

Description

Top quality, ultra high modulus, low conductivity, fast-curing polyurethane adhesive for the bonding of vehicle glass. It is specifically designed to give a fast and safe drive-away time on vehicles fitted with airbags. Fast 30 has been crash-tested to the most rigorous US safety standards FMVSS 208/212.

Features & Benefits

- cold application, good stability/workability – non sagging
- capable of withstanding high dynamic mechanical stress
- resistant to ageing and weathering
- no need for black primer (only Activator 5090)
- prevents contact corrosion in aluminium-body vehicles
- suitable for use with integral aerials
- open time: 15-20 min
- drive away time: 60 min (23 °C/73,4 °F and 50 % relative humidity)

Substrate preparation

The substrate to be bonded must be even, dry, dust free and not have any traces of grease or other contaminants that could harm bonding. Rub down any rusted areas. It is not necessary to remove old polyurethane sealant completely: simply trim it off leaving 1-2 mm thickness.

Bare metal should be cleaned with cleaner & activator (Prod. Nr. 5090). Respect a drying time 10-60 min depending on the weather conditions.

We recommend applying thin and uniform layer of black primer (Prod. Nr. 5082). Respect a drying time 15 - 60 min depending on the weather conditions.

Windshield preparation

The windshield frit should be cleaned with cleaner & activator (Prod. Nr. 5090). Respect a drying time 10-60 min depending on the weather conditions.

If the ceramic frit is not sufficiently opaque apply an uniform layer of black primer (Prod. Nr. 5082). Respect a drying time 15 - 60 min depending on the weather conditions before applying the sealant.

Windshield replacement

Windshield adhesive can be applied by a manual (Prod. Nr. 2860) or pneumatic gun (Prod. Nr. 9510). The triangle shaped form of the joint is determined by the shape of the nozzle. The windshield must be applied and pressed before the adhesive has formed its skin.

Due to large variety of substrates and installation conditions we recommend performing tests beforehand on difficult materials (particularly on non-ferrous or lacquered metals, painted substrates and plastic

substrates like PVC, PMMA or ABD) to determine whether abrasion or use of black primer may be necessary to improve the adhesion.

Technical information

Density 20°C:	approx 1,35g/ml ± 0,05
Color:	black
Application temperature:	5 to 35 °C/41 to 95 °F
Skin formation time:	approx 15 min (23 °C/50 %HR)/(73,4 °F/50 % HR)
Curing speed after 24 hours:	approx 3,5 mm (23 °C/50 % HR)/(73,4 °F/50 % HR)
Modulus at break (ISO 37):	>6 MPa
Elongation at break (ISO 37):	>300%
Temperature resistance:	-40 °C/-40 °F to +90 °C/194 °F (cured adhesive)
Shearing resistance at 7 days (23 °C (73,4 °F) / 50 % HR)	>3,5 MPa (>500 psi)
Water and salt spray resistance	excellent

Prod. Nr.	Description	Volume	Packaging
4515-0,31	black	310 ml	12

Shelf life

At least 9 months after production under normal storing condition at temperature below 25 °C/77 °F and unopened original packaging. In cold weather, store the packaging at about 20 °C/68 °F) before use.

Max 24 hours after first opening.

Read the material safety data sheet before use.

Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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