

# Technical Data Sheet

## Speed Set™ Windshield Adhesive/Sealant



### Overview

Speed Set™ is a one-part, high-strength, urethane adhesive/sealant formulated specifically for windshields and other fixed, non-movable glass. It meets Federal Motor Vehicle Safety Standards (FMVSS) 212 and 216 for windshield retention in front-impact and roof-crush testing.

### Features/Benefits

- Non-sag, european-grade formula
- Holds any size or shape bead – won't allow glass to slump or sink
- Adheres to old urethane, paint or primer
- May be used in short or long glass replacement methods
- High strength – excellent adhesion and flexibility
- Meets FMVSS 212 and 216 standards
- High initial strength – cures quickly
- Fast drive-away, with or without air bags

### Applications

- Windshields
- Fixed, non-movable glass

### Method of Application

Standard caulk gun

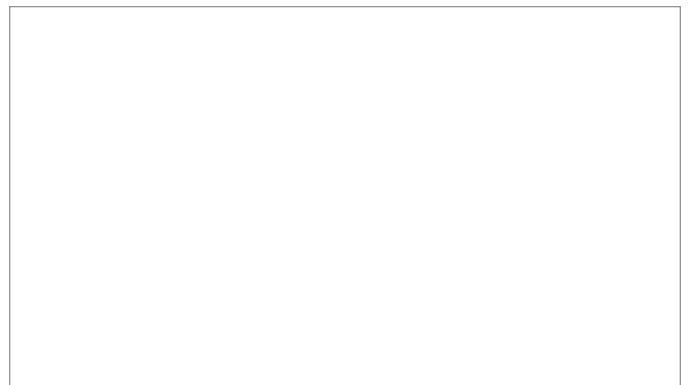
### Identification

Windshield adhesive/sealant

### Size

10.5 oz. (207ml) extruded aluminum cartridge with notched (VW) nozzle

(1 of 3)



## Directions for Use

### Long (Full-Cut) Method:

1. Remove the old windshield.
2. Remove all old urethane adhesive, loose paint, primer and rust from the pinch weld and make any repairs needed. Clean the pinch weld with Kent Automotive® Acrysol™ to remove any dirt, grease or oil. Use a pinch weld primer, self-etching primer or epoxy primer on any bare areas of the pinch weld.
3. Trial-fit the new windshield to ensure there is at least 1/2" of glass around the entire perimeter in contact with the pinch weld. Note: This 1/2" is in addition to the 5/16" width of the Speed Set™ Dam Tape (P20090) if it is going to be used. Adjust setting.
4. Apply a foaming glass cleaner like Kent Automotive® Glass Kleen Plus (KT11098) to the ceramic edge of the windshield. Allow the foam to dissipate/evaporate. Do not wipe the cleaner off the glass. If no "fisheyes" appear, wipe the glass cleaner off with a clean, dry paper towel and proceed to Step 7. If "fisheyes" appear, go to Step 5.
5. Use a white non-woven abrasive pad like Kent® Hand Pad KT11072 to scrub the ceramic edge of the glass where the adhesive will be applied. Wipe of the ceramic edge with a clean, dry paper towel. Do not use a shop rag.
6. Repeat Step 4. If "fisheyes" still appear there is an excessive amount of resin on the glass and the glass should not be used.
7. Apply a good quality glass primer to the area of the windshield where the adhesive will be applied.
9. If using Speed Set™ Dam Tape (P20090), apply it to inside edge of pinch weld.
10. Cut the nozzle for the Speed Set™ cartridge to make a bead 1/2" larger than the dam tape. Apply a bead of Speed Set™ behind the dam tape completely around the pinch weld. Do not apply to antenna leads.
11. Position glass on setting blocks, align, and press into place.
12. Tool excess Speed Set™ and water-test immediately. Tool or add more Speed Set™ at any leak points.
13. Reattach moldings and clean off any excess adhesive immediately with Kent® Acrysol™.

### Short (Partial Cut-Out) Method:

1. Remove the old windshield.
2. Most of the old urethane adhesive should be left on the pinch weld. However, if butyl tape or an unknown material was used, or if the original urethane is not bonded firmly to the pinch weld, it should also be removed and the **Long Method** should be used.
3. Trial fit the new windshield. Trim any high spots on the urethane bed to assure a flat surface. Adjust setting blocks and align as needed.
4. Apply a foaming glass cleaner like Kent Automotive® Glass Kleen Plus (KT11098) to the ceramic edge of the windshield. Allow the foam to dissipate/evaporate. Do not wipe the cleaner off the glass. If no "fisheyes" appear, wipe the glass cleaner off with a clean, dry paper towel and proceed to Step 7. If "fisheyes" appear, go to Step 5.
5. Use a white non-woven abrasive pad like Kent® Hand Pad KT11072 to scrub the ceramic edge of the glass where the adhesive will be applied. Wipe of the ceramic edge with a clean, dry paper towel. Do not use a shop rag.
6. Repeat Step 4. If "fisheyes" still appear there is an excessive amount of resin on the glass and the glass should not be used.
7. Apply a good quality glass primer to the area of the windshield where the adhesive will be applied.
8. Cut the nozzle on the Speed Set™ cartridge to create a 1/4" bead and apply on top of the old urethane completely around the pinch weld.
9. Position the glass on the setting blocks, align, and press into place.
10. Tool excess Speed Set™ and water-test immediately. Tool or add more Speed Set™ at any leak points.
11. Reattach moldings and clean off any excess adhesive immediately with Kent® Acrysol™.

## Drive-Away Times and Temperatures

### Vehicles Equipped with Air-Bags

Temperature	Drive-Away Time*	Relative Humidity
75°F (24°C)	4 hours	50%
50°F (10°C)	6 hours	50%
40°F (4°C)	8 hours	50%
32°F (0°C)	12 hours	50%

### Vehicles Not Equipped with Air-Bags

Temperature	Drive-Away Time*	Relative Humidity
75°F (24°C)	1-1/2 hours	50%
50°F (10°C)	2-1/2 hours	50%
40°F (4°C)	3 hours	50%
32°F (0°C)	5 hours	50%

\*NOTE: Drive-away times do not indicate material is fully cured. Lower temperatures and lower humidity will extend cure time.

## Technical Data

- Application thickness: 1/4" to 3/8"
- Work life: 30 to 40 minutes
- Skin time: 30 to 40 minutes
- Full cure: 24 to 48 hours
- Cure rate (4mm to 5mm thick): 24 hours at 65°F (18°C) and 65% humidity
- Drive-away: See tables above
- Lap sheer strength: 890 PSI
- Low temperature flexibility: +10°F (-12°C)
- Durometer hardness: 55±2 (Shore A)
- UV resistance: 500 hours, no deterioration
- Temperature range: -40°F to +350°F (-40°C to +177°C)