



Urethane Windshield Adhesive

4502

Urethane Windshield Adhesive is a one part moisture curing urethane adhesive designed to provide a strong bond to all windshield and backlight replacements. This product exhibits excellent adhesion to glass and pinchweld surfaces designed for use in a close cut-out method or tape installation. Urethane Windshield Adhesive passes FMVSS 212 strength requirements.



Mix Ratio

Ready to use.



Surface Prep & Application

Clean with glass cleaner. Use Acry Solvent 9783/9784 to clean bonding surface around perimeter of glass.

Close Cut-Out Method:

Clean the new windshield with glass cleaner and dry with a clean, lint free cloth. Apply Transtar Acry Solvent 9783/9784 to clean bonding surface around perimeter of glass. Allow 5 minutes to flash and dry off. Apply a thin coat of Pinchweld Primer over black ceramic band (frit). Allow to dry. Remove the old windshield cutting as close to the glass as possible. Trim away high spots off the original adhesive. Clean the remainder of original adhesive with a dry brush or compressed air. *Note: Transtar urethanes are primerless to the original urethane. Use Pinchweld Primer on any exposed bare or painted metal.* Gun a bead of 4502 Urethane Windshield Adhesive directly on the existing bed of urethane. Install windshield, applying even pressure on the bond line to assure uniform contact with the adhesive. Apply additional adhesive if required. Tool urethane around the edge and replace the molding. Clean up with Transtar Acry Solvent 9783/9784.

Full Cut-Out Method:

Clean the new windshield with glass cleaner and dry with a clean, lint free cloth. Wipe with a thin coat of Acry Solvent 9783 to the bonding surface around the edge of the windshield. Allow 5 minutes dry time. Remove all but a 1/16" - 1/8" layer of the original adhesive from the pinchweld. Clean the old urethane with Acry Solvent 9783/9784. Apply butyl tape to the inside edge of the pinchweld, pressing to assure complete contact with the surface before removing the release liner. Apply a bead of 4502 Urethane Windshield Adhesive behind the tape. The bead should be slightly higher than the profile of the dam tape. Install the windshield making sure to apply even pressure on the bond line to ensure contact with the adhesive. Additional urethane can be applied if necessary. Tool urethane around the edge of the windshield and replace the molding. Use Acry Solvent 9783/9784 to clean excess urethane. *NOTE: For maximum adhesion protection, windshields that have a black ceramic band will require priming with Pinchweld Primer.*

**Flash Times/Dry Times**

Skin time.....25 min @ 73°F (23°C), 50% RH and 3 mm thickness
 Drive away time.....2 hrs @ temps between 23°F (-5°C) and 104°F (40°C)
 Cure through time.....24 hrs @ 73°F (23°C), 50% RH and 3 mm thickness

**Product Specifications**

Color.....	Black	Size.....	11 fl oz
Shelf life.....	12 months	RTU solids.....	100%

Physical Performance Properties:
 Elongation at break700%
 Shore A hardness57
 Tensile strength1740 psi

Regulatory

Category.....	Adhesive		
VOC actual.....	0.03#/gal (4 g/l)	Wt % of exempt compound.....	0
VOC regulatory.....	0.03#/gal (4 g/l)	Vol % of exempt compound.....	0
Wt % of volatiles.....	<0.3%	Wt % of water.....	0
Density.....	10.3		

**Limitations & Precautions**

- Visit www.tat-co.com to assure use of the most current instructions and TDS on this product.
- See website (www.tat-co.com) for this document in other languages. (Vea el web site para este documento en español. Voir le site web pour ce document en français.)
- For use only by professional, trained painters. Not for sale to or use by the general public.
- Store between 50°F (10°C) and 77°F (25°C) in a cool dry place. The storage temperature should not exceed 77°F (25°C) for extended periods of time. Keep away from wet areas, direct sunlight and heat sources.

LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Transtar Autobody Technologies, Inc. warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within shelf life as stated in this datasheet, Transtar Autobody Technologies, Inc. will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Transtar Autobody Technologies, Inc. and its affiliates MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.