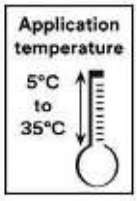
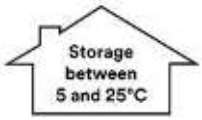
Product code : 74054A

SAPOFIX RAPIDE

Passes crash test after 2 hours according to FMVSS 212 standard.

DESCRIPTION





SAPOFIX RAPIDE is a one-component polyurethane-based sealant which cures under the effect of ambient humidity.

AREAS OF APPLICATIONS

SAPOFIX RAPIDE is intended for windshield and side windows bonding on vehicles with or without airbags in the automotive industry.
For other applications, contact our technical support.
The use or not of a primer depends on the quality of the substrates (see instructions for use). However, due to the large variety of substrates and installation conditions, it is necessary to make tests beforehand on difficult materials (particularly on non-ferrous or lacquered metals, painted substrates and other plastic substrates like PVC, PMMA or ABS) to determine whether abrasion or the use of a primer may be necessary to improve adhesion.
For further information, contact our technical support.

TECHNICAL DATA

Appearance	Thixotropic paste
Color	Black
Density at 20°C	1.24 ± 0.02
Application temperature	5 to 35°C
Skin formation time at 23°C and 50 % RH	25 to 40 min *
Cure time at 23°C and 50 % RH	> 3.5 mm after 24h
Shore A hardness (internal method IT-20 after ISO 868 - 3 seconds)	Approx. 57 after 14 days
Shearing resistance at 7d at 23°C and 50 % RH (Ford SAE J 1529)	> 3.5 MPa (> 500 psi)
Modulus at break (ISO 37)	Approx. 7.5 MPa
Elongation at break (ISO 37)	> 700 %
Tear strength (ISO 34)	Approx. 30 N/mm
Temperature resistance	-40 to +90°C (on cured sealant)
Water and salt spray resistance	Excellent

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Specific data	Minimum Drive Away Time (cars) with dual security airbags, according to FMVSS 212 standard: 2 hours at 23°C and 50% RH.

* this time depends on hygrometry and ambient temperature. In order to ensure a good adhesion, it is mandatory to do the bonding before the product has formed its skin.

INSTRUCTIONS FOR USE

Substrates preparation:
The substrates to be bonded must be even, dry, dust free and not have any traces of grease or other contaminants that could harm bonding (silicones or demoulding agents for example).
In case of a 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 on old polyurethane sealant.
Rub down any rusted area. Bare areas of the body must be cleaned with acetone or heptane before applying PRIMER WS.
Note: when using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

Depending on the type of windshield, it must be treated as follows:

- RAW GLASS:
EMFI's recommendations: Activator ACTIVATOR / Black primer PRIMER WS / Windshield sealant
Clean with ACTIVATOR according to the "WOWO" method ("Wipe On - Wipe Off") with a clean, dry and lint-free cloth (wipe as soon as the solvent is evaporated, i.e. 30 to 60 seconds after application).
Close immediately the bottle after use, as this product is very sensitive to humidity.
If it became cloudy, do not use it anymore.
For this application, it is possible to use single-use impregnated wipes (kit containing an impregnated wipe and a dry one for "WOWO").
Respect a drying time of 10 to 60 minutes depending on the temperature.
In case this drying time would be exceeded, renew the operation.
Then apply a thin and uniform layer of PRIMER WS with an applicator pad (or a 10 ml tube with single-use foam sponge applicator) in order to form a homogeneous film.
Well homogenize the primer before application:
- if packed in bottle: shake it thoroughly until agitator ball is moving then shake another 30 seconds,
- if packed in 10 ml tube: shake it thoroughly for 10 to 15 seconds.
Close the bottle immediately after use. Any contact of the primer with humidity will cause its curing. For this reason, the product must be used within 24 hours which follow the opening of the bottle.
Respect a drying time of 15 to 60 minutes depending on temperature before applying the sealant.
In case this time would be exceeded, the sealant's application can be done within 24 hours maximum, on the condition that there is no dust or traces of possible contaminants (grease or silicone).

- WINDSHIELD WITH CERAMIC FRIT:
EMFI's recommendations: Anti-silicone treatment / Activator ACTIVATOR / (Black primer PRIMER WS) / Windshield sealant
Bonding can be performed with or without the use of primer.
Bonding without PRIMER WS must be performed on a windshield with a ceramic frit ensuring optimal and uniform opacity to UV and not presenting silicone residues.
Failure to respect these two conditions can cause a partial or total loss of adhesion of the sealant on the windshield.
To eliminate silicone residues, degrease with heptane or methylethylketone (MEK), then abrade with "3M Scotch-Brite Red" (to overcome the "orange peel effect" likely to occur in presence of silicone residues). Degrease a second time with heptane or methylethylketone (MEK) and respect a drying time of 10 minutes according to temperature of the workshop.
Apply ACTIVATOR according to the method described for raw glass.