



DOLPHIN WINDSCREEN FIX

DOLPHIN WINDSCREEN FIX is specially designed for automotive glass replacement industry with a high degree of strength utilizing a hybrid polymer technology.



TECHNICAL PROPERTIES

Properties	Test Method	Unit	Specifications
Chemical Base			1-C MS
Cure Mechanism			Moisture
Cure Type			Neutral (MS Hybrid)
<i>As Supplied @ 25°C, 50% RH</i>			
Color			Black
Consistency			Homogeneous paste
Specific Gravity	ASTM D 1475	g/cm ³	1.38 ± 0.02
Flow Properties	ASTM C 639	mm	0 (Non-sag)
Skin Over Time	ASTM C 679	minutes	Approx. 10
Tack Free Time	ASTM C 679	minutes	Approx. 20
Depth Cure, 24 hrs	Lab Test	mm	~ 3.8
<i>As Cured – 7 Days @ 25°C, 50% RH</i>			
Hardness (Shore A)	ASTM D 2240	Points	55 - 60
Tensile Strength	ASTM D 412	N/mm ²	≤ 3.10
Elongation	ASTM D 412	%	≤ 450
Young's Modulus	ASTM D 412	MPa	≤ 1.40
Service Temp.		°C	-40 to +90

Note:

* Curing time (Skin Over Time & Tack Free Time) may vary depending on climatic condition during application.

* Information on this data sheet is subject to change without prior notice and should not be used for writing specifications.

TYPICAL USES

- Car front windscreen bonding and other automotive glass fixing and sealing application.
- Bonding and sealing of sunroof systems, floor construction elements, as well as windows & doors.
- Works for construction and building applications.
- Elastic bonding for industrial use as well as car and container industry.

KEY FEATURES

- Specially formulated for windscreen fixtures in automotive industry.
- Advanced Hybrid Polymer technology.
- Excellent adhesion and bonding strength with high mechanical properties.
- Very good non-sag properties and fast curing.
- Non-corrosive to metals.
- Excellent resistance to weather and UV.



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PACKAGING

DOLPHIN WINDSCREEN FIX is available in standard caulking cartridges (310ml), and packed sausages (600ml)

SURFACE PREPARATION

Ensure that the surface to be sealed is clean, dry, sound and grease free. Metals should be cleaned with a non-oily solvent soaked clean cloth. Solvent should be wiped from the surface with a clean dry cloth. Use an alcohol such as methylated spirits on glass. When used on remedial work, all existing sealant must be removed. Porous substrates such as concrete, brickwork, mortar etc. must be mechanically cleaned of loose particles using a steel brush, sanding disc or any similar means.

Remove old glass in accordance to manufacturer's instruction. All existing/old sealants and wipers must be removed according to manufacturer's instructions before application.

APPLICATION INSTRUCTION

Cut nozzle in V-shape and at a sharp angle slightly wider than the desired bead. Screw nozzle on the cartridge. For best results, apply the sealant with the use of piston-type application gun or air gun to ensure uniform thickness of bead.

TOOLING AND FINISHING

Immediately tool sealant after application and before skin formation. Tooling of sealant should be done in one continuous stroke. Remove masking tape immediately after tooling is completed.

CLEANUP AND REMOVAL

Uncured sealant may be removed from tools, equipment and non-porous surfaces with solvents. For porous substrates, allow the sealant to cure before removal by peeling or other mechanical means. Cured sealant can only be removed mechanically.

LIMITATIONS

With oil based alkyd type paints it has been noted that the drying time for the paint is increased. Not for PE, PP, Teflon, neoprene and bituminous surfaces. Preliminary tests for substrate compatibility is recommended if doubts on suitability exists.

STORAGE AND SHELF LIFE

When stored in original unopened container at or below 77°F (25°C) in dry warehouse conditions, **DOLPHIN WINDSCREEN FIX** has a shelf life of 12 months from manufacturing date. Containers should always be kept sealed when not in use.

HANDLING PRECAUTIONS

Use in well-ventilated area. Direct contact of uncured sealant may irritate eyes and skin. Do not handle contact lenses with sealant on hands. Obtain medical attention. In case of skin contact, remove from skin and flush with water.

KEEP OUT OF REACH OF CHILDREN • KEEP CONTAINER TIGHTLY CLOSED • FOR INDUSTRIAL & PROFESSIONAL USE

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made. AMI reserves the right to change the properties of its products without notice.

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