

ISPOFLEX 55/4 HV

DESCRIPTION

ISPOFLEX 55/4 HV is a component, moisture curing polyurethane based adhesive for direct glazing in Automotive Glass Replacement.

PROPERTIES

- One component formulation
- Good non-sag properties
- Short cut-off string
- Cold application
- Fast curing – Rapid strength development
- High mechanical performance
- High Modulus
- High initial bond strength
- Can be overpainted

APPLICATIONS

It is especially useful in bonding windshield glass into automotive frames

INSTRUCTIONS

- Remove the damaged glass. Before application ensure that surfaces are clean, dry and free from dust and grease.
- Shake the ISPOPRIMER COMBO for at least 30 seconds (after hearing the ball move) before application.
- Apply ISPOPRIMER COMBO to the outer edge of the glass where the urethane bond will be made and allow to dry.
- Ensure that primer is tack-free dry before proceeding.
- Cut tip of the nozzle to desired shape and size to provide a bead height sufficient to give good contact with the windshield around the entire perimeter. A triangular shaped notch will provide the optimal bead shape and height.
- It is recommended to apply the adhesive with a pneumatic sealant gun.
- Apply **ISPOFLEX 55/4 HV** directly to the glass
- Position the glass by aligning the masking tape on glass and car body. Press glass in place to assure complete contact with the Polyurethane Windshield Adhesive

STORAGE AND SHELF LIFE

9 months if stored properly in its original package between +5 °C and 30 °C.

PACKAGING

Product	Volume	Package
Black	310ml	12
Black (Sausage)	600ml	12

RESTRICTIONS

- Avoid application below 5 °C and above 40 °C.
- Do not apply on frozen or wet surfaces or through standing water.

TECHNICAL PROPERTIES

BEFORE CURING		
Basis	: Polyurethane	
Consistency	: Thixotropic	
Curing Mechanism	: Moisture Curing	
Density	: 1,13±0,03 g/ml	
Tack free time	: 30±10 min. (23°C and 50% R.H)	
Curing Rate	: Min. 3,5 mm/day (23°C and 50% R.H)	
Sagging	: 0 mm	(EN ISO 7390)

AFTER CURING		
Hardness Shore A	: 55-60	After 28 days
Paintibility	: Yes *	
Elongation at break	: Min. 300%	(ASTM D412)
Tensile Strength	: Min. 4 N/mm ²	(ASTM D412)

*Considering the diversity of paint base and quality, compatibility tests should be done before application.