



# PRODUCT DATA

## 4502

## Urethane Windshield Adhesive

### DESCRIPTION:

Urethane Windshield Adhesive is a one part moisture curing urethane adhesive designed to provide a strong bond to all windshield and backlight replacements. This product exhibits excellent adhesion to glass and pinchweld surfaces designed for use in a close cut-out method or tape installation. Urethane Windshield Adhesive passes FMVSS 208, 212, and 216 strength requirements.

### TECHNICAL DATA:

BASE POLYMER:	Polyurethane
APPEARANCE:	Black color
% SOLIDS:	100% Solids
V.O.C. CONTENT:	0.23 #/gal (28g/l)
SHELF LIFE:	1 year
TENSILE STRENGTH:	>600 psi
LAP SHEAR STRENGTH:	>500 psi
CURE THROUGH TIME:	24 - 36 hours @ 70°F (21°C) and 65% relative humidity
TACK FREE TIME:	40 minutes @ 70°F (21°C) and 50% relative humidity
HARDNESS:	Shore A 50 - 55
APPLICATION TEMPERATURE:	For best results 40°F - 110°F (4° - 43°C)
PACKAGING:	11 oz. (310 ml) fiber cartridge
ELONGATION AT BREAK:	300% at 72°F (22°C)

### NOTE:

For maximum adhesion protection, windshields that have a black ceramic band will require priming with Pinchweld Primer & Glass Bond #4406.

### SALES POINTS:

- Passes FMVSS 208, 212 and 216 strength requirements.
- Cost Effective
- Non Sag Formula
- Contains no Isocyanates

### SEE REVERSE SIDE FOR APPLICATION INSTRUCTIONS

(Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin).

### PACKAGE SIZE:

- 4502 Urethane Windshield Adhesive, 11 oz. cartridge (310 ml), 12/case
- 4406 Pinchweld Primer & Glass Bond, 4 fl oz (125 ml), 6/case



*DISCLAIMER: The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on Transtar Autobody Technologies experience and research and is believed to be reliable. As Transtar has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.*

# 4502

## Urethane Windshield Adhesive

### **DRIVE AWAY TIMES:**

150 PSI Lap Shear (with passenger air bag)		
70°F (21°C) - 50% Relative Humidity	Drive Away:	6.5 hours
50°F (10°) - 50% Relative Humidity	Drive Away:	13 hours
50 PSI Lap Shear (with passenger air bag)		
70°F (21°C) - 50% Relative Humidity	Drive Away:	3.5 hours
50°F (10°C) - 50% Relative Humidity	Drive Away:	8 hours

### **INSTRUCTIONS:**

#### CLOSE CUT-OUT METHOD

1. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth.
2. Apply Transtar Acry Solvent #9783/9784 to clean bonding surface around perimeter of glass. Allow 5 minutes to flash and dry off.
3. Apply a thin coat of Transtar Pinchweld Primer & Glass Bond #4406 over black ceramic band (frit). Allow 10 minutes to dry.
4. Remove the old windshield cutting as close to the glass as possible.
5. Trim away high spots off the original adhesive. Clean the remainder of original adhesive with a dry brush or compressed air.

*Note: Transtar urethanes are primerless to the original urethane. Use Transtar Pinchweld Primer & Glass Bond #4406 on any exposed bare or painted metal.*

6. Gun a bead of #4502 Urethane Windshield Adhesive directly on the existing bed of urethane.
7. Install windshield, applying even pressure on the bond line to assure uniform contact with the adhesive.
8. Apply additional adhesive if required. Tool urethane around the edge and replace the molding.
9. Clean up with Transtar Acry Solvent #9783/9784.

#### FULL CUT-OUT METHOD

1. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth.
2. Wipe with a thin coat of Acry Solvent #9783/9784 to the bonding surface around the edge of the windshield. Allow 5 minutes dry time.
3. Remove all but a 1/16" - 1/8" layer of the original adhesive from the pinchweld. Clean the old urethane with Acry Solvent #9783/9784.
4. Apply butyl tape to the inside edge of the pinchweld, pressing to assure complete contact with the surface before removing the release liner.
5. Apply a bead of #4502 Urethane Windshield Adhesive behind the tape. The bead should be slightly higher than the profile of the dam tape.
6. Install the windshield making sure to apply even pressure on the bond line to ensure contact with the adhesive.
7. Additional urethane can be applied if necessary. Tool urethane around the edge of the windshield and replace the molding.
8. Use Acry Solvent #9783/9784 to clean excess urethane.