

## PRODUCT DATA SHEET

## SikaTack® ELITE

DESIGNED FOR SIKA POWERCURE – HIGH SPEED PERFORMANCE IN ALMOST EVERY CLIMATE

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing <sup>A</sup>
Density (uncured)	1.3 kg/l
Non-sag properties	Very good
Application temperature	product 5 – 35 °C (41 – 95 °F) ambient -10 – 35 °C (14 – 95 °F)
Open time (CQP526-1)	8 minutes <sup>B</sup>
Curing speed (CQP049-1)	See table 1
Shore A hardness (CQP023-1 / ISO 7619-1)	60
Tensile strength (CQP036-1 / ISO 527)	7 MPa (1 015 psi)
Elongation at break (CQP036-1 / ISO 527)	300 %
Tear propagation resistance (CQP045-1 / ISO 34)	10 N/mm (57 pli)
Tensile lap-shear strength (CQP046-1 / ISO 4587)	5 MPa (725 psi)
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)	with airbag 30 minutes <sup>C / D</sup>
Cured to OEM level (CQP046-1 / ISO 4587)	60 minutes <sup>B</sup>
Insulation resistance (CQP079-2 / DIN IEC 60167)	Low conductive
Shelf life (CQP016-1)	9 months <sup>E</sup>

CQP = Corporate Quality Procedure

<sup>C</sup>) Details about MDAT contact Sika<sup>A</sup>) Provided by PowerCure<sup>D</sup>) -10 – 35 °C<sup>B</sup>) 23 °C / 50 % r. h.<sup>E</sup>) Storage below 25 °C

## DESCRIPTION

SikaTack® ELITE provides 30 minutes Minimum Drive Away Time and cures to OEM Level within just 60 minutes. It is applied with the Sika PowerCure Dispenser and can be used all year round for mobile or in house applications. SikaTack® ELITE has been tested according to FMVSS 212 with 95<sup>th</sup> percentile dummies.

## PRODUCT BENEFITS

- 30 min Minimum Drive Away Time, acc. FMVSS 212 / 95<sup>th</sup> percentile dummies
- Enables fast, robust ADAS calibration
- Cured to Automotive OEM Level within 60 minutes almost independent of climate
- Automotive OEM quality
- Compatible with all car makes thanks to Sika's all-in-one modulus technology

## AREAS OF APPLICATION

SikaTack® ELITE is suitable for experienced professional users only. This product and related process information is designed for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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Version 02.01 (04 - 2020), en\_US

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## CURE MECHANISM

SikaTack® ELITE cures by reaction with the accelerator.

Time [min]	Strength [MPa]
60	1.5
120	3

Table 1: Lap shear strength (CQP 046-1) at 23 °C / 50 % r.h.

## CHEMICAL RESISTANCE

SikaTack® ELITE is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

The bond faces must be treated according Sika's All Black installation process. Further information on the application and use of Pre-treatments, can be found in the corresponding Product Data Sheet.

Glass without ceramic coatings need proper UV protection.

### Application

Setup the PowerCure Dispenser according the PowerCure User Manual. If the application is discontinued for more than 2 minutes, the mixer needs to be replaced.

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use.

To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

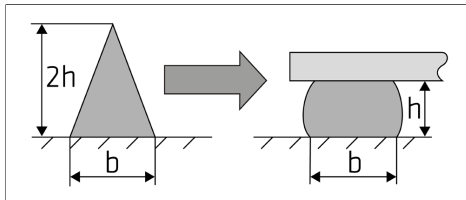


Figure 1: Compressing adhesive bead to final size

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the product has built a skin.

## Removal

Uncured SikaTack® ELITE can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using hand wipes or a suitable industrial hand cleaner and water. Do not use solvents on skin!

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika AGR Technician Training Manual
- PowerCure User Manual
- PowerCure Quick Reference Guide

## PACKAGING INFORMATION

PowerCure Pack	400 ml 600 ml
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## BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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