

SEALANTS

POWR 300 Series PP303HL Primerless High Modulus/Low Conductive Urethane

URETHANES
 POWR Urethane Auto Glass Adhesive

CRL
 PROFESSIONAL QUALITY
 OCTOBER 2009

PRODUCT NAME

POWR 300 Series PP303HL Primerless High Modulus/Low Conductive Urethane Primerless to Glass/Frit

PRODUCT DESCRIPTION

PP303HL is a one-part, fast-curing, isocyanate-free and primerless to glass, low conductive urethane, formulated for auto glass installations without the use of supporting tape while remaining easy to gun. Performance characteristics exceed criteria established by the automotive industry and those covered by FMVSS 212.

Use a fresh applicator each time the primer is applied.

- Where required, select and install appropriate sound blocking materials (foam tape).
- Apply a 1/2" to 5/8" (13 to 16 mm) high bead of PP303HL urethane adhesive around the entire perimeter of the pinchweld. Apply directly on top of the freshly trimmed existing bed of urethane or glass frit.
- Install glass into opening, using light hand pressure to assure complete contact with wet adhesive. Replace moldings and accessories.

LIMITATIONS

Not for use below 40°F (4°C) without following cold weather installation instructions.

TECHNICAL DATA

The physical properties of PP303HL Urethane Adhesive are shown below.

FEATURES	BENEFITS
Primerless to Glass	Reduced installation times, reduced costs, increased safety margin and reduced waste
Low conductive	Meets OEM specs.
Isocyanate-free	Safer for environment and technicians
Meets FMVSS 212	Safer and more secure installations
Easy gunning / Wide mouth cartridge	Save time and money

PHYSICAL PROPERTIES	VALUES
Base Polymer	Isocyanate-free Polyurethane
Color	Black
Tack Free Time	Approx. 10 minutes (At 73°F (23°C) / 50% RH)
Type of Curing	Moisture
Shore A (Hardness)	50-55
Tensile Strength	>1000 psi
Lap shear Strength	>550 psi

APPLICATION PROPERTIES	
Application Temperature	0°F to 113°F (-17°C to 45°C)
Storage	40°F to 90°F (4°C to 33°C)
Shelf Life	9 Months (In Unopened Container, When Stored at 77°F (25°C) / 50% RH)

NOTE: The foregoing information is published as general information only. The listed properties and performance characteristics are approximate values and are not part of the product specification.

INSTRUCTIONS

- Remove all exterior moldings, trim, and windshield following the vehicle manufacturer's instructions.
- Using the full cut method; inspect the old urethane to insure a firm bond exists to the pinchweld. Firmly bonded urethane should be trimmed, leaving a level bed around the entire pinchweld approximately 1/16" to 1/8" thick.
- If old urethane demonstrates any signs of peeling, or if butyl tape, silicone, or rust is apparent, remove all material down to the pinchweld and restore to OEM specifications prior to bonding.
- Prime pinchweld scratch marks and repaired rust areas with PP3MP Pinchweld Primer; allow 10 minutes to dry. (See PP3MP product data sheet for complete instructions.)
- Clean replacement windshield thoroughly with PWR22 Automotive Glass Cleaner. Caution: Some glass frits are conditioned with a variety of chemicals. CRL recommends that installers be aware that some frits may require additional preparation to insure a safe installation. If contamination is still present after the initial cleaning with PWR22 Glass Cleaner, CRL recommends wet scrubbing the bonding area with an open cell nylon pad (Cat. No. NP48) and re-clean with PWR22 as needed to insure no contamination exists. This process is recommended for both Primerless and Primed applications.
- Encapsulated parts should be primed with PP3UV EPDM/PVC Primer after cleaning first with PWR22.

PACKAGING

24-10.1 fl. oz. (300 ml) aluminum cartridges per case

CLEAN-UP

Wipe off excess PP303HL with CRL2032 General Purpose Adhesive Solvent.

HEALTH & SAFETY

For all CRL products, and for other products used in conjunction with CRL products, users must follow individual product data sheet and Material Safety Data Sheets (M.S.D.S.) for health and safety precautions. Always use protective eyewear. Inform your customer that: USE OF SEAT BELTS IS ALWAYS RECOMMENDED.

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S E A L A N T S

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PP303HL Safe Drive Away Chart

Minimum installation temperature: 40°F (4°C)
Minimum installation humidity: 10%
No special procedures required achieving times stated below

	90%RH	75%RH	50%RH	20%RH
>85°F (29°C)	2 hrs	2 hrs	2 hrs	2 hrs
70°F (21°C)	2 hrs	2 hrs	2 hrs	2 hrs
55°F (13°C)	2 hrs	2 hrs	2 hrs	2 hrs
40°F (4°C)	2 hrs	2 hrs	2 hrs	2 hrs

RH= Relative Humidity

For best results, CRL recommends that PP303HL Urethane Adhesive be used at temperatures of 25°F and above.

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