

# SikaTack<sup>®</sup>-Ultrafast

## Hot Applied, High Strength, Elastic Adhesive

### Technical Product Data (typical values)

Chemical base		1-C polyurethane
Color		Black
Cure mechanism		Moisture-curing
Density (uncured)		9.8 lbs/gal
Non-sag properties		Very Good
Cut-off string		Very Good
Application temperature	product	158° F 194° F (70° C to 90° C)
Service temperature		-40°F to 190°F
Tack free time <sup>1</sup>		15 min
Open time <sup>1</sup>		10 min
Shore A-hardness (ASTM D2240)		60-70
Tensile strength (ASTM D412)		1015 psi
Elongation at break (ASTM D412)		450%
Tensile lap-shear strength (ASTM D1002)		580 psi
Shelf life (storage below 75°F (24°C))	cartridge/drum	9 months/6 months

<sup>1</sup>) 73°F (23°C) / 50% r.h.

### Description

SikaTack<sup>®</sup>-Ultrafast is a fast-curing, one component, polyurethane adhesive with high green strength. SikaTack<sup>®</sup>-Ultrafast is manufactured under strict quality control to the highest Sika standards.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

### Product Benefits

- Short tack-free and curing time.
- Bonds and seals at the same time.
- One component: permits use of simple, light equipment and avoids mixing errors.
- Short cut-off string resulting in clean application properties.
- Very high thixotropy for good gap filling properties.
- Increases torsional stiffness of final assembly.
- Used in applications requiring high green strength for short fixture times.
- Shock / impact resistant.
- Vibration and sound damping properties.

### Areas of Application

Used for general purpose bonding of components and direct glazing of windows during manufacture of Buses, Trucks, Recreational Vehicles and Specialty Vehicles.

Industry



## Cure Mechanism

SikaTack®-Ultrafast utilizes a dual curing system. The material is pre-gelled by heat which gives it the unique high initial strength and unsurpassed non-sag properties. Final cure is through ambient moisture. SikaTack®-Ultrafast is extremely easy to use thanks to its excellent non-sag properties, easy extrusion and very high thixotropy.

## Method of Application

### Substrate

Make sure substrate is clean, dry, free of water, oil, grease or rust, and of sound quality. Remove all loose particles such as residues of color, splashes, etc. Clean surface with a strong jet of compressed air, sandblast or solvent.

### Priming

Pretest substrates for adhesion. Cleaners and/or primers may be required to achieve optimal adhesion. Please refer to the Surface Preparation Guidelines for specific application information available at [www.sikaindustry.com](http://www.sikaindustry.com).

### Surface preparation

Surfaces must be clean, dry and free from all traces of grease, oil and dust. Additional information can be obtained through the Technical Service Department of Sika Industry. For specific guidelines regarding surface preparation please refer to the Sika Primer Chart available at [www.sikaindustry.com](http://www.sikaindustry.com) or by calling the Technical Service Department of Sika Industry at 888 732-7452.

### Application

It is very important that SikaTack®-Ultrafast be applied within the recommended application temperature range of 158°F to 194°F (70°C to 90°C). Ideal recommended temperature 175°F (80°C) Material applied at temperatures outside this recommended range can result in less than optimal adhesion results and poor application characteristics including poor gunnability, excessive stringiness,

poor sag resistance and poor bead stability. **Note:** Cartridges should be heated in a Sika approved cartridge oven for a minimum of 1 hour prior to application, but not for more than 10 hours. If application involves material dispensing from drums, customers should seek advice from the Systems Engineering Department of Sika Industry regarding additional bulk dispensing equipment requirements.

Heat material to application temperature. Dispense material. The recommended application configuration of this material is in a V notch bead to assure proper surface contact with both substrates, (see Figure 1) where  $2H$  = approximate depth of joint, and  $H$  = the compressed adhesive thickness following bonding.

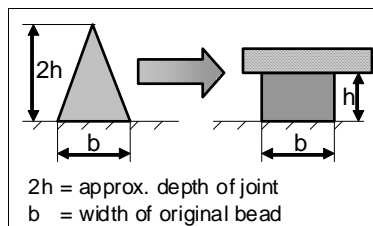


Figure 1: Recommended bead configuration

### Removal

Uncured Sikaflex®-Ultrafast may be removed from tools and equipment with mineral spirits or another suitable solvent. Strictly follow solvent manufacturer's instructions for use and warnings. Do not use any alcohol based liquids. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on hands!

### Limitations

For best results, use opened cartridges the same day. When applying adhesive, avoid air entrapment. Do not use on polyethylene, polypropylene, silicone, PTFE, and certain plasticized resins (consult our

Technical Services Department for advice.) Always use a piston type cartridge gun (hand operated or pneumatic) to apply adhesive.

### CAUTION: Irritant; Sensitizer:

Contains polyisocyanate prepolymer, xylene. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. Xylene may cause headaches, dizziness or other CNS effects; and may cause liver or kidney effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of PELs being exceeded, use an appropriate, properly fitted NIOSH/MSHA approved respirator.

### HMIS

Health	2
Flammability	1
Reactivity	0
Personal Protection	C

### First Aid

In case of skin contact, wash immediately and thoroughly with soap and water. If symptoms persist, consult physician. For eye contact, flush immediately with plenty of water for at least 15 minutes, contact a physician. For respiratory problems, remove person to fresh air; if symptoms persist, contact a physician. **In case of ingestion, dilute with water and consult physician. Remove contaminated clothing.**

### Further Information

Copies of the following publications are available on our website [www.sikaindustry.com](http://www.sikaindustry.com):

- Material Safety Data Sheets
- Product Data Sheet
- Sika Primer Chart
- Surface preparation guidelines
- General guidelines for bonding and sealing with Sika products

Further information available at:  
[www.sikaindustry.com](http://www.sikaindustry.com)

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**In case of emergency call:**  
**Chemtrec: 800-424-9300**  
**International: 703-527-3887**

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

**-KEEP OUT OF REACH OF CHILDREN**  
**-NOT FOR INTERNAL CONSUMPTION**  
**-FOR INDUSTRIAL USE ONLY**  
**-KEEP CONTAINER TIGHTLY CLOSED**

**Packaging Information**

Cartridge	300 ml
Drum	50 gal

**Value Basis**

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

**Storage and Handling**

Do not store near excessive heat. Store in tightly closed containers. For maximum shelf life, store unopened product at or below 75°F (24°C). Avoid direct contact. Wear personal protective equipment (chemical resistant goggles /gloves/ clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse.

**Clean Up**

In case of spills or leaks, ventilate area, avoid contact, wear suitable protective equipment, contain spill, collect with absorbent material, and transfer to suitable container. Dispose of in accordance with current, applicable local, state, and federal regulations.

**Limited Material Warranty**

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at [www.sikacorp.com](http://www.sikacorp.com) or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at [www.sikaindustry.com](http://www.sikaindustry.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

Further information available at:  
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