



VABER INDUSTRIALE S.P.A.

PRODUZIONE ADESIVI E PRODOTTI CHIMICI INDUSTRIALI

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TECHNICAL DATA SHEET

N° 2540006E

VABER VITROFIX

Date of release: June 09, 2000

Revision n°: 6 date: 31.01.2008

Approval: R&D

Verified: QMS

1. DESCRIPTION

VABER VITROFIX is a one component fast set polyurethane adhesive sealant recommended for automotive direct glazing.

VABER VITROFIX cures in a short time allowing for removal of vehicle after 3 hours at 23°C and 50% relative humidity (passes FMVSS212)

2. CHEMICAL AND PHYSICAL CHARACTERISTICS

ASPECT	: thixotropic black paste.	
CONSISTENCY	: high viscosity	
SPECIFIC GRAVITY	: $1,20 \pm 0,10 \text{ g/cm}^3$	1*
EXTRUSION RATE	: 60 - 90gr/min Ø 4mm 4 bar	2*
SKIN TIME	: 25 - 40 min @23°C 50% r.h.	3*
OPEN TIME	: 15 min @23°C 50% r.h.	
CURE RATE	: 4 mm/24 hours @23°C 50% r.h.	
TENSILE STRENGTH	: >6 N/mm ² (typ. 9,2N/mm ²)	4*
ELONGATION AT BREAK	: 400%	4*
SHEAR STRENGTH	: >3,5 N/mm ²	5*
HARDNESS SHORE A	: 60	6*
SERVICE TEMPERATURE	: -30 +90°C	

1* VABER Method T-03 (ref. ASTM D 792-91)

2* VABER Method T-19 (rif ASTM D 2452-87)

3* VABER Method T-54

4* VABER Method T-55

5* VABER Method T-09(rif ASTM D 1002)

6* VABER Method T-11 (rif ASTM D 217-94)

3. APPLICATION AND USE

Preparation of windscreen:

Verify the surface is clean and free from oil and grease.

Prepare the glass as follows: wipe with a lint cloth soaked in activator and after 5 min, to a maximum of 3 hours, apply black primer (shake well bottle before use) with a brush or appropriate felt pad.

The black primer is dry after 10 minutes and should be covered with PU adhesive within 30 minutes.

Preparation of the body:

Vaber Vitrofix may be applied directly on freshly cut old polyurethane bead (do not apply black primer). If the car body is new wipe with a lint cloth soaked in n-heptane.

Adhesive application:

For best extrudability, we recommend to condition adhesive at room temperature prior to use.

Apply a triangular and homogeneous bead of material on windshield. Position the windshield within 15 minutes at 23°C, 50% r.h. High temperatures and humidity shorten open time.

4. PACKING

VABER VITROFIX is available in 310 ml aluminium cartridges.

5. STORAGE AND SHELF-LIFE

VABER VITROFIX stored in its original package, in a dry and well-ventilated area, at temperature between +5°C and +30°C has a shelf-life of 9 months from the manufacturing date.

6. NOTICE

The above information and our technical indications (both verbal and written or resulting from testing), in particular those that regard the applications and uses of our products, correspond to our best knowledge and experience; however, they do not constitute our warranty relative to final results or our responsibility deriving from any juridical relationship whatsoever.

In fact, considering the multiplicity of materials, supports, handling and storage conditions, as well as the conditions of production and utilization, the user, in function of his specific circumstances of use, must always preventively verify all the information and instructions reported above.

No assertion contained in this publication is to be considered authorization or suggestion to violate any industrial property rights of third parties.