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# Technical Data Sheet Permatex® Glass Weld

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## PRODUCT DESCRIPTION

Permatex® Glass Weld is a one-component, moisture curing, high-performance adhesive that bonds auto glass to car bodies. Formulated to bond windshields and side or rear windows to passenger cars, trucks, tractors, and special vehicles, with a drive away time of 2 hours. This product can be used in all applications where a strong bond is necessary, including automotive topcoat paint, metal sheets, fiberglass, and reinforced plastic.

## PRODUCT BENEFITS

- One-component polyurethane
- Solvent free, odorless
- Fast curing
- Suitable for cold and warm application
- Outstanding thixotropy, high decking, non-sagging
- High viscosity, high green strength
- High modulus – maintains torsional rigidity and increases the vehicles NVH values
- Capable of withstanding high dynamic stresses
- Suitable for use with integral aerials

## TYPICAL APPLICATIONS

- Windshields
- Side and rear windows
- Backlites
- Sidelites

## DIRECTIONS FOR USE

### Assembly for windshield replacement

1. Clean dirt and debris before and after removing the window. Remove as much of the left over cured adhesive with a utility knife before proceeding.
2. Dry set the glass and align for uniform fit. Adjust as needed with setting blocks, ensuring there is a minimum 1/4" of glass bonding to the product.
3. Cut nozzle to desired bead size, a height of 1/2" to 9/16" and width of 1/4" to 5/16" is recommended. Note: Where installing encapsulated glass, apply a bead high enough to assure glass contact before encapsulation contacts the car body and prevents further setting.
4. Apply Permatex Glass Weld directly onto the remaining OEM film.
5. Press glass in place, ensuring sufficient contact is made with the adhesive.
6. Fill any voids with additional adhesive if necessary and remove excess from the sides.
7. Replace moldings and trims. Clean any excess urethane with adhesive cleaner/remover.

## Storage of Unused Product

1. Create a "Plug" by allowing excess material to extend beyond the extension nozzle or aerosol tip to cure, sealing and protecting the remaining product from moisture. For reuse, simply remove the cured product from the tip.

## For Cleanup

1. Remove uncured product from parts and hand-tools with Permatex® Fast Orange® Hand Cleaners. If skinned over, break film with a dry cloth to remove as much as possible. Remove the remaining material with Permatex® Gasket Remover.
2. Clean hands with a dry cloth or Permatex® Fast Orange® Hand Cleaner.

## PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Hybrid Polymer
Appearance	non-sag paste
Odor	Low odor
Specific Gravity	1.24
Viscosity	Thixotropic Paste

## TYPICAL CURING PERFORMANCE

Permatex® Glas Weld cures on exposure to moisture in the air. The product dries tack free in one hour and fully cures in 24 hours. Cure times will vary with temperature, humidity, and gap.

## PERFORMANCE OF CURED MATERIAL

After 7 days at 25°C (77°F), 50% Relative Humidity

	Typical Values
Hardness (Shore A)	>57
Elongation, %*	>700%
Tensile Strength, N/mm <sup>2</sup> (psi) **	>8.2 (>1200)

\*Material will stretch 7 times its original length before breaking.

\*\*Amount of force required to break material.

## TYPICAL ENVIRONMENTAL RESISTANCE

### Temperature Resistance Typical Values

Continuous, °C (°F)	-40 to 100	(-65 to 212)
Intermittent, °C (°F)	-40 to 140	(-65 to 284)

## GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.**

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).**

**ORDERING INFORMATION**

Part Number	Container Size
81100	10.5 oz Tube

**STORAGE**

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

**NOTE**

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