 OUT OF 3
windscreens worldwide is replaced using Sika adhesive

Local Sika presence in over
93 countries

50%
of vehicles produced worldwide use Sika technology

Sika technology saves
80 MILLION
litres of fuel annually (240 million kg of CO_2)

Sika supplies more than
400 MILLION
acoustic damping parts per year

CUSTOMER SAFETY IS OUR MISSION

At Sika we work closely with the automotive industry and provide solutions for producing more comfortable, safer and quieter cars. Today's vehicles are reinforced by the combination of bonding technology with the use of high-strength steel and other materials. Using adhesive technology to create additional body stiffening has become standard practice with the bonded windscreen; today, automotive engineers are using bonding solutions as an essential component for improving body stiffness and behavior in car accidents. Adhesive systems from Sika combine ease-of-use and reliability, and ensure that a repaired vehicle meets the same standards as a new one. This really makes the difference and guarantees the highest safety standards for every one of your repair jobs.

OEM COMPETENCE

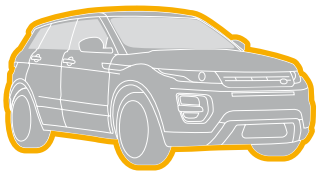
Sika is at the cutting edge of technology for lightweight vehicle manufacturing

THERE ARE CURRENTLY SOME **ONE BILLION REGISTERED PASSENGER VEHICLES**, AND THE NUMBER IS GROWING EVERY YEAR. CONSEQUENTLY, AND DUE TO THE CHALLENGES POSED BY RESOURCE SCARCITY, RISING ENERGY CONSUMPTION, AND INCREASING CO_2 EMISSIONS MORE EFFICIENT VEHICLES WILL CLEARLY BE NEEDED IN THE FUTURE. AND IN THIS RESPECT, THERE IS ONE CRUCIAL FACTOR. WHILE A FEW GRAMS OF CO_2 OR A LITTLE MATERIAL OR ENERGY SAVED BY SHAVING A FEW KILOGRAMS OFF ONE VEHICLE'S WEIGHT MAY SEEM MODEST, THE RESULTS ARE SIGNIFICANT OVER THE MILLIONS OF NEW CARS THAT ARE MANUFACTURED EVERY YEAR. EVEN SMALL IMPROVEMENTS CAN ADD UP QUICKLY.

Traditional material fastening methods, such as rivets, screws, and welding techniques like spot welding, are being replaced or supplemented by adhesive bonding methods that are not just ultra-high strength, but also remain elastic. These adhesives must not only adhere equally well to different materials, but also compensate for their different expansion characteristics while also maintaining just the right amount of stiffness and providing optimum handling.

Sika's adhesive technologies and products point the way toward high-performance lightweight construction and represent a substantial contribution to sustainable mobility.

OEM
APPROVED SYSTEM

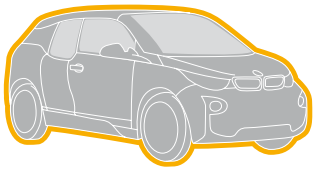


RANGE ROVER SPORT – THE FASTEST, MOST AGILE AND RESPONSIVE LAND ROVER EVER

The all-new Range Rover Sport has been completely redesigned from ground up. Land Rover has created a new milestone in automotive design. Sika's innovative adhesive technologies play a key role in increasing vehicle safety.

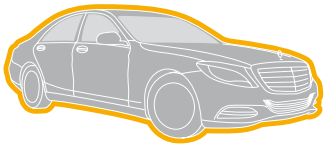
SikaPower® adhesive is used to bond areas that are subject to high mechanical load. Since the adhesive enables the body construction to absorb more energy, it enhances safety in a crash situation.

The Sika products in the Range Rover Sport play an important role in enhancing the vehicle's crash performance and resistance. They also improve the levels of comfort and durability, increase overall safety and make a major contribution to its lightweight design.



BMW i3 – A NEW STANDARD IN LIGHTWEIGHT CONSTRUCTION

Ultra-high modulus (UHM) **Sikaflex®** adhesives are a new development with which Sika is responding at an early stage to the increasingly wide range of materials being used in automotive design. They enable quick bonding processes with multi-material combinations, while guaranteeing that components remain durably functional. **Sikaflex® UHM** adhesives are unique within the industry. They are suitable for both fully automated adhesive application on the assembly line as well as manual application. The pioneering all-electric BMW i3 is the showcase for the new **Sikaflex® UHM** adhesive technology.



MERCEDES S CLASS – THE BONDED FUTURE

The Mercedes S Class features the latest generation of modular construction using a wide variety of material combinations. The car body is based on a mix of aluminium and high-strength steels. Special bonding techniques and sealants are needed to optimize safety, vibration characteristics, and acoustics. A wide range of Sika solutions are used in the new S Class: **Sikaflex® UHM** adhesives for bonding the lightweight aluminium roof to the steel car body and for enhancing overall vehicle stiffness, together with ultra-elastic adhesives for invisible bonding of the roof-stiffening panel. **Sikaflex®** adhesive is also used for the direct glazing. Expanding **SikaReinforcer®** frame stiffening components and **SikaPower®** structural adhesives ensure optimum NVH (noise, vibration, harshness) characteristics.

INNOVATION IS OUR PASSION

We are focused on the three core values that have made us the Number One on the international market: **INNOVATION, SIMPLICITY AND SAFETY**. Our aim is to simplify the professional application process by supplying reliable and fast-curing adhesive systems and short, safe drive-away times that maximize the safety levels for vehicle owners and passengers.

Making visions come true

INNOVATION

Sika adhesive solutions continue to be best-in-class. We do more than just respond to the needs of our professional customers; we also take future requirements of the automotive industry into account. This enables us to launch powerful innovations while focusing on you and your customers' needs.

From professionals, for professionals

SIMPLICITY

Your daily work inspires our development efforts. That's why we closely collaborate with automotive glass technicians and vehicle body experts in order to find intelligent solutions that meet your requirements perfectly, making Sika products easy to use – straight out of the box.

Always going above and beyond

SAFETY

We are serious about taking no shortcuts when it comes to protecting vehicle drivers and passengers. Sika applies the highest safety standards and outperforms international requirements.

MORE THAN 60 CRASH TESTS

NO SHORTCUTS WHEN IT COMES TO SAFETY

BY TECHNICIANS, FOR TECHNICIANS

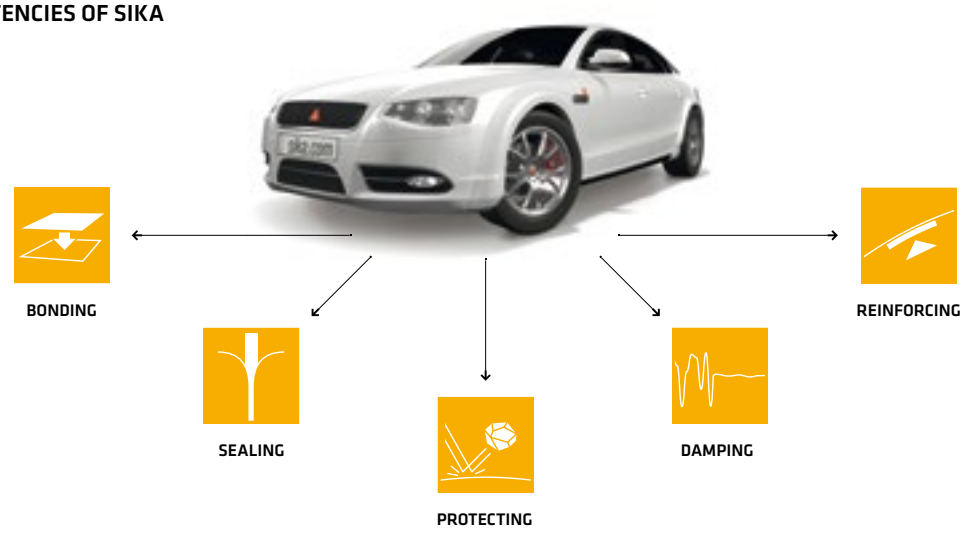
EASY HANDLING

SAVES TIME, INCREASES PRODUCTIVITY

AFTERMARKET EXPERT

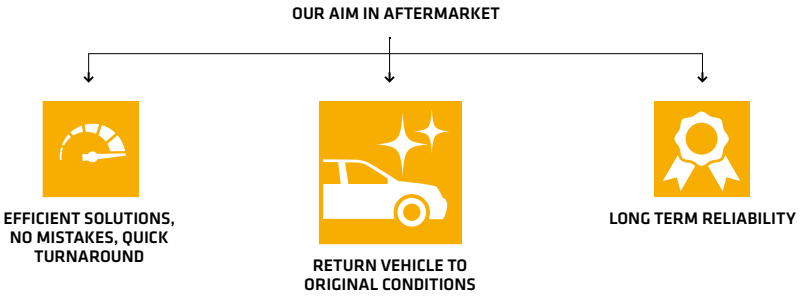
For bonding, sealing, damping, reinforcing and protecting

CORE COMPETENCIES OF SIKA



Sika has gained more than 25 years of experience in supplying the automotive aftermarket industry with adhesive and sealing systems. Based on this knowledge and expertise, Sika has developed product systems for use in the automotive repair and replacement industry. Today, we – Sika – are the Number One global supplier of windscreen adhesives for automotive aftermarket applications, and we have a comprehensive range of solutions for sealing, bonding, dampening and protecting.

Thanks to continuous innovation and listening to customer needs and requirements Sika solutions are recognized as best-in-class. All over the world, glass replacement specialists, body and paint workshops, authorized dealer repair shops, and maintenance and overhaul repair shops trust in Sika's products which are formulated to meet and/or exceed OEM requirements. Sika: the market leader in bonding, sealing, protection, damping, and reinforcing.



POWER*CURE*

PERFORM WITH THE ULTIMATE TECHNOLOGY

PowerCure is the latest technology for accelerated curing adhesives. For the first time here, Sika is taking a total solution approach. We believe reaching the next level of technology is only possible if the system reflects the reality an automotive glass technician has to deal with every day. PowerCure has been developed together with automotive glass technicians from the very beginning; it is designed for both mobile and shop environments and has proven its reliability under the harshest conditions.

PowerCure adhesives reach a new level of performance at an unmatched level of comfort. For the first time here, we have developed a total solution for vehicle glass replacement, and this has allowed us to question each little step, from mounting a unipack to the actual extrusion of the adhesive. The PowerCure system is probably the first ever to be developed together with automotive glass professionals from the very beginning.

- Simple as a one-component
- Minimized waste, maximized yield of adhesive
- Ergonomic design
- Fastest unit replacement on the market
- Long working time but quick curing

CURED TO OEM LEVEL

Sika's PowerCure adhesives allow a car to be lifted by its windscreen in as little as 60 minutes. This is what we understand practically by adhesives which are cured to OEM level.

PERFORMANCE BEYOND SDAT

Having just a short Safe Drive-Away Time (SDAT) is not the definition of a safe system! Vehicle manufacturers apply stricter standards for releasing a vehicle back into operation than the average automotive glass shop. Up until now, no system has been able to reach car manufacturers' (OEM) performance requirements quickly enough and easily enough to be used by independent automotive glass companies.

PowerCure ADHESIVES ARE DIFFERENT!

CURED TO OEM LEVEL

PowerCure adhesives cure independently of the climate from the inside of the bead. They cure within minutes to the strength level specified by vehicle manufacturers. PowerCure adhesives reinforce the car's body structure to the original level within just 60 minutes, whereas one-component products can require up to several weeks depending on the climate. Rapid deployment of structural integrity is one of the key reasons why some vehicle manufacturers require their service centers to use accelerated or two-component adhesives. There are further benefits to using PowerCure adhesives too:

- comebacks can be repaired quickly without risk of soiling car interiors
- sensors can be calibrated quickly and without any concerns
- insurance and subcontracted work will meet all OEM standards

and you could even lift a vehicle by the windscreen just 60 minutes after installation.

ADHESIVE FOR VEHICLE GLASS REPLACEMENT	
Product	SikaTack® ELITE designed for PowerCure
Technology	Accelerated polyurethane adhesive
Safe Drive-Away Time (SDAT)	30 min
SDAT temperature conditions	–10 °C to 40 °C
Cured to OEM level	60 min
Open time (23°C/50% r.h.)	10 min
Application temperature	Cold-applied
All-in-one modulus	✓

THE HIGHEST PRECISION IN YOUR HANDS

The PowerCure adhesive system delivers the precision and performance of high-end pump systems found at vehicle manufacturer's production lines. It combines high flexibility, ergonomic and easy handling, and minimizes waste in a clear and focused design. The use of a single, brushless motor mechanically couples extrusion, dosing and dynamic mixing, and allows controlling of extrusion speed on the go without compromise. Providing the fastest curing adhesives at unmatched comfort level, PowerCure is the total solution for smaller sealing and bonding applications.

PACKAGING

Based on the unipack: PowerCure packaging is based on the unipack, the most efficient packaging solution for windscreen adhesives. The packaging is designed to minimize wastage and to allow very simple mounting and replacement.

MIXER

Dynamic and efficient: The mixer is designed to fit an ordinary application nozzle. The specially shaped v-cut supports the application of the adhesive at a convenient angle to the glass and cuts material consumption by up to 8%.

DESIGN AWARD 2016

«FROM THE VERY BEGINNING WE ANALYZED WORKING AND HANDLING PROCEDURES OF APPLICATORS IN THE FIELD. EVERY LITTLE STEP WAS QUESTIONED AND CONSTANTLY CHALLENGED. WE AIMED TO MAKE USING PowerCure AS SIMPLE AS USING A SINGLE COMPONENT PRODUCT. IN MANY ASPECTS IT'S EVEN SIMPLER AND FASTER.»

David Tobler, Head Automotive Aftermarket

PowerCure DISPENSER

Single motor design: The PowerCure Dispenser matches the precision of pump and dosing systems found on vehicle manufacturers' production lines. The use of a single, brush-less motor mechanically couples extrusion, dosing and dynamic mixing. This allows users to control extrusion speed on the go without compromise.

*Registered Contractors only are permitted buy the Powercure Gun

SIKA SOLUTIONS FOR VEHICLE BODY REPAIR

Designed for maximum efficiency

16 WINDSCREEN BONDING

52 PROTECTIVE COATINGS

PLASTIC REPAIR 34


PANEL REPLACEMENT 26
SEALING 42
COMPONENT BONDING 38

WINDSCREEN BONDING PRODUCT RANGE

FROM SIKA CLEANING PRODUCTS TO PREMIUM ADHESIVES, WE ENSURE AN EFFICIENT PROCESS RIGHT FROM THE BEGINNING. AUTOMOTIVE GLASS PROFESSIONALS BENEFIT FROM AN EXCELLENT WORKFLOW WITH WELL-MATCHED PRODUCTS.

ADHESIVES	**SikaTack® ELITE** Designed for PowerCure	**SikaTack® PRO**	**SikaTack® DRIVE**
Technology			
Accelerated polyurethane	✓		
One-component polyurethane		✓	✓
Pre-treatment process			
Black Primerless		✓	✓
All Black	✓	✓	✓
Properties			
Cold-applied	✓	✓	✓
SDAT	30 min	30 min	60 min
SDAT test standard	95th percentile FMVSS 212	95th percentile FMVSS 212	95th percentile FMVSS 212
Cured to OEM level	60 min	--	--
Working time	10 min	8 min	12 min
All-in-one modulus	✓	✓	✓

PRE-TREATMENT PROCEDURES	**Black-Primerless process**	**All-Black process**
Float glass and ceramic coated glass	●	●
Bare metal scratches < 5 cm²	● ●	●
Bare metal scratches 5 cm² to 150 cm²	● ● ●	● ●
Intact OEM and aftermarket paint*	● ●	●
PVC and RIM encapsulation	● ●	●
Trimmed residual bead	●	optional/●
Pre-applied adhesive system	●	optional/●
PMMA/PC**	● ●	●

● Sika® Aktivator PRO
● Sika® Primer-207

*after complete curing of the paint
**additional UV protection required
For details check installation process charts (available separately)

WINDSCREEN BONDING ADHESIVES

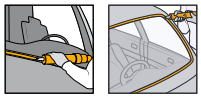
SikaTack® ELITE

High-speed Performance in Every Climate

SikaTack® ELITE is an advanced windscreen adhesive, specifically developed and engineered for our innovative PowerCure system technology. The quick curing of SikaTack® ELITE enables you to meet OEM requirements in less than 60 minutes! The Safe Drive-Away Time is already reached just 30 minutes after installation. Boost your business with a potentially record-breaking performance.

Thatcham® Quality Assured Repair Equipment

THATCHAM APPROVAL
SikaTack® ELITE is a Thatcham-approved repair product.



YOUR BENEFITS

- True 30 min Safe Drive-Away Time, tested under the new 95th percentile FMVSS 212 standard
- Cures to OEM level within 60 min
- Meets all OEM requirements, including Volvo, VW, Audi, etc.
- Fast curing
- Curing independent of climate conditions
- Very short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus

SikaTack® ELITE requires the PowerCure Dispenser as well as the PowerCure Mixer Nozzle. For pre-treatment, SikaTack® ELITE requires the Sika All-Black bonding process.

AVAILABLE ITEMS

■ Box with 14 × 600 ml PowerCure Pack	Item No.	496374

PowerCure System

The PowerCure adhesive system delivers the precision and performance of high-end pump systems found in vehicle manufacturers' production lines. It combines high levels of flexibility, and ergonomic and easy handling, and minimizes waste in a clear and focused design.

*Registered Contractors only are permitted buy the Powercure Gun

SikaTack® PRO

Premium Choice for Automotive glass Professionals

Our innovative windscreen adhesive has been tested under the most severe conditions. With our all-in-one technology, SikaTack® PRO is a perfect fit for all car makes and models, and delivers high value for money.

YOUR BENEFITS

- True 30 min Safe Drive-Away Time, tested under the new 95th percentile FMVSS 212 standard
- Safe Drive-Away Time valid for all climates, ranging from -10 to 35°C
- Very short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

Box with 12 × 300 ml cartridge, black	Item No.	496038
Box with 12 × 400 ml unipack, black	Item No.	496039
Box with 20 × 600 ml unipack, black	Item No.	496037

SikaTack® DRIVE

The Application Champion

SikaTack® DRIVE is a windscreen adhesive with superior application properties: it is the application champion on the market. SikaTack® DRIVE offers a true 60 min Safe Drive-Away Time for climates ranging from 5°C to 35°C. With Sika's all-in-one modulus technology, it is a great choice for all car makes and models.

YOUR BENEFITS

- True 60 min Safe Drive-Away Time
- Short cut-off string
- Compatible with all car makes due to Sika's all-in-one modulus technology
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

Box with 12 × 300 ml cartridge, black	Item No.	401648
Box with 12 × 400 ml unipack, black	Item No.	97234

SikaTack® MOVE Transportation

All-in-one Solution for Bus and Coach Glass Replacement

SikaTack® MOVE Transportation is a windscreen adhesive with excellent weathering stability. It is ideally suited for the replacement of bus and coach glass where it can be used for bonding as well as sealing application. SikaTack® MOVE Transportation offers a 2-hour Safe Drive-Away Time for supported windscreens.

YOUR BENEFITS

- 2-hour Safe Drive-Away Time for supported bus and coach glass*
- Excellent weathering stability; useful for exterior joint sealing
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

Box with 20 × 600 ml unipack, black	Item No.	89696

*special advice on Safe Drive-Away Time for heavy bus and coach glass is available upon request.

SikaTack® MOVE^{IT}

Everyday General Windscreen Adhesive

SikaTack® MOVE^{IT} is a cold applied automotive windscreen adhesive with a wide temperature range from -10°C to +35°C. It offers a 60 minute Safe Drive-Away Time and can be used for all passenger cars with or without airbags.

YOUR BENEFITS

- 60 min Safe Drive-Away Time
- Wide application temperature range
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

Box with 12 × 400 ml unipack, black	Item No.	523759

Sikaflex®-223

Weathering-resistant Joint Sealant

Sikaflex®-223 is a multi-purpose joint sealant with excellent adhesion on aluminium, GRP, stainless steel, 2-c coatings and organic glass (polycarbonate and PMMA). Due to its excellent weathering resistance, it is well suited for open joints. In the automotive aftermarket, it can be used for the bonding of plastic windscreens when the bond line is protected from UV light.

YOUR BENEFITS

- Excellent weathering stability; useful for sealing exterior joints
- Repair solution for plastic windscreens (bond line needs UV protection)*
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	525949
■ Box with 20 × 600 ml unipack, black	Item No.	514643
■ Box with 12 × 300 ml cartridge, white	Item No.	525948
■ Box with 20 × 600 ml unipack, white	Item No.	514644

* protection of bond line by a black frit or external protection, e.g. with Sika® UV Shielding Tape.

SikaFast®-1640

Rear Mirror Bonding Kit

SikaFast®-1640 is designed for bonding rear mirror brackets to vehicle windscreens. It is suitable for bonding glass, ceramics and metals as well as a combination of these materials. The rear mirror can be installed just minutes after the bracket has been bonded.

YOUR BENEFITS

- Ideal for bonding rear mirror brackets to windscreens
- Very fast curing to handling strength
- Easy to use
- 100% reactive substance, no solvents

AVAILABLE ITEMS

■ Box with 25 × 50 g + 10 ml kit, light yellow	Item No.	517865

SikaFast®-5211NT

SikaFast®-5211 NT is a fast curing, flexible structural adhesive designed to replace mechanical fixings such as rivets, screws or welding. It is suitable for high strength fastening of concealed joints and exhibits excellent adhesion on different types of substrates including top coats, plastics, glass, wood, etc. Suitable for bonding of complex rear mirror brackets.

YOUR BENEFITS

- Adhesion to a wide range of substrates
- Low odour
- Fast strength development

AVAILABLE ITEMS

■ Box with 12 × 10 ml syringe, grey	Item No.	466659
■ Box with 12 × 250 ml, grey	Item No.	413411

WINDSCREEN BONDING CLEANING AND PRE-TREATMENT

Sika® Cleaner PCA

Contamination Remover

A smart cleaning foam usually used in combination with Sika® Cleaner G+P, designed specifically for removing contamination that cannot be sufficiently removed with standard cleaners or without scratching the surface.
See the effect before the treatment is even finished!

We recommend using Sika® Cleaner PCA as part of the windscreen pre-treatment process. It can be used in combination with the Black-Primerless and All-Black bonding process.

YOUR BENEFITS

- Easy to use
- Highly reliable
- Multipurpose product
- Removes many kinds of contamination such as green snake contamination, fingerprints, tape residues, etc.
- Can be used for primer application

AVAILABLE ITEMS

■ Box with 168 pads, light grey	Item No.	492763
■ Box with 48 pads, light grey	Item No.	529100

Sika® Aktivator PRO

The all-season Glass Activator for Black-Primerless Bonding

This unique pre-treatment agent is specially designed to provide adhesion on automotive glass replacement substrates. Thanks to the single wipe application, Sika® Aktivator PRO simplifies the work activities, increases performance and boosts quality.

YOUR BENEFITS

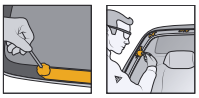
- Single wipe application
- 3 min flash-off time
- All-season technology

AVAILABLE ITEMS

■ Box with 8 × 100 ml can, colorless	Item No.	161887
■ Box with 6 × 250 ml can, colorless	Item No.	154884
■ Box with 4 × 1000 ml can, colorless	Item No.	154885

Sika® Primer-207

The All-Black Pre-treatment Solution for Automotive Glass Replacement



This multipurpose glass and paint primer is specially designed for automotive glass replacement. Sika® Primer-207 offers excellent adhesion performance as a one-step primer for float glass and ceramic-coated glass as well as OEM and aftermarket paints, PVC, PMMA, ABS and a number of other plastic materials. It is also useful as a corrosion protection primer for the AGR business.

Sika® Primer-207 is used as part of the Black-Primerless and All-Black bonding process for automotive glass replacement.

YOUR BENEFITS

- Quick drying: only takes 3 min, all year round
- One product: simplifies work procedures and inventories
- One solution for all typical AGR substrates

AVAILABLE ITEMS

■ Box with 8 × 100 ml can, black	Item No.	417301
■ Box with 6 × 250 ml can, black	Item No.	417302

Sika® Remover-208

Cleaning Agent for Surface Preparation and Removal of Uncured Adhesives

Sika® Remover-208 is used to remove uncured traces of Sikaflex® and SikaTack® products from tools and equipment. It is also suitable as a cleaner for non-porous and painted substrates prior to bonding.

AVAILABLE ITEMS

■ Box with 4 × 1000 ml can, colorless	Item No.	34288

WINDSCREEN BONDING ACCESSORIES

From intelligent repair sets to easy-to-use applicator guns, our versatile accessories help you complete your Sika toolkit and increase the productivity of your working processes.

Sika® Application Gun

The Sika® Application Gun is the ideal dispenser for one-component windscreen adhesives. It is based on the Milwaukee C18PCG but comes with a clear barrel and improved extrusion plunger, increasing the adhesive yield of unipacks.

Box contents: Sika® Application Gun, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

■ Box with 220V EU/UK CTR300 version	Item No.	425589
■ Box with 220V EU/UK UP600 version	Item No.	425591

PowerCure Dispenser

The PowerCure Dispenser is required to extrude PowerCure adhesives such as SikaTack® ELITE.

Box contents: Sika PowerCure Dispenser, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

■ Box with 220V EU/UK 2Ah	Item No.	489272

* Only registered contractors are permitted to buy the PowerCure Dispenser

Sika® Nozzle Cut

Specially designed for fast and easy V-shape cutting of adhesive cartridge nozzles.

AVAILABLE ITEMS

■ Box with Sika® Nozzle Cut	Item No.	92729

PowerCure Mixer Nozzles

PowerCure adhesives such as SikaTack® ELITE require the use of PowerCure mixing nozzles.

AVAILABLE ITEMS

■ Box with 50 units V-cut mixers	Item No.	483560
■ Box with 40 units round mixer nozzles	Item No.	496783

PowerCure Spare Parts

Spare parts for the PowerCure Dispenser are available to order online at: www.sika.com/powercure.

There is a range of spare parts available for small repairs on-site as well as the corresponding instructions.

AVAILABLE ITEMS

■ Box with Li-Ion battery 18V 2Ah	Item No.	494106
■ Box with spare cover, grey	Item No.	494111
■ Box with hand pad, black	Item No.	494112
■ Box with mixer cap, red	Item No.	494109
■ Box with tooth rack cover, red	Item No.	494118

PANEL REPLACEMENT PRODUCT RANGE

SIKA IS A KEY MANUFACTURER OF STRUCTURAL BONDING SOLUTIONS FOR VEHICLE MANUFACTURING. FOR THE REPLACEMENT OF OUTER PANELS AS WELL AS STRUCTURAL COMPONENTS OF PASSENGER CARS SIKA OFFERS A COMPLETE SYSTEM SOLUTION.

	Degreasing	**Panel bonding**		**Baffle repair**		**Protection**	
Sika products	Sika® Aktivator PRO	SikaPower®-4720		Sikaflex®-227	SikaBaffle®-278	Sikagard®-6220	Sikagard®-6470
	Sika® Remover-208			Sikaflex®-527 AT		Sikagard®-6250	
Recommendations		For outer panels*	For structural parts	For intact part	Original part lost, broken	Cavity sealing	Stone chip coating
	Only for metal and e-coat		Riveting or welding as per OEM requirements	Apply before mounting panel	Injection application after panel is mounted		

* door skins, rear body panel, roof skins, quarter panels

PANEL REPLACEMENT SYSTEM

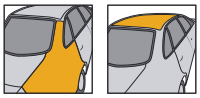
SikaPower®-4720

High Strength Panel Adhesive

SikaPower®-4720 is a toughened, high strength two-component epoxy adhesive with built-in corrosion protection and excellent adhesive properties. It is suitable for panel bonding with exposure to high dynamic stress areas. This structural adhesive can easily be spot-welded when wet.

Thatcham® Quality Assured Repair Equipment

THATCHAM APPROVAL
SikaPower®-4720 is a Thatcham-approved repair product.



YOUR BENEFITS

- Excellent adhesion performance
- Long open time with fast cure
- Conforms to OEM standards
- Over clamp protection

AVAILABLE ITEMS

- Box with 12 × 195 ml cartridge, black/white — Item No. 458296

Sika® Aktivator PRO

The all-season Glass Activator for Black-Primerless Bonding

This unique pre-treatment agent is specially designed to provide adhesion on automotive glass replacement substrates. Thanks to the single wipe application, Sika® Aktivator PRO simplifies the work activities, increases performance and boosts quality.

YOUR BENEFITS

- Single wipe application
- 3 min flash-off time
- All-season technology

AVAILABLE ITEMS

■ Box with 8 × 100 ml can, colorless	Item No.	161887
■ Box with 6 × 250 ml can, colorless	Item No.	154884
■ Box with 4 × 1000 ml can, colorless	Item No.	154885

Sika® Remover-208

Cleaning Agent for Surface Preparation and Removal of Uncured Adhesives

Sika® Remover-208 is used to remove uncured traces of Sikaflex® and SikaTack® products from tools and equipment. It is also suitable as a cleaner for non-porous and painted substrates prior to bonding.

AVAILABLE ITEMS

■ Box with 4 × 1000 ml can, colorless	Item No.	34288

Sikaflex®-227

Fast Skinning Elastic Adhesive/Sealant

Sikaflex®-227 is a one-component polyurethane adhesive/sealant, which can be painted over, and is toolable and brushable. It is suitable for various sealing and bonding applications such as hem flange seals and repairing detached noise dampening parts.

YOUR BENEFITS

- Adheres to a wide range of substrates, without primer in many cases
- Exhibits tenacious adhesion to a wide range of substrates
- Paintable
- Weather-resistant

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	1395
■ Box with 12 × 300 ml cartridge, grey	Item No.	6964
■ Box with 12 × 300 ml cartridge, white	Item No.	6965

Sikaflex®-527 AT

The Multi-Purpose Hybrid Sealant



The high-performance Sikaflex®-527 AT is a one-component hybrid sealant for multi-purpose elastic joints for both the interior and exterior of the car body. It is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound dampening measures in collision repair and vehicle body construction.

YOUR BENEFITS

- Instantly paintable with solvent and water-based paints
- Excellent tooling and finishing with paint brush or spatula
- Optimum combination of material workability and cure rate over a wide temperature range
- Permanently elastic and ageing-resistant

AVAILABLE ITEMS

■ Box with 12 × 300 ml can, black	Item No.	170783
■ Box with 12 × 300 ml can, grey	Item No.	182107
■ Box with 12 × 300 ml can, white	Item No.	170785

SikaBaffle®-278

Two-Component Acoustic Foam

SikaBaffle®-278 is a ready-to-use, fast curing, two-component polyurethane foam in an aerosol can. The product is used to seal hollow cavities against noise, air, water and dust in vehicles. A professional and safe activation system combines the two components within the can.

YOUR BENEFITS

- Excellent noise and vibration absorption
- Cured foam does not shrink or expand
- No dripping
- Good adhesion to a wide variety of substrates

AVAILABLE ITEMS

■ Box with 6 × 200 ml aerosol, black	Item No.	88989

SikaDamp®-620

Sound-absorbing Dampening Pad

SikaDamp®-620 is a sound dampening pad that is based on a specially formulated extruded butyl compound with an aluminium foil backing. It has excellent sound-dampening properties and is used to absorb structure-borne sound and resonance in sheet metal panels and other thin gauge components. The product is supplied in handy pad form.

YOUR BENEFITS

- Self-adhesive, sticks immediately on contact
- No (appreciable) creep or plastic deformation
- Can even be affixed around sharp corners and angles
- Good adhesion to all materials

AVAILABLE ITEMS

■ Box with 1 × roll of 1.8 mm × 0.5 m × 5 m, grey	Item No.	441671

Sikagard®-6220/-6220 S

High Penetrating Cavity Wax

Sikagard®-6220 are durable waxes with excellent rust-proofing properties. It provides effective protection against corrosion in vehicle body cavities and convinces with its outstanding application properties and excellent final performance. Thanks to its very high creep capability, it even protects hardly accessible areas and tight intervals perfectly.

YOUR BENEFITS

- Very high creep capability, penetration of fine hair-line cracks
- Excellent film build-up and does not drip when applied to joints
- Heat-resistant and excellent flexibility in cold temperatures
- High salt-spray resistance and outstanding water displacing effect

AVAILABLE ITEMS

Box with 12 × 1 l can, amber	Item No.	440137
Box with 12 × 500 ml aerosol, amber	Item No.	440222

Sikagard®-6250/-6250 S

Thixotropic Cavity Wax

Sikagard®-6250 are durable waxes with excellent rust-proofing properties. It provides effective protection against corrosion in vehicle body cavities and convinces with its outstanding application properties and excellent final performance. Sikagard®-6250 shows self-healing capabilities and is extremely heat-resistant.

YOUR BENEFITS

- Wash-out resistant, homogenous film build-up
- No hazing and dripping during application
- High salt-spray resistance and outstanding water displacing effect

AVAILABLE ITEMS

Box with 12 × 1 l can, white	Item No.	440220
Box with 12 × 500 ml aerosol, white	Item No.	440219

Sikagard®-6470/-6470 S

High-Performance Stone Chip Protection Coating

Sikagard®-6470 are durable, rubber-based protective coatings with excellent rust-proofing and sound-dampening properties. It provides effective protection against stone chip impacts to the vehicle body and convinces with an improved final performance. Thanks to its advanced application properties, original textures can easily be reproduced. Sikagard®-6470 is 'best-in-class' when it comes to paintability, especially with water-based paint systems.

YOUR BENEFITS

- Easy, quick and perfect restoration of original factory-finish
- Excellent paintability with water-based paint systems
- High heat resistance and excellent flexibility in cold temperatures
- Enhanced abrasion and impact resistance

AVAILABLE ITEMS

Box with 12 × 1 l can, black	Item No.	440131
Box with 12 × 500 ml aerosol, black	Item No.	440216
Box with 12 × 1 l can, grey	Item No.	440134
Box with 12 × 500 ml aerosol, grey	Item No.	440217

PANEL REPLACEMENT ACCESSORIES

FROM INTELLIGENT REPAIR SETS TO EASY-TO-USE APPLICATOR GUNS, OUR VERSATILE ACCESSORIES HELP YOU COMPLETE YOUR SIKA TOOLKIT AND INCREASE THE PRODUCTIVITY OF YOUR WORKING PROCESSES.

Sika® Application Gun

The Sika® Application Gun is the ideal dispenser for one-component windscreen adhesives. It is based on the Milwaukee C18PCG but comes with a clear barrel and improved extrusion plunger, increasing the adhesive yield of unipacks.

Box contents: Sika® Application Gun, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

■ Box with 220V EU/UK CTR300 version	Item No.	425589
■ Box with 220V EU/UK UP600 version	Item No.	425591

Sika® CW Gun

Pressure Cup Gun for Sikagard® Cavity Waxes

The Sika® CW Gun is a high-end pneumatic pressure cup gun for spraying Sikagard® cavity waxes such as Sikagard®-6220 and Sikagard®-6250.

YOUR BENEFITS

- Screw for regulating material flow
- Built-in back-pressure valves
- Quick coupling system
- 2-Step trigger
- Extra-long and thin hose with round nozzle
- Equipped with an additional hook probe

AVAILABLE ITEMS

■ Box with Sika® CW Gun	Item No.	446095

Sika® UBC^{Plus} Gun

Vacuum Gun for Sikagard® Protective Coatings

The Sika® UBC Gun is an easy-to-use vacuum gun for spraying Sikagard® underbody and stone chip protection coatings out of a 1 litre can. The Sika® UBC^{Plus} Gun also contains a hose kit for using with Sikagard® cavity waxes.

YOUR BENEFITS

- Adjustable spray nozzle for a variety of textures
- Plug-and-Play mode

AVAILABLE ITEMS

■ Box with Sika® UBC Gun	Item No.	448197
■ Box with Sika® UBC^{Plus} Gun + hose kit	Item No.	448196

Sika® SCP Gun

Pressure Cup Gun for Sikagard® Protective Coatings

The Sika® SCP Gun is a high-end pneumatic pressure cup gun for spraying Sikagard® underbody and stone chip protection coatings out of a 1 litre can, such as Sikagard®-6060, Sikagard®-6440 and Sikagard®-6470.

YOUR BENEFITS

- Pressure control valve
- Screw for regulating material flow and spray air
- Fully automatic air-pressure relief
- Threadless can connection
- No extra screw needed for regulating spray air

AVAILABLE ITEMS

■ Box with Sika® SCP Gun	Item No.	446096

Spare Static Mixer Tips for SikaPower 4720

AVAILABLE ITEMS

■ Box with 14 × bag with 15 pieces	Item No.	467658

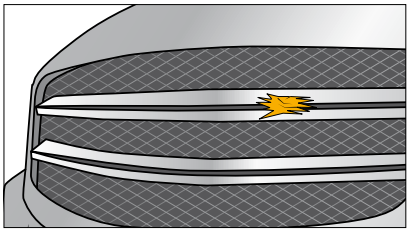
PLASTIC REPAIR PRODUCT RANGE

WITH THE SikaPower®-2900 RANGE, SIKA OFFERS A COMPLETE RANGE OF PRODUCTS FOR BUMPER REPAIR, CLIP BONDING, CLIP RESHAPING AND HEADLIGHT REPAIR APPLICATIONS IN CAR BODY REPAIR. THE PRODUCTS MAY ALSO BE SUITABLE FOR OTHER PLASTIC BONDING APPLICATIONS. THE SikaPower®-2900 RANGE EQUIPS YOUR WORKSHOP WITH A SIMPLE AND BEST-IN-CLASS ADHESIVE SYSTEM FOR A VARIETY OF PLASTIC REPAIRS.

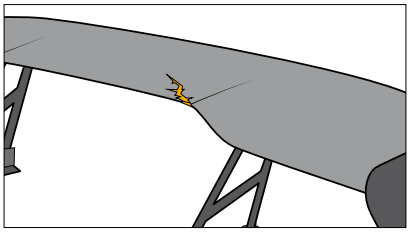
	Cleaning	Plastic Repair	
Sika Products	Sika® Cleaner G+P Cleaning of plastic parts	SikaPower®-2950 Repair of bumpers	SikaPower®-2955 Clip reshaping

SikaPower®-2950 FAST – FOR PLASTIC RE-SHAPING AND REPAIR

Radiator Grills

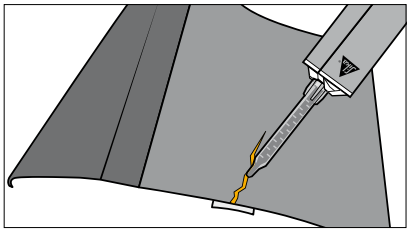


Spoilers



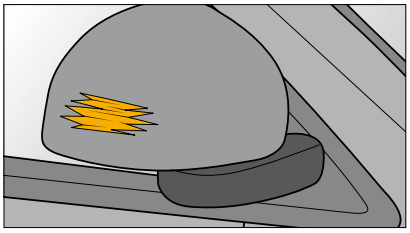
SikaPower®-2780 Plastic Putty

Bumpers

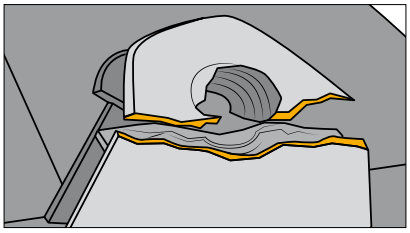


SikaPower®-2955 SUPERFAST – FOR SMALL REPAIRS AND QUICK BONDING

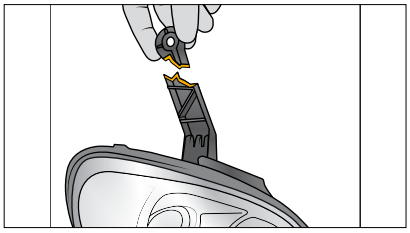
Small repair areas (less than 5 cm)



Rebuilding broken bumper tabs



Bonding brackets on headlamps



PLASTIC REPAIR SYSTEM

SikaPower®-2950

Plastic Adhesive Fast

SikaPower®-2950 is a two-component polyurethane adhesive with excellent adhesion properties. It is specifically designed for plastic repair work on bumpers and other plastic parts.

YOUR BENEFITS

- Excellent sandability
- Can be painted over with nearly all types of paint
- High impact resistance
- High strength but still elastic
- No shrinkage
- Suitable for nearly all types of plastic – use SikaPower®-2900 Primer (except PP, PTFE, PE)

AVAILABLE ITEMS

- Box with 6 × 50 ml cartridge, black — Item No. 505377

SikaPower®-2955

Plastic Adhesive Super-Fast

SikaPower®-2955 is an easy-to-use and very fast setting adhesive system for repairing small plastic damages as well as for rebuilding broken bumper tabs or bonding plastic parts such as broken brackets on headlamps.

YOUR BENEFITS

- Can be sanded after only a short time (after 10 min)
- Paintable
- Very good sag resistance (thixotropy), allowing vertical application
- Good impact resistance
- Suitable for nearly all types of plastic – use SikaPower®-2900 Primer

AVAILABLE ITEMS

- Box with 6 × 50 ml cartridge, black — Item No. 505390

PLASTIC REPAIR CLEANING AND ACCESSORIES

SikaPower®-2900 Primer

Primer for SikaPower®-2900 Plastic Repair Products

SikaPower®-2900 Primer is used to achieve improved adhesion in plastic repair applications on a broad range of different plastic substrates.

AVAILABLE ITEMS

■ Box with 6 × 200 ml aerosol, colorless Item No. 505295

Contouring Film for SikaPower®-2900 Series

Backing Material Perfect for Tab Repair

AVAILABLE ITEMS

■ Box with 30 × roll of 360 cm, transparent Item No. 505296

Reinforcement Film for SikaPower®-2900 Series

Reinforcing the Back of Plastic Repairs

AVAILABLE ITEMS

■ Box with 20 × roll of 360 cm, transparent Item No. 505297

Mixer Tips for SikaPower®-2900 Series

For Achieving the Perfect Mix of Both Adhesive Components

AVAILABLE ITEMS

■ Box with 20 × 12 pc bag, green Item No. 505298

Dispensing Gun for SikaPower®-2900 Series

High-quality Manual Dispensing Gun for High-performance Applications

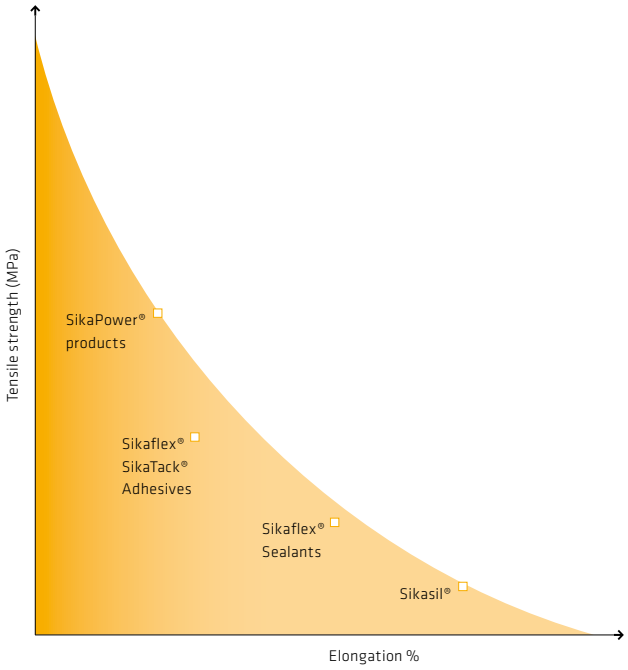
AVAILABLE ITEMS

■ Box with Dispenser SikaPower®-2900 Series Item No. 512113

COMPONENT BONDING PRODUCT RANGE

SIKA OFFERS A RANGE OF ELASTIC AND STRUCTURAL BONDING SOLUTIONS FOR VARIOUS APPLICATIONS IN THE CAR REPAIR SHOP.

ELASTIC BONDING	STRUCTURAL BONDING
Sikaflex® and SikaTack® adhesive systems are used when a combination of different materials and different material heat expansion properties come into the picture. Elastic adhesives are typically used with a joint thickness of 4 mm.	Structural bonding is the most effective joining technique used in the body shop. Car manufacturers around the world rely on SikaPower® adhesives for a broad range of applications.
Sikaflex®-252	SikaPower®-4720
Sikaflex®-552 AT	SikaFast®-5211 NT
Sikaflex®-260 N	



Sika's Advanced Technology «AT»
Advanced Technology «AT» products are based on a new type of hybrid polymer that was developed by Sika's own research and development department. It is a marriage between the successful Sika® PUR Technology and the well-known Modified Silicone Technology (MS Polymers).

Benefits of AT Products

- Adheres without primer to all substrates commonly used in body shops
- Outstanding application properties
- Excellent smoothing/tooling properties at both low and high temperatures
- Odourless, solvent-, isocyanate-, silicone and PVC-free products
- Ageing- and weathering-resistant

ELASTIC BONDING SOLUTIONS

Sikaflex®-552 AT

The High-Performance Hybrid Adhesive

Sikaflex®-552 AT is a high-performance, elastic gap-filling, one-component hybrid assembly adhesive for vehicle body panels and accessories. It is suitable for structural joints that are subjected to dynamic stresses.

YOUR BENEFITS

- Excellent adhesion to a wide variety of substrates without using a primer
- Ageing-resistant, vibration-, impact- and shock-resistant
- Can be painted over with water-based paint systems
- Fast curing, excellent non-sag properties and high green strength

AVAILABLE ITEMS

Box with 12 × 300 ml cartridge, black	Item No.	182104
Box with 20 × ,600 ml unipack, black	Item No.	438611
Box with 12 × 300 ml cartridge, white	Item No.	182103
Box with 20 × 600 ml unipack, white	Item No.	170795

Sikaflex®-252

Assembly Adhesive

Sikaflex®-252 is suitable for structural joints that will be subjected to dynamic stresses. Suitable substrate materials are timber, metals, particularly aluminium (incl. anodized components), sheet steel (incl. phosphated, chromated and zinc-plated components), metal primers and paint coatings (2-c systems), ceramic materials and plastics.

YOUR BENEFITS

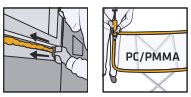
- Can be painted over
- Good gap-filling properties
- Bonds well to a wide variety of substrates

AVAILABLE ITEMS

Box with 12 × 300 ml cartridge, black	Item No.	7195
Box with 20 × 600 ml unipack, black	Item No.	7194
Box with 12 × 300 ml cartridge, white	Item No.	1375
Box with 20 × 600 ml unipack, white	Item No.	1372
Box with 20 × 600 ml unipack, grey	Item No.	28193

Sikaflex®-223

Weathering-resistant Joint Sealant



Sikaflex®-223 is a multi-purpose joint sealant with excellent adhesion to aluminium, GRP, stainless steel, 2-c coatings and organic glass (polycarbonate and PMMA). Due to its excellent weathering resistance, it is well suited for open joints. In the automotive aftermarket, it can be used for the bonding of plastic windscreens when the bond line is protected from UV light.

YOUR BENEFITS

- Excellent weathering stability; useful for sealing exterior joints
- Repair solution for plastic windscreens (bond line needs UV protection)*
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

Box with 12 × 300 ml cartridge, black	Item No.	525949
Box with 12 × 300 ml cartridge, white	Item No.	525948

* protection of bond line by a black frit or external protection, e.g. with Sika® UV Shielding Tape.

STRUCTURAL BONDING SOLUTIONS

SikaPower®-2955

Plastic Adhesive Super-Fast

SikaPower® 2955 is an easy-to-use and very fast setting adhesive system for repairing small plastic damages as well as for rebuilding broken bumper tabs or bonding plastic parts such as broken brackets on headlamps.

YOUR BENEFITS
- Can be sanded after only a short time (after 10 min)
- Paintable
- Very good sag resistance (thixotropy), allowing vertical application
- Good impact resistance
- Suitable for nearly all types of plastic – use SikaPower®-2900 Primer

AVAILABLE ITEMS
- Box with 6 × 50 ml cartridge, black — Item No. 505390

SikaPower®-4720

High Strength Panel Adhesive

SikaPower®-4720 is a toughened, high strength two-component epoxy adhesive with built-in corrosion protection and excellent adhesive properties. It is suitable for panel bonding with exposure to high dynamic stress areas. This structural adhesive can easily be spot-welded, even when wet.

Thatcham® Quality Assured Repair Equipment

THATCHAM APPROVAL
SikaPower®-4720 is a Thatcham-approved repair product.

YOUR BENEFITS
- Excellent adhesion performance
- Long open time with fast cure
- Conforms to OEM standards
- Over clamp protection

AVAILABLE ITEMS
- Box with 12 × 195 ml cartridge, black/white — Item No. 458296

SikaFast®-5211 NT

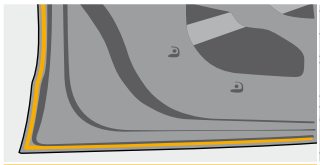
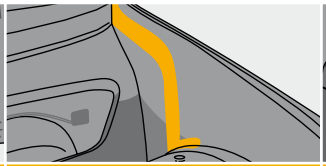
SikaFast®-5211 NT is a fast curing, flexible structural adhesive designed to replace mechanical fixings such as rivets, screws or welding. It is suitable for high strength fastening of concealed joints and exhibits excellent adhesion on different types of substrates including top coats, plastics, glass, wood, etc. Suitable for bonding of complex rear mirror brackets.

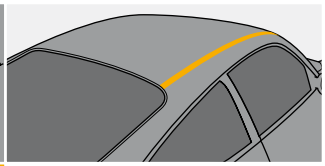
YOUR BENEFITS
- Adhesion to a wide range of substrates
- Low odour
- Fast strength development

AVAILABLE ITEMS
- Box with 12 × 10 ml syringe, grey — Item No. 466659
- Box with 12 × 250 ml, grey — Item No. 413411

SEALING PRODUCT RANGE

BACKED BY UNRIVALLED EXPERTISE IN AUTOMOTIVE APPLICATIONS, OUR ADVANCED PORTFOLIO OF ONE-COMPONENT Sikaflex® SEALANTS HAS BEEN SPECIFICALLY DESIGNED TO PROVIDE A FAST, EASY SOLUTION IN THE AUTOMOTIVE CAR BODY REPAIR PROCESS. THE BROAD RANGE OF SIKA SEALANTS INCLUDE SOLUTIONS FOR SEAM SEALING, SPRAY- AND BRUSHABLE SEAM APPLICATIONS, AS WELL AS FOR BONDING SMALL PARTS ON TO THE VEHICLE.



Standard sealants	Brushable sealants	Sprayable sealants	Self-levelling sealants
Hem flange seals Body seams Lap joints Roof ditch seals	Surface application Seams, flanges, lap joints	Interior spray seams Exterior spray seams	Roof ditch Seals
Sikaflex®-227 Sikaflex®-527 AT Sikaflex®-215	Sikaflex®-227 Sikaflex®-527 AT Sikaflex®-529 AT Sikaflex®-215 Sikagard®-6300	Sikaflex®-529 AT	

Sikaflex® AT Series

Products in the Sikaflex® AT series utilize a new type of hybrid polymer that encompasses the best properties of our PU and modified silicone (MS) technologies. Designed for easy application with low emissions, they are ideal for a wide range of sealing and bonding applications.

Backed by more than 2000 paint adhesion tests, our Sikaflex® AT products work well with modern paint systems. They can be applied wet-on-wet, or after a longer period, regardless of the climatic conditions.

The Sikaflex® AT series for seam sealing provides an ageing-resistant and permanently elastic seal, with good adhesion to all of the most commonly used materials, including metal primers, paint coatings, metals, painted plastics and plastics.

SEALING SOLUTIONS

Sikaflex®-527 AT

The Multi-Purpose Hybrid Sealant

The high-performance Sikaflex®-527 AT is a one-component hybrid sealant for multi-purpose elastic joints for both the interior and exterior of the car body. It is suitable for sealing, seam sealing, simple bonding as well as for vibration reduction and sound dampening measures in collision repair and vehicle body construction.

YOUR BENEFITS

- Instantly paintable with solvent and water-based paints
- Excellent tooling and finishing with paint brush or spatula
- Optimum combination of material workability and cure rate over a wide temperature range
- Permanently elastic and ageing-resistant

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	170783
■ Box with 12 × 300 ml cartridge, grey	Item No.	182107
■ Box with 12 × 300 ml cartridge, white	Item No.	170785

Sikaflex®-227

Fast Skinning Elastic Adhesive/Sealant

Sikaflex®-227 is a one-component polyurethane adhesive/sealant, which can be painted over, and is toolable and brushable. It is suitable for various sealing and bonding applications such as hem flange seals and repairing detached noise dampening parts.

YOUR BENEFITS

- Adheres to a wide range of substrates, without primer in many cases
- Exhibits tenacious adhesion to a wide range of substrates
- Paintable
- Weather-resistant

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	1395
■ Box with 12 × 300 ml cartridge, grey	Item No.	6964
■ Box with 12 × 300 ml cartridge, white	Item No.	6965

Sikaflex®-215

Brushable Sealant for Chassis and Body Structures

Sikaflex®-215 is a high-quality, low-viscous one-component polyurethane sealant that can be used for brush applications. It can be painted over and is compatible with low temperature paint processes, making it the perfect solution for chassis and body structure sealing applications.

YOUR BENEFITS

- Can be painted over
- Excellent workability, easy brush application
- Very fast skinning
- Withstands paint ovens

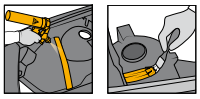
AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, white	Item No.	481017

Sikaflex®-529 AT

The Sprayable and Brushable Hybrid Sealant

The one-component Sikaflex®-529 AT is designed to be used as a sprayable and brushable elastic sealant (surface areas and beads) for seam sealing and lap joints in vehicle body constructions and to restore the original factory finish in collision repairs. Where applied, Sikaflex®-529 AT improves the resistance against stone chips and other small objects that come into contact with the car body.



YOUR BENEFITS

- Can be painted over instantly with solvent and water-based paints
- Sprayable but bead application is also possible with excellent tooling properties
- No overspray and advanced non-sag properties
- Permanently elastic and ageing-resistant

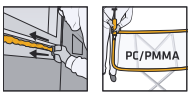
AVAILABLE ITEMS

■ Box with 12 × 290 ml cartridge, ochre	Item No.	409007
■ Box with 12 x 290 ml cartridge, black	Item No.	408986
■ Box with 12 x 290 ml cartridge, light grey	Item No.	528208
■ Box with 12 × 300 ml unipack, ochre	Item No.	171196

Sikaflex®-223

Weathering-resistant Joint Sealant

Sikaflex®-223 is a multi-purpose joint sealant with excellent adhesion on aluminium, GRP, stainless steel, 2-c coatings and organic glass (polycarbonate and PMMA). Due to its excellent weathering resistance, it is well suited for open joints. In the automotive aftermarket, it can be used for the bonding of plastic windscreens when the bond line is protected from UV light.



YOUR BENEFITS

- Excellent weathering stability; useful for sealing exterior joints
- Repair solution for plastic windscreens (bond line needs UV protection)*
- Compatible with Sika's Black-Primerless and All-Black bonding process

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	525949
■ Box with 20 × 600 ml unipack, black	Item No.	514643
■ Box with 12 × 300 ml cartridge, white	Item No.	525948
■ Box with 20 × 600 ml unipack, white	Item No.	514644

* protection of bond line by a black frit or external protection, e.g. with Sika® UV Shielding Tape.

Sikaflex®-521 UV

Excellent Weathering-resistant Sealant

Sikaflex®-521 UV is a multi-purpose, non-sag, elastic 1-c sealant based on a polyurethane-hybrid compound. It bonds well to a wide variety of substrates and is suitable for making permanent, high-bonding strength elastic seals. Suitable substrate materials are timber, metals, metal primers and paint coatings (2-c systems), ceramic materials and plastics.

YOUR BENEFITS

- UV, ageing- and weathering-resistant
- Bonds well to a wide variety of substrates without the need for special pre-treatment
- Can be painted over
- Silicone and PVC-free

AVAILABLE ITEMS

■ Box with 12 × 300 ml cartridge, black	Item No.	60179
■ Box with 12 × 300 ml cartridge, grey	Item No.	62139
■ Box with 12 × 300 ml cartridge, white	Item No.	54864

Sikaflex® AutoTape

High-Performance Seam Sealing Tape

Sikaflex® AutoTape is a unique sealing tape for fast, easy and clean seam sealing application in the automotive aftermarket. It is used for repairing sealing on doors, trunks and hoods on passenger cars, trucks, busses and other vehicles.

YOUR BENEFITS

- Fast, easy and clean application
- Can be painted over immediately after application
- Achieves 'new car' standard of finish

AVAILABLE ITEMS

■ Box with 10 × roll of 6 mm × 16 m, white	Item No.	448567
■ Box with 10 × roll of 8 mm × 16 m, white	Item No.	448568
■ Box with 10 × roll of 10 mm × 16 m, white	Item No.	448569

Sikagard®-6300

Brushable Seam Sealer

Sikagard®-6300 is a brushable seam sealer that has been formulated to allow body shops to recreate OEM brushed finishes. It is mostly used on overlap joints and seams, shock absorber mountings, floor pans and bulkheads etc. It dries quickly leaving visible brush marks and shows good adhesion on different metals.

YOUR BENEFITS

- One-component
- Brushable
- Can be painted over
- Recreates OEM brushed finishes

AVAILABLE ITEMS

■ Box with 12 × 1 kg can, grey	Item No.	116335

SikaPower®-415 P1

Moisture Pre-Curable/Heat-Curing Body Shop Sealant

SikaPower®-415 P1 is a one-component, cold-applied, humidity or thermal pre-curable, heat curing sealant based on epoxy and polyurethane. It is designed for sealing seams or joints for sheet metal assembly work and is cured with heat, i.e. in the electrocoat oven, to form an elastic thermoset.

YOUR BENEFITS

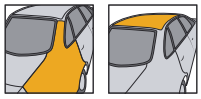
- One-component
- Adheres well to oily substrates
- Pre-cures by exposure to atmospheric moisture at ambient temperatures
- Good wash-out resistance after pre-curing
- Suitable for sealing various metals, e.g. steel, aluminium, zinc-coated steel, etc.
- Can be electro- or powder-coated after pre-curing

AVAILABLE ITEMS

■ Box with 12 × 400 g cartridge, black	Item No.	85055

SikaPower®-4720

High Strength Panel Adhesive



SikaPower®-4720 is a toughened, high strength two-component epoxy adhesive with built-in corrosion protection and excellent adhesive properties. It is suitable for panel bonding with exposure to high dynamic stress areas. This structural adhesive can easily be spot-welded when wet.

YOUR BENEFITS

- Excellent adhesion performance
- Long open time with fast cure
- Conforms to OEM standards
- Over clamp protection

AVAILABLE ITEMS

■ Box with 12 × 195 ml cartridge, black/white	Item No.	458296

SEALING AND COMPONENT BONDING CLEANING AND PRE-TREATMENT

Sika® Aktivator-100

Sika® Aktivator-100 improves adhesion on substrates such as glass, ceramic coated glass, the cut face of old polyurethane adhesive, polyurethane pre-applied windows, and paints.

Compatibility and use of the product according to the pre-treatment chart on page 66 or as per specific recommendations.

AVAILABLE ITEMS

■ Box with 6 × 250 ml can, colorless	Item No.	1431

Sika® Aktivator-205

Sika® Aktivator-205 is an alcohol solution containing a bond-activating substance designed for the activation of surfaces prior to bonding and sealing with Sika® products.

Compatibility and use of the product according to the pre-treatment chart on page 66 or as per specific recommendations.

AVAILABLE ITEMS

■ Box with 6 × 250 ml can, colorless	Item No.	3210

Sika® Aktivator PRO

The All-season Glass Activator for Black-Primerless Bonding

This unique pre-treatment agent is specially designed to provide adhesion on automotive glass replacement substrates. Thanks to the single wipe application, Sika® Akti-vator PRO simplifies the work activities, increases performance and boosts quality.

YOUR BENEFITS

- Single wipe application
- 3 min flash-off time
- All-season technology

AVAILABLE ITEMS

■ Box with 8 × 100 ml can, colorless	Item No.	161887
■ Box with 6 × 250 ml can, colorless	Item No.	154884
■ Box with 4 × 1000 ml can, colorless	Item No.	154885

Sika® Primer-207

The All-Black Pre-treatment Solution for Automotive Glass Replacement

This multipurpose glass and paint primer is specially designed for automotive glass replacement. Sika® Primer-207 offers excellent adhesion performance as a one-step primer for float glass and ceramic-coated glass as well as OEM and aftermarket paints, PVC, PMMA, ABS and a number of other plastic materials. It is also useful as a corrosion protection primer for the AGR business.

YOUR BENEFITS

- Quick drying: only takes 3 min, all year round
- One product: simplifies work procedures and inventories
- One solution for all typical AGR substrates

AVAILABLE ITEMS

■ Box with 8 × 100 ml can, black	Item No.	417301
■ Box with 6 × 250 ml can, black	Item No.	417302

Sika® Primer-210

Sika® Primer-210 is used to improve the adhesion of Sikaflex® adhesives on many metals such as aluminium and galvanized steel, plastics and paint-primed substrates.

Compatibility and use of the product according to the pre-treatment chart on page 66 or as per specific recommendations.

AVAILABLE ITEMS

■ Box with 6 × 250 ml can, colorless — Item No. 155720

Sika® Primer-215

Sika® Primer-215 is suitable for application on the following substrates: plastics such as GRP, epoxy resins, PVC, ABS and timber. Sika® Primer-215 must not be used on plastics that are prone to stress cracking, such as acrylics or polycarbonates.

Compatibility and use of the product according to the pre-treatment chart on page 66 or as per specific recommendations.

AVAILABLE ITEMS

■ Box with 6 × 250 ml can, colorless — Item No. 1428

Sika® Remover-208

Cleaning Agent for Surface Preparation and Removal of Uncured Adhesives

Sika® Remover-208 is used to remove uncured traces of Sikaflex® and SikaTack® products from tools and equipment. It is also suitable as a cleaner for non-porous and painted substrates prior to bonding.

AVAILABLE ITEMS

■ Box with 4 × 1000 ml can, colorless — Item No. 34288

SEALING AND COMPONENT BONDING ACCESSORIES

Sika® Application Gun

The Sika® Application Gun is the ideal dispenser for one-component windscreen adhesives. It is based on the Milwaukee C18PCG but comes with a clear barrel and improved extrusion plunger, increasing the adhesive yield of unipacks.

Box contents: Sika® Application Gun, 2Ah 18V Li-ion rechargeable battery, charger with EU/CH cord, spare parts set, documentation.

AVAILABLE ITEMS

■ Box with 220V EU/UK CTR300 version	Item No.	425589
■ Box with 220V EU/UK UP600 version	Item No.	425591

Sika® Spray Gun

The Multi-Purpose Application Gun for Spray Seams

The Sika® Spray Gun has been specially adapted for use with the sprayable Sika-flex®-529 AT sealant. It works with compressed air and is designed to use PE cartridges. This gun will produce a smooth spray finish along seams, folds and lap joints.

AVAILABLE ITEMS

■ Box with Sika® Spray Gun	Item No.	180319

PROTECTIVE COATINGS PRODUCT RANGE

Sikagard® PROTECTIVE COATINGS ARE DESIGNED AND TESTED FOR MAXIMUM EFFICIENCY IN PROFESSIONAL BODY SHOPS. THEY SPEED UP OPERATIONS AND ENSURE THE PERFECT RESTORATION OF OEM FINISHES. RESTORING THE VEHICLE TO ITS ORIGINAL APPEARANCE IS THE PRIME CONCERN OF THE OWNER. AS A RESULT, PROFESSIONAL CAR BODY AND PAINT SHOPS ARE CONFRONTED WITH HUGE DEMANDS THAT ARE DIFFICULT TO SATISFY.

Sikagard® PRODUCTS ARE ADVANCED PROTECTIVE COATINGS THAT ARE TAILORED TO THE SPECIFIC REQUIREMENTS OF CAR BODY SHOPS. THEY OFFER BEST-IN-CLASS APPLICATION PERFORMANCE AND ARE DESIGNED TO PERFORM UNDER EXTREME ENVIRONMENTAL CONDITIONS.

Product selection guide

	Under-body coating	Stone chip protection	Cavity wax	Use for engine conservation	Creep capability	Oven drying	Infra red drying	Drying temperature	Touch dry	Paintable	Drive-away time	Service temperature
Sikagard®-6060	✓			–	–	No	No	23°C	75 min	No	3.5 h	–25°C / +80°C
Sikagard®-6060 S	✓			–	–	No	No	23°C	75 min	No	2.5 h	–25°C / +80°C
Sikagard®-6440	✓	✓		–	–	Max 60°C	Max 40°C	23°C	60 min	24 h	180 min	–30°C / +90°C
								40°C	40 min	6 h	90 min	
								60°C	20 min	4 h	60 min	
Sikagard®-6440 S	✓	✓		–	–	Max 40°C	Max 40°C	23°C	30 min	16 h	120 min	–25°C / +80°C
								40°C	20 min	5 h	45 min	
								60°C	–	–	–	
Sikagard®-6470		✓		–	–	Max 60°C	Max 40°C	23°C	45 min	60 min	120 min	–40°C / +90°C
								40°C	15 min	45 min	60 min	
								60°C	15 min	30 min	45 min	
Sikagard®-6470 S		✓		–	–	Max 40°C	Max 40°C	23°C	10 min	20 min	30 min	–25°C / +80°C
								40°C	10 min	20 min	30 min	
								60°C	–	–	–	
Sikagard®-6220			✓	No	High	–	–	23°C	60 min	–	3 h	–50°C / +75°C
Sikagard®-6220 S			✓	No	High	–	–	23°C	45 min	–	2 h	–50°C / +75°C
Sikagard®-6250			✓	Yes	Low	–	–	23°C	105 min	–	5 h	–25°C / +180°C
Sikagard®-6250 S			✓	No	Low	–	–	23°C	60 min	–	3 h	–25°C / +75°C

PROTECTIVE COATINGS RANGE

Sikagard®-6060/-6060 S

Corrosion-Resistant Underbody Coating

Sikagard®-6060 are spray applied anti-corrosion coatings for the repair and protection of non-visible areas such as underbody parts of vehicles that do not need to be painted over, as well as for vibration reduction and sound dampening on underbody parts. The product can be sprayed haze-free without any cob webbing. It does not drip and shows good adhesion on different paints, metal primers, metals and PVC without any pre-treatment.

YOUR BENEFITS

- Excellent corrosion resistance and "self-healing" effect
- High film thicknesses
- No running or dripping even at high film thicknesses
- Top adhesion performance
- Fast drying

AVAILABLE ITEMS

- Box with 12 × 1 l can, black — Item No. 440118
- Box with 12 × 500 ml aerosol, black — Item No. 440218

Sikagard®-6440/-6440 S

Underbody and Stone Chip Protection Coating



Sikagard®-6440 are durable, thixotropic, rubber-based protective coatings with very good rust-proofing and sound-dampening properties. The product is effective for protecting the underbody and the vehicle body against stone chips. It can easily reproduce the original texture, and also performs well when painted over.

YOUR BENEFITS

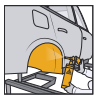
- All-in-one solution for underbody coating, stone chip protection and sound dampening
- Variety of textures achievable (does not apply to Sikagard®-6440 S)
- Excellent performance regarding paintability. Good abrasion resistance and adhesion performance

AVAILABLE ITEMS

- Box with 12 × 1 l can, black — Item No. 440206
- Box with 12 × 1 l can, grey — Item No. 440207
- Box with 12 × 500 ml aerosol, black — Item No. 440208

Sikagard®-6470/-6470 S

High-Performance Stone Chip Protection Coating




Sikagard®-6470 are durable, rubber-based protective coatings with excellent rust-proofing and sound-dampening properties. It provides effective protection against stone chip impacts to the vehicle body and convinces with an improved final performance. Thanks to its advanced application properties, original textures can easily be reproduced. Sikagard®-6470 is 'best-in-class' when it comes to paintability, especially with water-based paint systems.

YOUR BENEFITS

- Easy, quick and perfect restoration of original factory-finish
- Excellent paintability with water-based paint systems
- High heat resistance and excellent flexibility in cold temperatures
- Enhanced abrasion and impact resistance

AVAILABLE ITEMS

- Box with 12 × 1 l can, black — Item No. 440131
- Box with 12 × 500 ml aerosol, black — Item No. 440216
- Box with 12 × 1 l can, grey — Item No. 440134
- Box with 12 × 500 ml aerosol, grey — Item No. 440217

Sikagard®-6220/-6220 S

High Penetrating Cavity Wax

Sikagard®-6220 are durable waxes with excellent rust-proofing properties. It provides effective protection against corrosion in vehicle body cavities and convinces with its outstanding application properties and excellent final performance. Thanks to its very high creep capability, it even protects hardly accessible areas and tight intervals perfectly.

YOUR BENEFITS

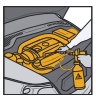
- Very high creep capability, penetration of fine hair-line cracks
- Excellent film build-up and does not drip when applied to joints
- Heat-resistant and excellent flexibility in cold temperatures
- High salt-spray resistance and outstanding water displacing effect

AVAILABLE ITEMS

■ Box with 12 × 1 l can, amber	Item No. 440137
■ Box with 12 × 500 ml aerosol, amber	Item No. 440222

Sikagard®-6250/-6250 S

Thixotropic Cavity Wax



Sikagard®-6250 are durable waxes with excellent rust-proofing properties. It provides effective protection against corrosion in vehicle body cavities and convinces with its outstanding application properties and excellent final performance. Sikagard®-6250 shows self-healing capabilities and is extremely heat-resistant.

YOUR BENEFITS

- Wash-out resistant, homogenous film build-up
- No hazing and dripping during application
- High salt-spray resistance and outstanding water displacing effect

AVAILABLE ITEMS

■ Box with 12 × 1 l can, white	Item No. 440220
■ Box with 12 × 500 ml aerosol, white	Item No. 440219

PROTECTIVE COATINGS ACCESSORIES

FROM INTELLIGENT REPAIR SETS TO EASY-TO-USE APPLICATOR GUNS, OUR VERSATILE ACCESSORIES HELP YOU COMPLETE YOUR SIKA TOOLKIT AND INCREASE THE PRODUCTIVITY OF YOUR WORKING PROCESSES.

Sika® SCP Gun

Pressure Cup Gun for Sikagard® Protective Coatings

The Sika® SCP Gun is a high-end pneumatic pressure cup gun for spraying Sikagard® underbody and stone chip protection coatings out of a 1 litre can, such as Sikagard®-6060, Sikagard®-6440 and Sikagard®-6470.

YOUR BENEFITS

- Pressure control valve
- Screw for regulating material flow and spray air
- Fully automatic air-pressure relief
- Threadless can connection
- No extra screw needed for regulating spray air

AVAILABLE ITEMS

■ Box with Sika® SCP Gun	Item No.	446096

Sika® UBC^{Plus} Gun

Vacuum Gun for Sikagard® Protective Coatings

The Sika® UBC Gun is an easy-to-use vacuum gun for spraying Sikagard® underbody and stone chip protection coatings out of 1 litre cans. The Sika® UBC^{Plus} Gun also contains a hose kit for using with Sikagard® cavity waxes.

YOUR BENEFITS

- Adjustable spray nozzle for a variety of textures
- Plug-and-Play mode

AVAILABLE ITEMS

■ Box with Sika® UBC Gun	Item No.	448197
■ Box with Sika® UBC^{Plus} Gun + hose kit	Item No.	448196

Sika® CW Gun

Pressure Cup Gun for Sikagard® Cavity Waxes

The Sika® CW Gun is a high-end pneumatic pressure cup gun for spraying Sikagard® cavity waxes such as Sikagard®-6220 and Sikagard®-6250.

YOUR BENEFITS

- Screw for regulating material flow
- Built-in back-pressure valves
- Quick coupling system
- 2-Step trigger
- Extra-long and thin hose with round nozzle
- Equipped with an additional hook probe

AVAILABLE ITEMS

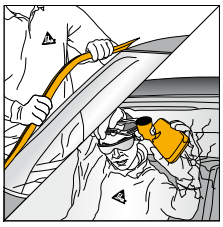
■ Box with Sika® CW Gun	Item No.	446095

Sikagard®

Protective coatings for car body repair
performance under severe conditions

TIPS AND TRICKS

BLACK-PRIMERLESS PROCESS AUTOMOTIVE GLASS REPLACEMENT

1 

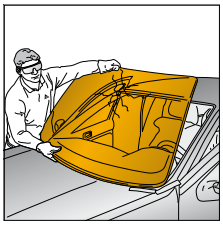
- Remove all decorative trims

2 

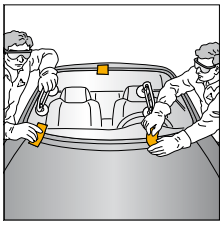
- Cover the aperture with masking tape

3 

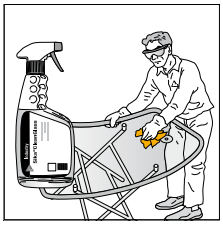
- Cut out damaged windscreen using an electrical knife, cutting wire, cold knife etc.

4 

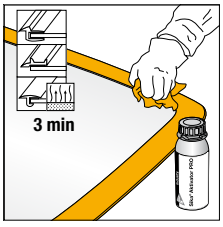
- Remove damaged windscreen

5 

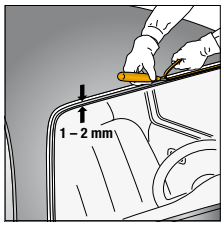
- Dry fit new windscreen

6 

- Clean the new windscreen with Sika® Cleaner G+P

7 

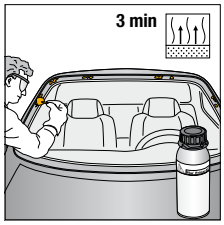
- Activate the bonding surface of the glass using Sika® Aktivator PRO

8 

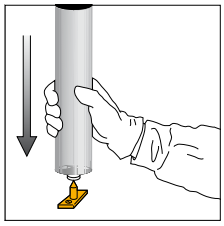
- Trim back the remaining adhesive bead to 1-2 mm

9 

- Clean the aperture using Sika® Cleaner G+P and activate the remaining bead with Sika® Aktivator PRO

10 

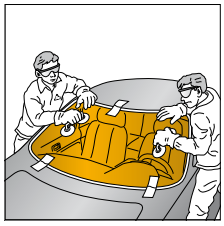
- Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification

11 

- Open the cartridge or the unipack

12 

- Apply a triangular bead of adhesive either to the glass or the aperture

13 

- Place the windscreen in position within the open time of the adhesive

14 

- Refit trims and mouldings

BONDING SURFACE	BLACK PRIMERLESS PROCESS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5 cm^2	● ●
Bare Metal 5 cm^2 to 150 cm^2	● ● ●
Intact OEM Paint	● ●
Repair Paint (after complete curing of paint)	● ●
PVC/RIM Encapsulation	● ●
Fresh Cut Bead	●
Pre-applied adhesive system	●
Polycarbondate**	● ●
PMMA**	● ●

● = Sika® Primer-207 ● = Sika® Aktivator PRO

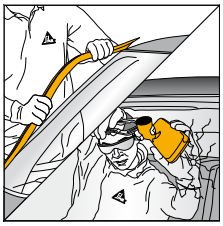
* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.

ALL BLACK PROCESS
AUTOMOTIVE GLASS REPLACEMENT

1



- Remove all decorative trims

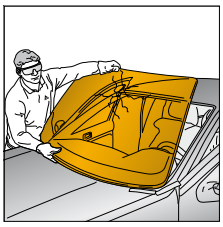
2

- Cover the aperture with masking tape

3

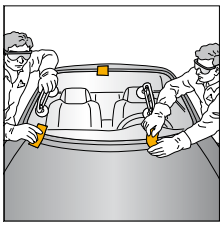
- Cut out damaged windscreen using an electrical knife, cutting wire, cold knife etc.

4



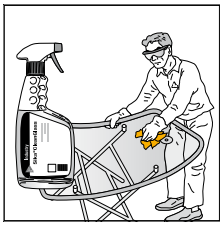
- Remove damaged windscreen

5



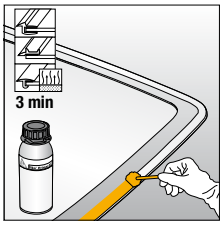
- Dry fit new windscreen

6



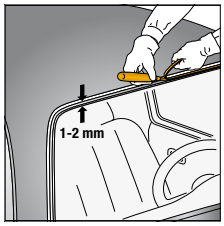
- Clean the new windscreen with Sika® Cleaner G+P

7



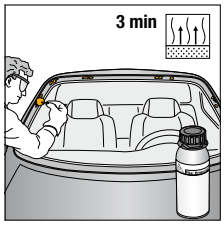
- Prime the bonding surface of the glass using Sika® Primer-207

8



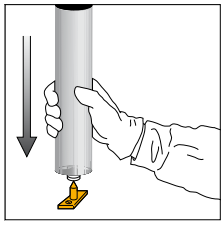
- Trim back the remaining adhesive bead to 1-2 mm

9



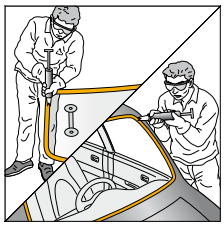
- Cover any minor damage to paint work using Sika® Primer-207. In case of larger areas contact your body shop or refer to the car manufacturer's specification

10



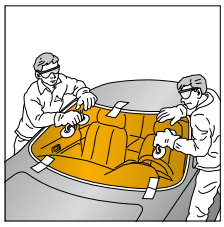
- Open the cartridge or the unipack

11



- Apply a triangular bead of adhesive either to the glass or the aperture

12



- Place the windscreen in position within the open time of the adhesive

13

- Refit trims and mouldings

BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5 cm²	●
Bare Metal 5 cm² to 150 cm²	●●
Intact OEM Paint	●
Repair Paint (after complete curing of paint)	●
PVC/RIM Encapsulation	●
Fresh Cut Bead	Optional / ●
Pre-applied adhesive system	Optional / ●
Polycarbondate**	●
PMMA**	●

● = Sika® Primer-207

* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

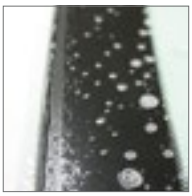
** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.

CONTAMINATION REMOVAL

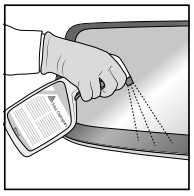
In general, Sika® Cleaner G+P is ideal for removing traditional forms of surface contamination such as dirt, dust and skin oils that are commonly found on automotive glass parts. However, it has been Sika's experience that many parts contain so-called non-traditional contaminants that require additional treatment. The nature and quantity of such non-traditional contaminants can vary significantly. Generally, the source of this contamination is the manufacturing process itself.

- Mould release agents associated with encapsuled parts (where trim is bonded to the part)

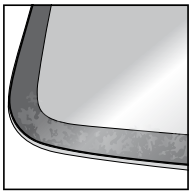


- Silicone residue from a vacuum tube laminating process which is used for the lamination process of laminated safety glass

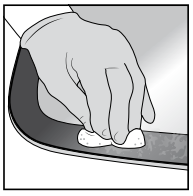
Recommended Procedure



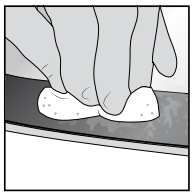
1st step: Wet glass



2nd step: Check contamination



3rd step: Use fresh unit Sika® Cleaner PCA. Start cleaning ceramic frit



4th step: Immediate detection of removal effect visible

5th step: Dry with paper towel

BONDING PLASTIC WINDSCREENS (PMMA AND PC)

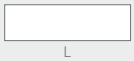
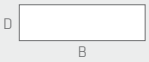
Plastic windscreens can be found on vehicles such as:
- Construction machines
- Special purpose vehicles (police, army, etc.)
- Lightweight construction vehicles
- Roof modules on some vehicles

Typical materials used are PMMA (polymethacrylate) and PC (polycarbonate). In the manufacturing process, many polycarbonate sheets are coated with a scratch-resistant surface. Unlike standard float glass, plastic windscreens have a much higher thermal expansion coefficient, resulting in greater movement (expansion and contraction of the window). In addition, plastic windscreens do not have ceramic coating on the glass, nor any other integrated UV protection for the bond line. For these reasons, the following procedures must be followed when bonding plastic windscreens.

Permanent glazing
If the coating is unknown, it is recommended to test the surface before bonding (contact Sika for support); otherwise, use the following procedure:

Step 1	Abrade the bonding area with an abrasive pad (e.g. from sia Abrasives) or sand paper	Remove scratch-resistant coating on the bonding area
Step 2	Remove dust and clean surface with Sika® Cleaner G+P	Clean surface from dust
Step 3	Apply Sika® Primer-207, flash off for 10 minutes	Create suitable surface for bonding
Step 4	Apply Sikaflex®-223. Layer thickness as per table below	Bonding

Adhesive Thickness

LARGEST WINDSCREEN LENGTH	TRIANGULAR BEAD REQUIRED		ADHESIVE BEAD DIMENSION*	
				
L (m)	H (mm)	B (mm)	D (mm)	B (mm)
0.5	8	6	4	6
1.0	8	8	4	8
1.5	12	10	6	10
2.0	16	12	8	12
Over 2.0 Meter			contact Sika	

* important: confirm to minimal adhesives thickness, D.

UV protection
To ensure a durable bond, the bond line of transparent windscreens must be protected against UV light. Possible solutions are:
- Suitable print color
- Protective metal or opaque plastic trims
- Sika® UV Shielding Tape

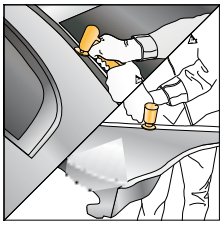
Without UV protection, Sika® Primer-207 will eventually wear off on the plastic windscreen. The exact point at which this will result in a failure depends largely on the weather, the quality of the synthetic material and the general load.

SikaPower®-4720
PANEL REPLACEMENT GUIDE

1

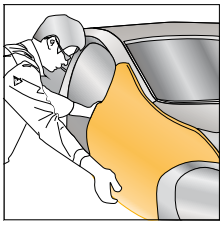
- Cut and remove damaged panel in accordance with OEM recommendations

2



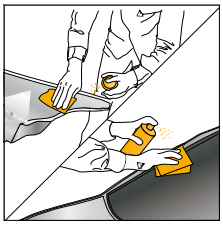
- Grind bonding areas on both car body and new panel to bare metal

3



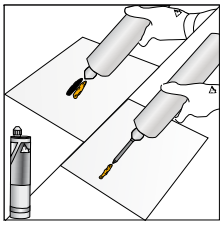
- Straighten all metal and align parts
- Dry fit panel

4



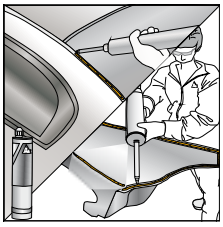
- Clean target bonding areas with a suitable residue-free solvent

5



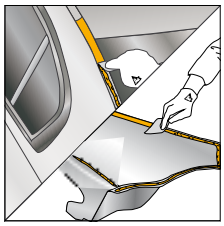
- Before attaching mixer, extrude some material until both Parts A and B flow evenly
- Attach static mixer and dispense a small amount of adhesive

6



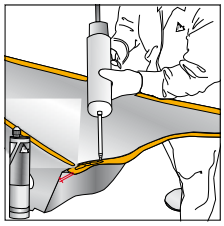
- Apply an adhesive bead to all bare metal areas of both pieces to be bonded

7



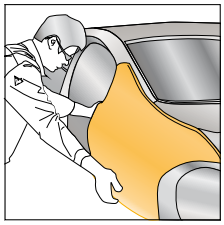
- Spread the adhesive to cover all bare metal areas with a plastic spatula

8



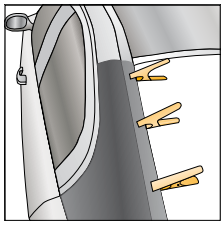
- Apply a second bead of adhesive on new panel approx. 5 mm from the edge of the panel
- Do not apply a second bead at points that will be spot welded

9



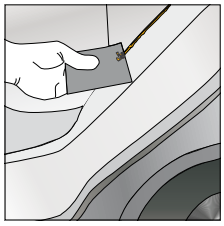
- Align new part to car body within 60 minutes[1)] after start of adhesive application

10



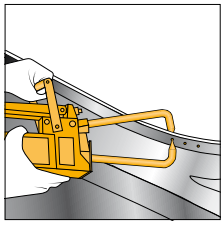
- Clamp panel in its proper position, start in corners, panel end points and positions where tension is present in the fit (remove clamps after 4.5 hours[1)])

11



- Tool any adhesive squeeze-out to seam along the bonded edge

12



- Proceed with welding or riveting where required and in accordance with OEM recommendations

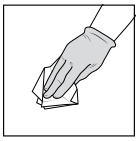
Temp-erature	Open time	Clamp time	Grindable	Drive-away time
10°C	90 min	16 h	48 h	48 h
23°C	60 min	4.5 h	16 h	24 h
30°C	30 min	2 h	6 h	8 h
60°C	n.a.	30 min	1 h	1 h

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.

[1)] All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Cure time may be accelerated by applying heat up to 85°C using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.

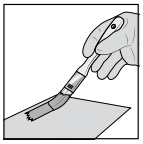
APPLICATION TIPS

PROCEDURE

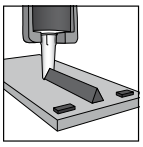


Bonding surfaces must be clean, dry and free of oil and grease. If necessary, sand bonding surfaces with a scouring pad and remove the dust. Remove heavy soiling with Sika® Remover-208 or Sika® Cleaner P. See the primer chart for more information

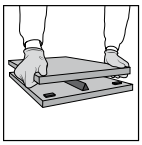
If necessary (see primer chart), wipe bonding surfaces with a clean, lint-free paper tissue moistened with an activator (Sika® Aktivator-100, Sika® Aktivator-205 or Sika® ADPrep). Observe the corresponding curing time



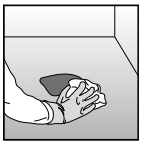
If necessary (see primer chart), apply primer to bonding surfaces with a brush, wool felt applicator or foam applicator. Observe the corresponding curing time



When bonding with non-sag products, apply the adhesive as a triangular bead. Cut the nozzle according to the printed scale and hold the gun perpendicular while applying. With two-component products, use a static mixer and apply the adhesive in dots or as a bead. Observe the minimum layer thickness and use spacers as needed



Position and press both plates so that they adhere to one another. If necessary, fix the component and leave it to polymerise. Respect handling time



Use a scraper and Sika® Remover-208 to remove any excess uncured adhesive. Other cleaners may interfere with the curing process

THINGS TO OBSERVE FOR APPLICATION

WORKING WITH A MATCHED SYSTEM
Using a matched system of pre-treatment agents and adhesives is recommended in order to ensure easy application of the products and trouble-free bonding.

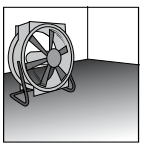
NO ALCOHOL ON UNCURED ADHESIVE
Once the adhesive has been applied, avoid contact between the freshly applied adhesive and products containing alcohol until a skin has formed. Alcohol disrupts the reaction and causes the adhesive to stay pasty or sticky instead of curing. Use Sika® Remover-208 to remove adhesive residue.

SILICONE ON SUBSTRATE OR ADHESIVE
Skin creams and products containing silicone can degrade adhesion and lead to debonding and water ingress.

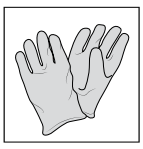
GLUING OF SPACERS
Gluing spacers with cyanoacrylate adhesives (super glue) can cause bonding problems in the surrounding area, leading to leaks. Self-adhesive spacers can be used without problems. Spacers should not be embedded in the adhesive bead, but should be as close as possible to the adhesive to avoid leaks. To avoid high local stresses, the hardness of the spacers should correspond to the hardness of the adhesive.

The application instructions and procedure must be followed precisely to ensure durable bonded joints.

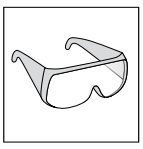
RESPECT SAFETY AT ALL TIME



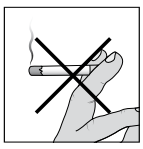
Ensure good ventilation



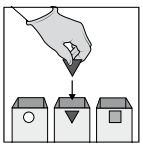
Wear protective gloves



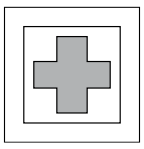
Wear protective glasses



Do not smoke, no fire, no food



Correct disposal of waste and residues



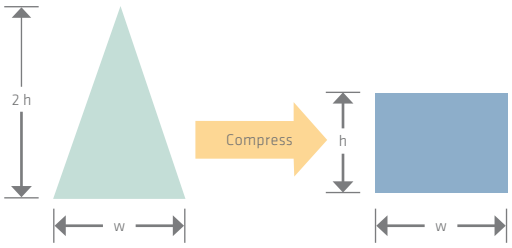
Be prepared for emergencies

NOZZLE GEOMETRY

Leaks and stress in the components and other problems can be eliminated by proper preparation before bonding. Cutting the adhesive nozzle correctly reduces potential sources of errors. This allows the adhesive to be applied with the right dimensions and perform properly. The adhesive should always be applied to the bonded joint in the form of a triangular bead. This ensures optimal wetting of the material by the adhesive. It also prevents gaps in the adhesive bead, insufficient compensation for the tolerances of the joined parts, and an excessively thin layer which could result in water entry. With plastics, an adhesive layer that is too thin can lead to stress cracks. With a flush bond on a flange, the height of the nozzle cut should correspond to the height of the flange. The surfaces of the joined parts are brought even by pressing (see sketches).

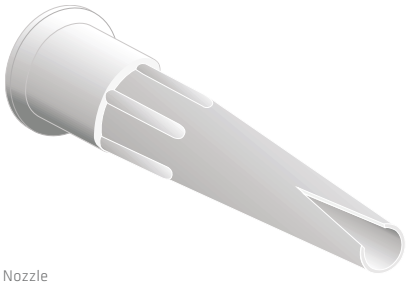
For single-component moisture curing adhesives, the bonded joint should be no wider than 20 mm due to the longer curing time.

Adhesive application **Desired adhesive dimension**



Thickness = h
If necessary use spacer

V-cut for application of a triangular adhesive bead
Diameter = bead width
V height = approximately twice the required adhesive layer thickness



Nozzle

PRE-TREATMENT CHART

Information about the pre-treatment of surfaces in this document serves as a guideline only and must be verified by tests on original substrates. Project specific pre-treatment recommendations, based on laboratory tests, are available from Sika on request.

	Sika® Aktivator-205	Sika® Aktivator-100
Color	Colorless, clear	Colorless to slight yellow
Type of product	Adhesion promoter	
Application temperature	General range is 10 – 35°C (50 – 95°F). For specific values refer always to the most recent Product Data Sheet.	
Application	Wipe with a clean and lint-free paper towel	
Consumption	Approximately 40 ml/m²	
Flash-off time (23°C/50% r.h.)	The range varies from 3 to 30 minutes depending on product and climatic conditions. For specific values refer always to the most recent Product Data Sheet.	
Color of container cap	Yellow	Orange

	Sika® Primer-204 N	Sika® Primer-207	Sika® Primer-210	Sika® Primer-215
Color	Opaque yellow	Black	Transparent, yellowish	Transparent, yellowish
Type of product	Primer			
Application temperature	General range is 10 – 35°C (50 – 95°F). For specific values refer always to the most recent Product Data Sheet.			
Prearrangement	Shake can very thoroughly until mixing ball rattles freely. Continue shaking for another minute.			n.a.
Application	Brush/felt/foam applicator			
Consumption	The consumption is in the range of 100 to 150 ml/m². Porous substrates need approx. 200 ml/m². For specific values refer always to the most recent Product Data Sheet.			
Flash-off time (23°C/50% r.h.)	The range varies from 10 to 60 minutes depending on product and climatic conditions. For specific values refer always to the most recent Product Data Sheet.			
Color of container cap	Light blue	Black	Gray	Dark blue

Notice: Sika activators and primers are moisture reactive systems. In order to maintain product quality it is important to reseal the container immediately after use. With frequent use i.e. opening and closing several times, we recommend to dispose of the product one month after first opening. With infrequent use, we recommend to dispose of the product 2 months after opening. For further information refer to our "General Guidelines for Bonding and Sealing with Sikaflex® and SikaTack®".
When selecting a foam applicator, the solvent resistance has to be taken into account, e.g. melamine foam Basotect from BASF is suitable.
When using Hybrid products in combination with Polyurethane, the Polyurethane has to be fully cured prior to the Hybrid application.

1. Aluminium
Aluminium and aluminium alloys are supplied in the form of profiles, sections, sheets, plates and castings. The information given here on surface preparation and priming relates to this group of products. Alloys containing magnesium may have water-soluble magnesium oxide on the surface. This oxide layer has to be removed with very fine abrasive pads. In the case of aluminium that has been surface treated (chromated, anodized or coated), a simple pre-treatment is usually sufficient.

2. Anodized aluminium
Aluminium is a reactive material which oxidizes on exposure to air. Anodization is an electrochemical or chemical process to protect aluminium from corrosion by forming a tough surface layer. Due to the wide variety of treatments such as coloring, sealing as well as the application of translucent lacquers of varying chemical composition, it is required to run preliminary tests to check for satisfactory adhesion.

3. Steel
Depending on the exposure conditions, steel is subject to corrosion. Sika primers, which are applied to the surface in a very thin layer, do not provide corrosion protection as such.

4. Stainless steel
The terms "stainless steel" and "special steel" embrace a whole group of products of varying chemical composition with varying surface finishes. These have an important influence on the adhesion behavior. The surface may contain single type chromium oxide. By removing it with a very fine abrasive pad the adhesion can be improved.

5. Hot dipped, galvanized steel
The principal techniques for applying zinc coatings to steel are a) the Sendzimir process, b) electrogalvanizing, c) hot dip or continuous strip galvanizing. In the case of a) and b) the substrate is prepared to a controlled specification and the composition of the surface layer is more or less uniform throughout. The surface composition of hot dipped components is not uniform. It is therefore necessary to carry out periodic adhesion checks. Oiled zinc coated steel has to be degreased prior to use. Do not use abrasives in case of electrogalvanized steel.

6. Non ferrous metals
Metals like brass, copper and bronze are prone to interact with the sealant or adhesive. Therefore it is recommended to contact Sika for advice prior to the use.

7. FRP (fibre reinforced plastic)
These materials consist for the most part of thermosetting plastics derived from unsaturated polyesters, less commonly from epoxy resins or polyurethanes. Newly manufactured components based on unsaturated polyesters contain quantities of styrene in monomeric form, recognized by its distinctive odour. These components have not yet attained full cure, and as such are subject to further shrinkage following their removal from the mould. For this reason only aged or tempered FRP mouldings should be selected for adhesive bonding. The smooth side (gel coat side) may be contaminated with mould release agent, which will adversely affect adhesion. The rough reverse side, which is exposed to the air during manufacture, usually contains paraffin, added to assist air drying. Here it is necessary to abrade the surface thoroughly prior to additional surface preparation. Thin section FRP mouldings made from transparent or pale colored material are translucent. In such cases a suitable UV barrier must be incorporated (see also point 10. Transparent or translucent substrates). Preliminary tests must be carried out to determine the most appropriate method of surface preparation.

8. Plastics
Some plastics require special physico-chemical treatment before they can be successfully bonded (flame treatment or plasma etching in combination with chemical pre-treatment). Polypropylene and polyethylene are two examples. With many plastic blends (e.g. engineering plastic) it is impossible to give specific guidance due to the potential variety of components and internal/external release agents they contain. Thermoplastics are subject to a risk of stress cracking. Thermally formed components must be destressed prior to adhesive bonding process. For transparent or translucent plastics see point 10.

9. PMMA/PC
For PMMA and PC substrates we recommend Sikaflex®-222 UV in combination with a UV-Shielding tape (see also points 8 and 10). In case of scratch-resistant coating on PMMA or PC, remove this layer in the bonding area with sand paper (120 grit) and pretreat as defined for non coated substrates. Note that this this last step may impair the mechanical properties of the PMMA/PC. Contact Sika for solutions without removal of the coating.

10. Transparent or translucent substrates
In the case of transparent or translucent substrates where the bond face is exposed to direct sunlight through the transparent or translucent layer, some form of UV barrier must be incorporated to shield the adhesive bond. This may consist of an opaque cover strip, an optically dense screen printed border or a black primer for semi transparent substrates such as translucent FRP or screen prints. Due to the high UV exposure on external application a black primer as a sole UV protection is not suitable. For inhouse applications and where the bondline is occasionally exposed to UV, a sole black primer for UV protection might be suitable.

11. Surface coatings, paint finishes
Preliminary trials are necessary before attempting to bond substrates with an applied surface coating. As a general rule, reactive systems that cure thermally (cataphoretic immersion coatings, powder coatings) or by addition of polymerisation (epoxy or polyurethane paints) can usually be successfully bonded with Sikaflex® and SikaTack® products. Alkyd resin paints that dry by oxidation are not suitable for bonding. Paint systems that rely on a physical cure mechanism – typically coatings based on polyvinyl butyral or epoxy resin esters – are generally compatible with sealants only, i.e. not with adhesives. Caution: The presence of paint additives designed to modify film formation, such as conditioners, silicones, matting agents, etc., may adversely affect adhesion to the paint surface. Consider that certain coatings can be negatively influenced by wheatering, for example if exposed during transport prior the bonding and sealing process. Surface coatings must be monitored for consistency of quality and uniformity of composition through a quality assurance system.

12. Phenolic film faced plywood
These are waterproof plywood panels with a yellow or brown film facing. The surface preparation is the same as for paints and coatings. Due to the variety of coatings the required adhesion may not always be achieved. In such case grind the surface down to the wood and pretreat it as such.

Overpaintablility
Sikaflex® products can be overpainted with most conventional paint systems. The best results are obtained if the sealant is allowed to cure fully first. If early overpainting is required, trials must be carried out to check compatibility with the paint system. Please note that non-flexible paint systems will impede joint movement, which can lead to cracking of the paint. PVC-based paints and paints that dry by oxidation (oil or alkyd resin based) are generally not suitable for application over Sikaflex® products.

PRE-TREATMENT CHART Sikaflex®-200 AND SikaTack® SERIES

VERSION 7 (08/2016)

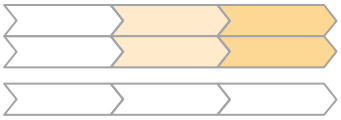
Substrate	Mechanical 1	Adhesion Promoter / Cleaner	Primer	Mechanical 2	Adhesion Promoter	Primer	3
Aluminium (AlMg3, AlMgSi1 and similar)	AP-C AP-C	SA-100	SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	CONTACT SIKA TECHNICAL DEPARTMENT INDUSTRY
Aluminium (anodized)		SA-100	SP-207	AP-C	SA-205	SP-204 N SP-207	
Steel (mild)		SA-205 SA-100	SP-204 N SP-206 GP	AP-C AP-C	SA-205	SP-204 N SP-207	
Steel (stainless)		SA-100	SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	
Steel (hot-dip galvanized, electrogalvanized)		SA-205	SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	
Non-ferrous metals (copper, brass, bronze,...)	AP-C	SA-205	SP-210	AP-C	SA-205	SP-210	
Two-component top coat, water- and solvent based (PUR, acrylic)		SA-100	SP-207		SA-100	SP-207 SP-206 GP	
Powder coat (Polyester (PES), EP/PES)		SA-100	SP-207	AP-C AP-C	SA-100	SP-207 SP-206 GP	
Two-component paint primer, water- and solvent based (PUR, acrylic, epoxy)		SA-100	SP-207		SA-100	SP-207 SP-206 GP	
Cathode dip coating (e-coating)		SCP SA-100			SA-100	SP-207	
Coil coating, mainly Polyester		SA-205 SCA		AP-C	SA-205 SCA	SP-206 GP	
FRP (unsaturated polyester) gelcoat side or SMC		SA-100	SP-207	AP-C	SA-100	SP-207	
FRP (unsaturated polyester) lay-up side	AP-C AP-C	SA-100	SP-207 SP-206 GP	GR-V GR-V	SA-205	SP-207 SP-215	
FRP (Epoxy-matrix), CFRP	AP-C AP-C	SA-100	SP-207 SP-206 GP	AP-C AP-C	SA-100	SP-207 SP-206 GP	
ABS			SP-209 D SP-206 GP		SA-100 SA-100	SP-209 D SP-206 GP	
Hard PVC			SP-215 SP-207		SA-205	SP-215 SP-207	
PMMA/PC (without anti-scratch coating)			SP-209 D SP-207	AP-C AP-C		SP-209 D SP-207	
Glass			SP-207			SP-207	
		SA-100			SA-100		
Ceramic screen print			SP-207			SP-207	
		SA-100			SA-100		
Wood / Plywood						SP-215	

PRECONDITION:
Surfaces have to be clean, dry and free of oil, fat, dust and loose particles. Depending on the nature of soiling, Sika® Remover-208, Sika® Cleaner P, water based cleaners or steam washer, etc. may be used. For soiled substrates, it might be necessary to grind the surface down to sound material. Verify compatibility with cleaning products.

Levels	Description
1	■ General sealing applications, small components with low level of stress exposure ■ Non-structural interior bonding applications, no exposure to temperature extremes, no contact with water
2	■ Sealing applications involving large components where higher joint movements are to be expected ■ Interior and exterior bonding applications under normal environmental conditions
3	■ Other applications, not covered under Level 1 and 2, where additional requirements are specified ■ Serial application

Abbreviation	Product/Explanation
AP-C	Abrasive Pad, very fine (e.g. from 3M) + cleaning step by dry wipe, SCP or similar
GR-V	Grinding (60 – 80 grit) and vacuum cleaning
SCP	Sika® Cleaner P
SA-100	Sika® Aktivator-100
SA-205	Sika® Aktivator-205
SCA	Sika® Coating Aktivator
SP-204 N	Sika® Primer-204 N
SP-206 GP	Sika® Primer-206 G+P
SP-207	Sika® Primer-207
SP-209 D	Sika® Primer-209 D
SP-210	Sika® Primer-210
SP-215	Sika® Primer-215

* **Note:** Product name was changed from Sika® Aktivator to Sika® Aktivator-100

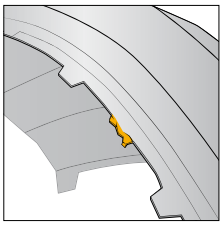


1st Process = Recommended process
2nd Process = Alternative

No surface preparation required, but preconditions must be respected.

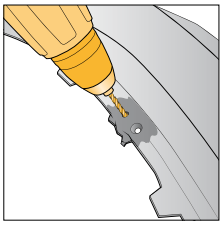
SIKA PLASTIC ADHESIVE SUPERFAST RE-SHAPE AND MODEL PLASTIC CLIPS

1



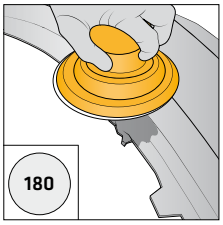
- Damage: a broken plastic clip

2



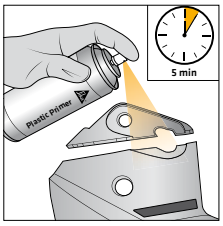
- Drill few holes with V-neck

3



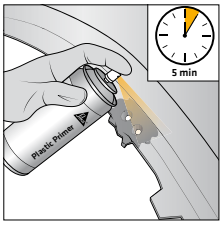
- Sand the area around the broken clip use 180 grit sandpaper

4



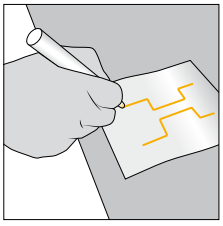
- Clean entire work area using Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains

5



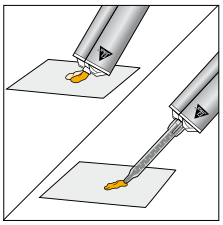
- Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min[1)]

6



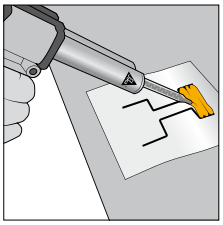
- Draw the shape of the clip and bonding-areas on the Sika Contouring Film

7



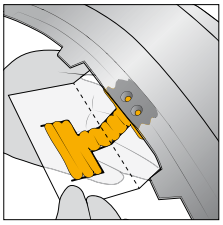
- Before attaching mixer, extrude some material until both parts A and B flow evenly
- Attach static mixer and dispense a small amount of adhesive

8



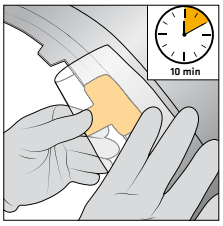
- Apply Plastic Adhesive Superfast within the prefigured area

9



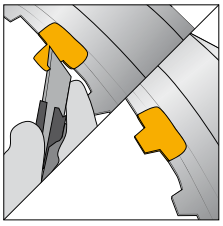
- Press adhesive on the backside of the area and bend it in the middle

10



- Press other side on the top and wait for curing

11



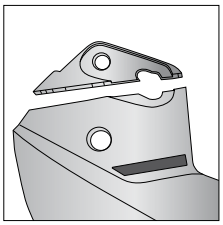
- After curing, cut the new clip to required shape

[1)] All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Cure time may be accelerated by applying heat up to 85°C using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.

Our most current General Sales Conditions shall apply.
Please consult the most current local Product Data Sheet prior to any use.

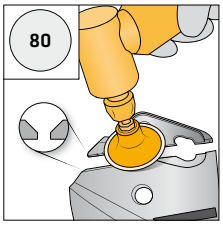
SIKA PLASTIC ADHESIVE SUPERFAST BONDING OF PLASTIC PARTS

1



- Damage: a broken piece of plastic

2



- Grind a V-groove (1 cm approx.) into the side edges, use 80 grit sandpaper

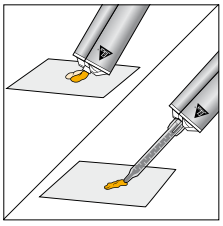
3

- Clean entire work area using Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains

4

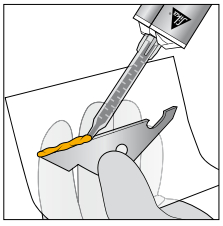
- Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min[1)]

5



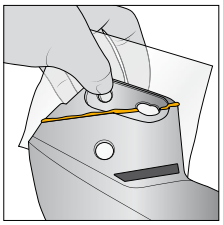
- Before attaching mixer, extrude some material until both parts A and B flow evenly
- Attach static mixer and dispense a small amount of adhesive

6



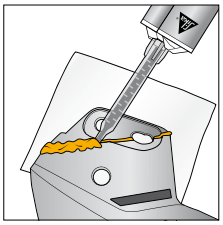
- Position one part on the Sika Contouring Film and apply Plastic Adhesive Superfast on the breaking point

7



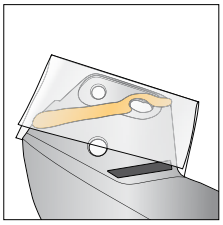
- Fix both parts

8



- Fill up the break with adhesive

9



- Bend the film and compress adhesive and wait for adhesive to be cured according to product label

[1)] All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Cure time may be accelerated by applying heat up to 85°C using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.

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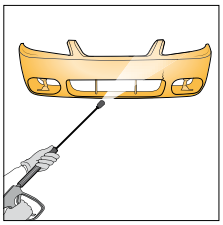
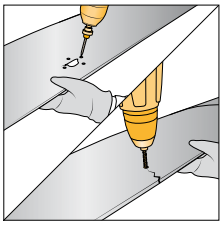
SIKA PLASTIC ADHESIVE FAST BUMPER AND PLASTIC REPAIR

1



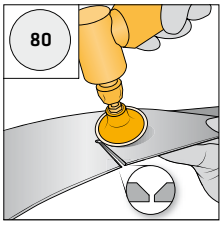
- Rinse plastic part with high pressure

2



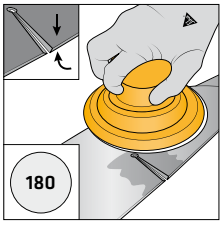
- Crack: Drill hole with a V-cut at the end of the crack
- Hole: Drill few holes with V-neck around the damage

3



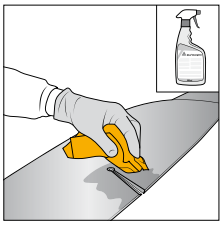
- On the front side grind a V-groove (1 cm approx.) into the side edges, use 80 grit sandpaper for grinding

4



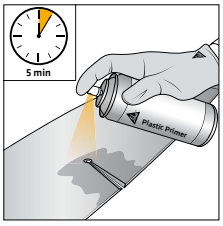
- Roughen the surfaces on the front and back sides with 180 grit sandpaper

5



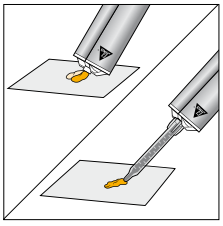
- Clean entire work area using Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains

6



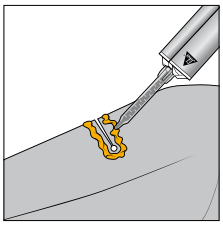
- Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min[1)]

7



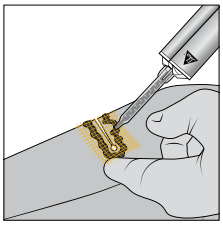
- Before attaching mixer, extrude some material until both parts A and B flow evenly
- Attach static mixer and dispense a small amount of adhesive

8



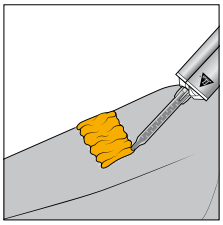
- Apply Plastic Adhesive Fast around the crack to the backside of the part

9



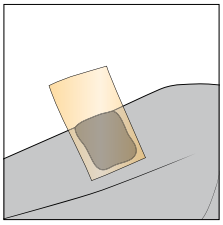
- Position the pre-cut reinforcement film into the applied adhesive

10



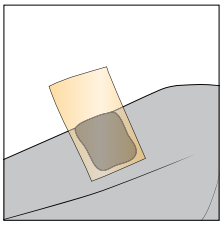
- Apply the adhesive bubble-free on top of the reinforcement film until it is completely covered

11



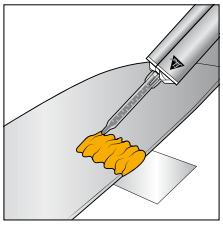
- Spread from the adhesive using the Sika Contouring Film from the middle to the edges to avoid bubbling

12



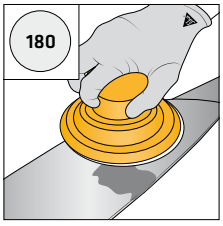
- Fill the damaged area on the front side of the part with adhesive

13



- Spread from the adhesive using the Sika Contouring Film
- Respect curing time[1)] as per product label

14

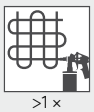


- Sand the surface and proceed with filling and painting

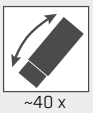
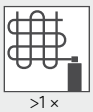
PROTECTIVE COATINGS

APPLICATION PROCEDURE

LITRE CANS

1. 	Surface must be clean, dry and free of rust, dust and grease	**4.**  20 - 30 cm	Spray from a distance of 20 - 30 cm
2.  ~40 ×	Shake can approx. 40 times upside down before use	**5.**  >1 ×	Spray in an X motion several times to build up a continuous coat
3.  3 - 6 bar	Use an air pressure of approx. 3 - 6 bar	**6.** 	Clean gun after use
 15 - 25°C	Apply product at room temperature		Do not spray on parts of the brake or exhaust system

AEROSOL CANS

1. 	Surface must be clean, dry and free of rust, dust and grease	**3.**  20 - 30 cm	Spray from a distance of 20 - 30 cm
2.  ~40 x	Shake can approx. 40 times upside down before use	**4.**  >1 ×	Spray in an X motion several times to build up a continuous coat
		5. 	After use, invert can and spray in short bursts to clear nozzle
	Do not spray on parts of the engine		Product is suitable for engine conservation (only valid for Sikagard®-6250)

For more details please consult most current local Product Data Sheet prior to any use.

[1] All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Cure time may be accelerated by applying heat up to 85°C using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.

Our most current General Sales Conditions shall apply.
Please consult the most current local Product Data Sheet prior to any use.

NOTES

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SIKA FULL RANGE SOLUTIONS FOR CONSTRUCTION:

WATERPROOFING

CONCRETE

REFURBISHMENT

MERCHANT

SEALING AND BONDING

FLOORING

ROOFING

INDUSTRY

FOR MORE INFORMATION:

WHO WE ARE

Sika Limited and Sika Ireland Limited are part of the global Sika Group, specialising in the manufacture and supply of chemical based products. Sika have a leading position in the development and production of systems and products for bonding, sealing, damping, reinforcing, and protecting in the building sector and the motor vehicle industry. Sika has subsidiaries in 97 countries around the world and manufactures in over 190 factories. With over 17,000 employees Sika generates annual sales of CHF 5.75 billion (£4.69bn). We are also committed to providing quality, service, safety and environmental care.

In the UK and Ireland, we provide market-leading solutions for concrete, waterproofing, roofing, flooring, refurbishment, sealing & bonding, and industry, and have manufacturing sites in Welwyn Garden City, Preston, Leeds and Dublin with more than 700 employees and a turnover of more than £220 million.

bsi. ISO 9001 Quality Management FM 12504 | ISO 14001 Environmental Management EMS 45308 | OHSAS 18001 Occupational Health & Safety Management OHS 585274

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