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TECHNICAL DATA SHEET

1. IDENTIFICATION OF THE PRODUCT

NAME OF THE PRODUCT BOSSEAL 60 minutes black glass, 300 ml
CODE 080045

2. DESCRIPTION

Cartridge single-component polyurethane sealer, high viscosity and fast drying. Polymerizes with atmospheric humidity. Application with manual or pneumatic applicator gun. Curing time (23ºC/50% HR): 12 min. approx. Maximum time open (23ºC/50% HR): 5 min. approx. Period for withholding vehicle: with airbag, 1 hours; 2 airbags.

3. AREAS OF APLICATION

BOSSEAL RAPID glass sealant 60' can be used to bond windshield and side windows of cars with or without a primer. For other applications, refer to our technical service. Using a primer or not depends on the quality of the substrates.

4. TECHNICAL DATA

Appearance	Thixotropic paste
Colour	Black
Density at 20ºC	1.23 ± 0.02
Application temperature	5 to 35ºC
Skin formation time at 23ºC at 50% HR	25 to 40 min.
Cure time at 23ºC and 50% HR	>3.5 mm/24h
Shore A hardness (internal method IT-20 after ISO 868 – 3 seconds)	60 to 65
Shearing resistance at 5h at 23ºC and 50% HR (Ford SAE J 1529)	> 0.9 MPa (>130psi)
Shearing resistance at 7d at 23ºC and 50% HR (Ford SAE J 1529)	> 3.5 (>500psi)
Water and salt spray resistance	Excellent
Specific data Elongation at break (ISO 37) Modulus at break (ISO 37) Tear strength (ISO 34) Crash test (standard FMVSS 212) with security	 >700% Approx. 7.5 MPa Approx. 30 N/mm Resist after 1 hour at 23ºC and 50% HR dual air bags.

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5. INSTRUCTIONS FOR USE

5.1. Substrate preparation

The substrate must be clean, even, dry and free of dust.
Carefully respect the evaporation times of the solvents.
When using solvents, extinguishing all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.
In case of windshield replacement, it is not necessary to completely remove the old sealant; simply trim it off, leaving a 1 to 2mm thickness.
The application of fresh polyurethane over a polymer is not compatible. But there is no compatibility problem applying fresh polyurethane sealant to old polyurethane sealant.
Rub down any rusted area. Clean bare areas of the body before applying the primer

The windshield has to be treated as follows:

Raw glass

Activator – Black primer – Windshield sealant. Clean with the single-use kit containing an impregnated wipe and a dry wipe, first use the impregnated wipe, and the dry with dry wipe. Wipe as soon as the solvent is evaporated, 30 to 60 seconds after application. As the primer is very sensitive to humidity, the bottle must be closed immediately after use. If it is cloudy, do no use it.

Let dry between 10 to 60 minutes after application according to temperature. In case of excessive drying time, degrease a second time. Then apply a thin and uniform film of primer with an applicator pad (or a 10 ml tube with single-use foam sponge applicator) in order to form a homogeneous film. Homogenize the product before application. Close the bottle immediately after use. Any contact with humidity will make the primer cure. For this reason, the product must be used within 24 hours after opening bottle. Let dry between 15 and 60 minutes according to temperature before application of the sealant.

Windshield with ceramic fruit

Anti-silicone treatment – Activator – (Black primer) – Windshield sealant
Bonding may be performed with or without primer. Bonding without primer must be performed
on a windshield with ceramic frit ensuring optimum and uniform opacity to UV and with no silicone residue.
Noncompliance with these conditions may cause partial or total loss of adhesion of the sealant on the windshield. Degrease with heptane or methylethylketone (MEK), abrade (in order to avoid orange peel effect likely to occur in presence of traces of silicone), degrease a second time with heptane or MEK and respect a drying time of 10 minutes. Apply activator according to
the method described for raw glass.
Let dry between 10 and 60 minutes before the next step:
- If ceramic frit is sufficiently opaque, application of the sealant
- If ceramic frit is not sufficiently opaque, application of primer with an applicator pad (or a 10ml tube with single-use foam sponge applicator) followed by a waiting time if 15 to 60 minutes before application of the sealant.

- **Encapsulated windshield**

Degrease if needed with MEK or acetone (do not use alcohol) and respect a 10 minutes drying time, then apply the primer.

- **Windshield coated with a primer**

Degrease with MEK or acetone. After about 10 minutes, apply primer.
For other types of substrates, refer to our technical service.
Never clean the old sealant with a solution containing alcohol.

- **Bonding**

After full drying of the primer (minimum 15 minutes, maximum 1 hour), the sealant can be applied with a hand or pneumatic gun. The triangle-shaped form of the joint is determined by the nozzle. If applied in cold weather, store the packagings at about 20ºC before use. The windshield must be applied and pressed before the end of the tack free time. Do not apply in the presence of cured or non-cured silicones or hybrid sealants (M, SPUR or STPE). Do not apply at temperatures lower than 5ºC.

Note: all times described in the above instructions are valuable for a minimum temperature of 15ºC. In case of lower temperatures (between 5 and 15ºC), drying times must be twice longer.

- **Cleaning**

Uncured sealant can be cleaned up with MEK or acetone.
After curing, abrasion is necessary

6. STORAGE AND SHELF LIFE

12 months is closed original packaging stored in dry premises at a temperature lower than 25ºC. If necessary, gently warm the product before use until it reaches a suitable temperature.
Storage at a temperature over 25ºC will decrease the shelf life of the sealant.

7. PACKAGING

300ml aluminium cartridges.