Fast Cure Urethane Windshield Adhesive
20100

A one part medium viscosity moisture curing urethane adhesive designed for windshield bonding, stationary and backlights. High initial bond strength. The fast rate of cure results in rapid strength and shorter service temperature. Urethane Windshield Adhesives passes FMVSS212 and FMVSS216.

**PRODUCT**

20100  10.5 fl oz (310 ml)

**COMPATIBLE PREPARED SUBSTRATES:**

- Glass
- Primed and Painted Metal

**SURFACE PREPARATION:**

1. Surface must be clean, sound, dry, and free from all traces of dust and grease.
2. Clean glass with 20030 Glass Cleaner.
3. Prime glass and pinch weld with 20110 Pinch & Glass Bond Primer. Apply masking tape prior to priming. Leave primer to dry for 10 minutes.

**APPLICATION:**

We recommend using Pro Form’s 26182 Heavy Duty Caulking Gun.

1. To restore windshield to meet government standards clean glass with 20030 Triple Strength Glass Cleaner. Apply 20110 Pinchweld & Glass Bond Primer to glass & pinch weld and let dry.
2. Remove the steel seal and pierce a large hole on the nozzle end.
3. Apply a bead to pre-treated OEM pinch weld.
4. Position windshield into body opening and press into adhesive before the end of the track free time.
5. Tools can be cleaned with 19000 General Purpose Adhesive Cleaner.

**GENERAL PREPARATION**

1. Inspect new glass for defects. Ensure all moldings are available.
2. Remove windshield wiper arm, trim and other components to allow complete access to the glass.
3. Mask adjacent areas to protect vehicle against scratches.
4. Cut out urethane and remove broken glass using suction clamps. Clean any glass debris from windshield area.
5. Trim back the remaining adhesive leaving a minimum of 2mm (1/16”) over pinch welds. Avoid scratching or scraping exposed areas of the metal substrate. This will provide a good base for new adhesive application. Butyl tape should be completely removed.
6. Using a clean, dry, lint-free cloth, clean metal surfaces with 19000 General Purpose Adhesive Cleaner.
7. Dry fit the glass into position. Mark proper alignment using masking tape.

**GLASS PREPARATION**

1. Clean the glass bondline on each side using 20030 Triple Strength Glass Cleaner. Let dry thoroughly.
2. Apply a thin coat of 20110 Pinch & Glass Bond Primer to the entire bondline of the glass. Let dry at least 10 minutes (above 30°F (-1°C)) or 20 minutes (between 0°F (-17°C) and 30°F(-1°C)).
3. If foam damming material is present, it should be replaced.

NOTE: The triangular bead method is used on the OEM assembly line to dramatically reduce leakage rates. A
round bead can trap air, causing future leaks. A triangular bead minimizes this risk. The triangular bead will also more readily compensate for irregularities in the windshield and in the pinchweld, another significant cause of leaks.

**APPLYING ADHESIVE:**

1. Remove the steel backing of the cartridge and pierce a large hole on the nozzle end.
2. Load cartridge into 26182 applicator gun.
3. Cut nozzle to desired bead size. We recommend a bead of 1/2” to 9/16” (13mm to 14mm) in height to provide the proper adhesion between the glass and the pinchweld. Adjust application to the depth of the body flange if necessary.
4. Apply adhesive in a continuous bead leaving no gaps.
5. Position the glass on car body making sure there is a 1/2” (13mm) clearance around the entire perimeter. Align the glass and insure the adhesive is in contact with the two surfaces around the entire perimeter.
6. Fill any voids between car body and glass with more adhesive.
7. Attach moldings, wiper arm and hardware.
8. Clean any excess adhesive using 19000 General Purpose Adhesive Cleaner.

**NOTE:** This product requires moisture in the air to fully cure. If spacers are used, they must be installed correctly. Improperly used, spacers may create future leaks and detract from the structural abilities of the adhesive. When using spacers, lay the adhesive bead first. Then press the spacer into the side of the adhesive bead towards the passenger compartment. Do **NOT** place the spacer on top of the bead. The adhesive bead must also extend well above the top of the spacer to insure proper contact with the glass.

**CLEAN UP**

Clean equipment immediately after use with 19000 General Purpose Adhesive Cleaner. Clean all spray equipment immediately after use as activated paints will harden in equipment.

**TECHNICAL DATA:**

- **APPEARANCE:** Black
- **SOLIDS:** 95%
- **CURE SYSTEM:** Moisture curing
- **FLASHPOINT:** <50
- **SHELF LIFE:** 1 year (unopened)
- **V.O.C. CONTENT:** No V.O.C.’s
- **TACK FREE TIME:** About 40 minutes @ 21°C (70°F) and 50% Relative Humidity.
- **CURE THROUGH TIME:** 24-36 hours at 70°F (21°C)/50% Relative Humidity
- **TENSILE STRENGTH:** 600 psi
- **LAP SHEAR STRENGTH:** 500 psi
- **HARDNESS SHORE A:** 50-55
- **APPLICATION TEMPERATURE:** 40°F (5°C) to 104 (40°C)
- **SERVICE TEMPERATURE:** - 40°F (-40°C) to 194°F (90°C) briefly up to 120
- **STORAGE:** Stored in cool dry conditions at temperatures of 25°C (78°C)
PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION:

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

PRODUCT USE:

Many factors beyond Pro Form’s control and uniquely within user’s knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user’s method of application.

WARRANTY, LIMITED REMEDY, DISCLAIMER AND LIMITATION OF LIABILITY

Pro Form Products Ltd. (“Pro Form”) makes no warranty, either express or implied, and specifically excludes any implied warranties or conditions of quality, whether of merchantability, fitness or otherwise. On any claim, irrespective of the legal theory invoked, Pro Form’s total liability shall not exceed the purchase price of the product. At its option, Pro Form may instead replace or repair the product. In no event shall Pro Form be liable for any damages of any type, or for loss.