



Product code : 74057A

## SAPOFIX USA

### DESCRIPTION

SAPOFIX USA is a one-component polyurethane sealant which cures by the action of air moisture. By this reaction, the product changes from a pasty to an elastomeric state with high tensile strength.

### AREAS OF APPLICATION

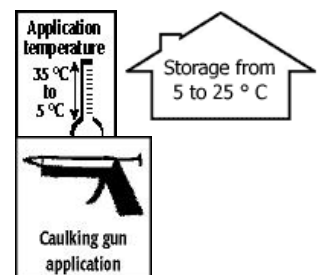
SAPOFIX USA can be used for windshield bonding in the car industry.

### TECHNICAL DATA

Appearance	Thixotropic paste
Colour	Black
Density at 20 °C	Ca 1.19
Application temperature	5 to 35 °C
Skin formation time at 23 °C and 50 % HR	40 to 60 min
Cure time at 23 °C and 50 % HR	> 3.5 mm/24 h
Final Shore A hardness (ISO 868 - 3 seconds)	> 55
Shearing resistance at 7 d at 23 °C and 50 % HR (Ford SAE J 1529)	> 3.5 MPa (> 500 psi)
Specific data	Modulus at break (ISO 37) : > 6 MPa (> 900 psi)

### ADVICE

See also material safety data sheet



### INSTRUCTIONS FOR USE

Substrates preparation :

The windscreen has to be treated as follows :

- on raw glass, clean with the degreaser SAPOCOL 1001 and then apply the primer SAPOCOL 2001 BLACK.
  - on ceramic frit glass, degrease with ethanol and then apply EMFIPRIM 34022A or 34027A.
  - on encapsulated windscreen, degrease with methylethylketone (MEK) or acétone (do not use alcohol) and then apply EMFIPRIM 34025A.
  - on windscreen coated with a primer, degrease with MEK or acetone.
- Never clean the old sealant with a solution containing alcohol.

Bonding :

When the primer is completely dry (after 10 to 15 min, or more under 20 °C), SAPOFIX USA can be applied with a pneumatic or a hand gun and pressed on the second substrate before the end of the tack free time.

Take care that this time (which decreases when temperature increases) is not exceeded.

The shape of the joint is given by the nozzle.

Do not apply at temperatures under 5 °C. In cold weather, store the cartridges at about 20 °C before use.

Do not apply on silicones or in presence of polymerised silicones or hybrid sealants (MS or SPUR).

**Cleaning :**

Tools can be cleaned with EMFINET 683, xylene, MEK or acetone before curing.

After curing, mechanical cleaning is required.

**STORAGE AND SHELF LIFE**

12 months in hermetically sealed original packagings between 5 and 25 °C

**PACKAGING**

310 ml aluminium cartridges, 400 and 600 ml sausages

**SAFETY**

Harmful. Read material safety data sheet before use.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

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