



WINBOND INTERNATIONAL LTD

SIXTYHV PRIMERLESS

Technical Data Sheet - SixtyHV Primerless

Ver. 5.0 March 2021

**High decking, fast curing, primerless to glass, metals and plastics,
one-part SiMP elastic structural, windshield & assembly adhesive
1hour Drive Away Time FMVSS 212 Certified**

DESCRIPTION

SixtyHV is a high decking, fast curing, primerless to glass, metals and plastics, flexible and high performance SiMP – Silyl Modified Polymer adhesive for vehicle glass direct glazing. It is specifically designed to give a fast and safe drive-away time on vehicles fitted with airbags in 1 hour.

AREAS OF APPLICATION

Purposely designed for bonding windscreens in the Auto Glass Replacement aftermarket, side and rear windows to passenger cars, trucks, tractors and special vehicles. It is ideal for direct glazing on vehicles where high shear modulus and non-conductive properties are required. Also used for bonding fiberglass reinforced plastic elements (roofs, side and frontal panels) on vehicles. It can be used in all applications where a strong elastic-structural bonding to elements of different compositions (automotive topcoat paint, metal sheets, fiberglass and reinforced plastic) is necessary and that undergo a strong mechanical or thermal stress.

FEATURES

- SiMP Silyl-Modified Polymer
- Solvent and isocyanate free, odourless
- Primerless adhesion to glass, metals and plastics
- Fast application and curing
- Suitable for cold application
- Outstanding thixotropy, high decking, non-sagging, short cut-off string
- High viscosity and green strength: instant grab and load bearing capacity
- Capable of withstanding high dynamic stresses
- Suitable for use with integral aerals
- Prevents contact corrosion in aluminium-body vehicles
- No Hazard symbol required



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DRIVE AWAY TIME (DAT) information

TÜV Crash Tested

- Drive Away Time: 1 hour
- On vehicles fitted with both driver and passenger airbags

SixtyHV meets Federal Motor Vehicle Safety Standard 212 and all long-term durability requirements according to the full range of laboratory and Crash Test Data

TECHNICAL DATA

Appearance	Non-sag thixotropic paste	
Colour	Black.	
Chemical nature	SiMP Silyl-Modified Polymer	
Curing Mechanism	Moisture-curing	
Curing through volume [mm] (NPT Method 07) (24h - 23°C and 50% RH)	3.0	ca.
Hardness Shore A (DIN 53505)	62	ca.
Density [g/cm ³] (NPT method 06) (23°C and 50% RH)	1.44	ca.
Skin time [min] (NPT Method 17) (23°C and 50% RH)	15	ca.
Elastic modulus at 100% [N/mm ²] (ISO 37 DIN 53504)	2.5	ca.
Tensile strength [N/mm ²] (ISO 37 DIN 53504)	3.0	ca.
Tear strength [N/mm] (ISO 34-1)	7.4	ca.
Elongation at break [%] (ISO 37 DIN 53504)	230	ca.
Application temperature [°C]	From +5 to +40	
Temperature Resistance [°C]	From -40 to +100	



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APPLICATION

The surfaces to be treated should be perfectly clean, dry, and free from dust and grease. It is necessary to treat the bonding surface according to Winbond application guidelines, using Winbond Glass Wipe, degreaser / activator. SixtyHV is primerless to glass, metals and plastics. It is advisable to carry out preliminary adhesion tests on the support.

Do not cure in the presence of curing silicone sealants. Avoid contact with alcohol and other solvent cleaners during cure. When applying sealant, avoid air-entrapment. Since system is moisture-cured, permit sufficient exposure to air. Bonded elements may require additional holding or support during curing period. Tooling and finishing must be carried out within the tack-free time of the sealant.

CLEANING OF EQUIPMENT AND PERSONAL PROTECTIVE MEASURES

Clean the tools used with acetone or solvent. When the adhesive has not yet hardened, it can be removed using paper or a cloth. Once hardened, the product can only be removed mechanically. Avoid skin contact by using appropriate gloves. If it comes in contact with the skin, remove immediately and wash with soap and water.

PACKAGING

PE cartridge 290ml – 12 pieces per box

Foilpack 400ml – 12 pieces per box

Foilpack 600ml – 20 pieces per box

STORAGE AND SHELF LIFE

SixtyHV can be stored for 12 months in its original packaging (unopened container) between 10°C and 25°C in a cool, dry place. The storage temperature should not exceed 25°C for extended periods of time. Keep away from wet areas, direct sunlight and heat sources.

GENERAL INFORMATION

The information contained in this technical data sheet is to the best of our knowledge correct, being based on our knowledge and experience to date and cannot be used as a guarantee, due to the various different materials present on the market and the fact that the application conditions are not under our direct control and supervision. NPT srl, however, guarantees constant product quality. NPT srl, has the right to modify or up-date this technical data sheet according to requirements. Customers are kindly requested to verify that they are in possession of the latest version.

ALWAYS CONSULT THE MATERIAL SAFETY DATA SHEET BEFORE USING THE PRODUCT