

# POWR BOND One Hour Windshield Adhesive

## PRODUCT NAME

CRL POWR BOND One Hour Windshield Adhesive

## PRODUCT DESCRIPTION

POWR BOND One Hour is a cold-applied, super fast curing, high viscosity, non-conductive adhesive designed for replacement bonding of automotive glass. It is engineered to conform to O.E.M. strength requirements when installed in accordance with our instructions. Passes or exceeds U.S. Federal Motor Vehicle Safety Standards FMVSS212 (Barrier Crash Test) and FMVSS208 (Occupant Crash Protection) in its most severe interpretation with dual air bags and unrestrained dummies. The fast curing formula is tack free in only 10 minutes and offers Safe Drive Away Time in as little as 1 hour at 0°F (-17.8°C).

## INSTRUCTIONS

For use by trained applicators only. Refer to CRL POWR BOND URETHANE ADHESIVE SYSTEM "Guide to Proper Installation". CRL POWR BOND Urethanes are supported by a One Step Primer 1214006 and aerosol glass cleaner PWR22 formulated for use in all areas of glass bonding, including the glass frit, pinchweld, and EPDM/PVC moldings. 1214006 One Step Primer must be used prior to any adhesive application to prevent glass displacement. Failure to do so may result in personal injury or property damage.

1. Remove all exterior moldings, trim, and cut glass out using appropriate tools and full cut method.
2. Dry fit new glass, mark with alignment tape, then remove for prep work. Minimum 1/4" (6 mm) bond required to maintain OEM specifications.
3. Inspect the old urethane to insure a firm bond exists to the pinchweld. Clean pinchweld area with plain water, wipe dry, then trim urethane to within 1/16" (2 mm) height (full cut method).
4. 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. Touch up bare metal scratches and repaired areas with Cat. No. 1214006 One Step Primer. Do not apply on old urethane. Butyl tape, foam dam or spacers are not needed.
5. Clean the inside of the windshield with POWR foaming glass cleaner (Cat. No. PWR22) and a lint free towel. If "beading" develops, the glass should be scrubbed with a nylon pad (Cat. No. NP48). Manufacturing residue or another contaminant may be on the glass. Clean the glass a second time. If the problem is not solved, return the glass to the vendor. Apply Cat. No. 12214006 One Step Primer to the frit area with a dauber. Allow to flash off for a minimum of 10 minutes, but no more than 8 hours before installing adhesive. This procedure must be performed above 40°F (4°C).
6. Apply Cat. No. 1214006 One Step Primer to encapsulated moldings if they are part of the bonding area.
7. Measure to the top of the roofline and cut the nozzles 1/6" (1.6 mm) longer with a "V-notch" of 1/2" to 5/8" (12 to 16 mm). This provides the appropriate triangular bead. Apply urethane at a 90 degree angle to the pinchweld or glass in a continuous motion around the entire perimeter. Close all starting and stopping points. Taking care not to touch the primed frit, set windshield and deck to fit.
8. Replace moldings in reverse order of removal. Clean up vehicle and return to customer after urethane has reached a safe drive away time (consult cure rate chart below).
9. Note temperature/humidity levels and batch codes for urethane and primer used on invoice.

## TECHNICAL DATA

The physical properties of 1214002 One Hour Urethane Adhesive are shown below.

PHYSICAL PROPERTIES		VALUE
Base Polymer	.....	Polyurethane
Color	.....	Black
Tack Free Time	.....	Approx. 10 minutes above 0°F (-17.8°C)
Type of Curing	.....	Moisture
Shore A (Hardness)	.....	50-55
Tensile Strength	.....	>750 psi
Lap Shear Strength	.....	>650 psi
APPLICATION PROPERTIES		
Application Temperature	.....	>0°F to 100°F (-17.8°C to 38°C)
Storage	.....	41°F to 77°F (5°C to 25°C)
Shelf Life	.....	12 months (In Unopened Container, When Stored at 75°F (24°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.

## PACKAGING

12-10.5 Fl. Oz. (310 ml) aluminum cartridges per case.

## CLEAN-UP

Wipe of excess 1214002 POWR BOND One Hour Urethane with CRL2032 General Purpose Adhesive Solvent or CRL99W Wipes in a Bucket.

## STORAGE

Adhesive and primer must be stored below 75°F (24°C). Storing above 75°F (24°C) can cure product in the cartridge.

## 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 Sheet (MSDS) for health and safety precautions. Always wear protective eyewear.

## POWR BOND SAFE DRIVE AWAY TIME RECOMMENDATIONS

WITHOUT AIRBAGS						
T/RH	> 0°F	≥ 25°F	≥ 35°F	≥ 55°F	≥ 72°F	≥ 92°F
≥ 85%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
65-85%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
45-65%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
25-45%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
≥ 10%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR

WITH AIRBAGS						
T/RH	> 0°F	≥ 25°F	≥ 35°F	≥ 55°F	≥ 72°F	≥ 92°F
≥ 85%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
65-85%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
45-65%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
25-45%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR
≥ 10%	1 HR	1 HR	1 HR	1 HR	1 HR	1 HR