Technical Data Sheet

August 2017

6263 POLYURETHANE SEALANT

PRODUCT DESCRIPTION

TAFTFLEX 6263 is a single component polyurethane based elastomeric sealant which cures under the effect of atmospheric humidity to form a durable and tough elastomer. It can meet (FMVSS 212) with security dual air bags after 1 hour.

TYPICAL APPLICATION AREAS

TAFTFLEX 6263 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 of the quality of the substrates (refer to Instructions for use).

SPECIFICATIONS

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

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INSTRUCTION FOR USE:

Substrate preparation:

The substrates must be clean, even, dry and free of dust. Carefully respect the evaporation times of the solvents. When using solvents, extinguish 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 2 mm thickness. 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.

Never clean the old sealant with a solution containing alcohol.

- RAW GLASS:

Instructions : Activator/Primer/Windshield Sealant.

Clean with Activator according to the WOWO (wipe on/wipe off) method with a clean, dry and lint-free cloth (wipe as soon as the solvent is evaporated, i.e. 30 to 60 seconds after application). As the activator is very sensitive to humidity, the bottle must be closed immediately after use. If it is cloudy, do not use it. For this application, it is possible to use single-use impregnated wipes (kit containing an impregnated wipe and a dry wipe for WOWO). Let dry between 10 to 60 minutes after application according to temperature. In case of excessive drying time, repeat 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. Shake until agitator ball is moving. Shake another 30 seconds. 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 the bottle. Let dry between 15 and 60 minutes according to temperature before application of the sealant.

- WINDSHIELD WITH CERAMIC FRIT:

Instructions : Anti-silicone treatment / Activator / 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 with 3M Scotch-Brite Red (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 10 ml tube with single-use foam sponge applicator) followed by a waiting time of 15 to 60 minutes before application of the sealant.

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- ENCAPSULATED WINDSHIELD:
Degrease if needed with MEK or acetone (do not use alcohol) and respect a 10 minutes drying time, then apply Primer

- WINDSHIELD COATED WITH A PRIMER:
Degrease with MEK or acetone. After about 10 minutes, apply Primer

*Follow the same instructions for use than those indicated above for Primer

BONDING

TAFTFLEX 6263 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 packaging at about 20 °C before use. The windshield must be applied and pressed before the end of the skinning time. Do not apply in the presence of cured or non-cured silicones or hybrid sealants (MS, SPUR or STPE). Do not apply at temperatures lower than 5 °C.

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

CLEANING

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

PACKAGINGS

- 310ML Cartridges
- 600ML Sausages

STORAGE CONDITIONS

12 months in closed original packaging stored in dry premises at a temperature lower than 25°C. In cold weather, store the packaging at about 20°C before use.

HANDLING PRECAUTIONS

- Refer to Safety Data Sheet (MSDS) before using this product.
- Always wear personal safety gears when handling this product. (Impervious gloves, eyes protection goggles, respiratory mask.)