

## PART NUMBER

Norton Urethane Windshield Sealer

076607**82735**

## PACKAGE SIZE

10.5 fl oz. Metal Cartridge (310 ml)

## DESCRIPTION

A one part urethane adhesive sealant for windshield and backlite installations. Easy handling, fast-set properties, excellent shelf life. Passes Motor Vehicle Safety Standard #212 windshield barrier test and #216 crush test.

## APPLICATION

Close Cut-Out Method:

1. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth
2. Clean bonding surface around perimeter of glass with Norton Panel and Adhesive Cleaner (076607**82780**). Allow 5 minutes to flash and dry off
3. Apply a thin coat of Pinchweld Primer over black ceramic band (frit). Allow to dry
4. Remove the old windshield cutting as close to the glass as possible
5. Trim away high spots off the original adhesive. Clean the remainder of original adhesive with a dry brush or compressed air.
6. Norton Urethane Windshield Sealer is primerless to the original urethane. Use Pinchweld Primer on any exposed bare or painted metal.
7. Gun a bead directly on the existing bed of urethane
8. Install windshield, applying even pressure on the bond line to assure uniform contact with the adhesive
9. Apply additional adhesive if required. Tool urethane around the edge and replace the molding
10. Clean up with Norton Panel and Adhesive Cleaner (076607**82780**)

Full Cut-Out Method:

11. Clean the new windshield with glass cleaner and dry with a clean, lint free cloth.
12. Clean bonding surface around perimeter of glass with Norton Panel and Adhesive Cleaner (076607**82780**). Allow 5 minutes to flash and dry off
13. Remove all but a 1/16" - 1/8" layer of the original adhesive from the pinchweld. Clean the old urethane with Norton Panel and Adhesive Cleaner (076607**82780**)
14. Apply butyl tape to the inside edge of the pinchweld, pressing to assure complete contact with the surface before removing the release liner
15. Apply a bead of Norton Urethane Windshield Sealer behind the tape. The bead should be slightly higher than the profile of the dam tape
16. Install the windshield making sure to apply even pressure on the bond line to ensure contact with the adhesive
17. Additional urethane can be applied if necessary. Tool urethane around the edge of the windshield and replace the molding.
18. Clean up with Norton Panel and Adhesive Cleaner (076607**82780**)

*NOTE: For maximum adhesion protection, windshields that have a black ceramic band will require priming with Pinchweld Primer*





## TECHNICAL DATA

COLOR:	Black
TENSILE STRENGTH:	>600 PSI
LAP SHEAR STRENGTH:	>500 PSI
ELONGATION AT BREAK:	300% at 72°F (22°C)
RTU Solids:	100%
HARDNESS:	SHORE A 50-55
TACK FREE TIME:	40 Minutes
CURE TIME:	24-36 Hours
SHELF LIFE:	1 Year
DRIVE AWAY TIME:	

	150 PSI LAP SHEAR (W/PASSENGER AIRBAG)	50 PSI LAP SHEAR (W/PASSENGER AIRBAG)
70°F (21°C)	6.5 hours	3.5 hours
50°F (10°C)	13 hours	8 hours

## REGULATORY

CATEGORY: ADHESIVE			
VOC Actual	0.55#/gal (66 g/l)	Weight % of Exempt Compounds	0
VOC Regulatory	0.58#/gal (70 g/l)	Volume % of Exempt Compounds	0
Weight % of Volatiles	<10%	Density of Material #/gal	10.8
Weight % of Water	0		

## PRECAUTIONS

For professional use only. Before use, read and follow all TDS, label and SDS precautions.

