

SODAL UNIVERSAL CLEANER 165

Adhesion Enhancer

Technical Data:

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|----------------|--|
| Density | 0.80 g/cm ³ |
| Solids content | 1 % maximum |
| Composition | Adhesion enhancer in an alcohol solution |
| Appearance | Colourless to slightly amber liquid, low viscosity |

(*) these values may vary depending on environmental factors such as temperature, moisture, type and size of substrates

Product:

Soudal Universal Cleaner 165 is an adhesion enhancer necessary in the preparation of the glass where Soudal Universal Primer 175 will be used.

Application:

The required quantity is very small and amounts to a few microns of wet product. Use a clean and dry cotton cloth, wet it with Soudal Universal Cleaner 165 and pass it over the surface to be prepared leaving a thin film. Then clean it down with a dry clean cloth.

Drying time of the film:

Immediately

Covering time:

Maximum 4 hours after wiping.

After 4 hours, apply again Soudal Universal Cleaner 165.

Storage:

Shelf life is 9 months from manufacturing date, in its original un-opened container if stored between 5°C and 35°C maximum. Soudal Universal Cleaner 165 is sensitive to air moisture: bottles have to be closed tightly immediately after use and must be used within 5 days maximum. Frequent opening of the bottle will cause a step-by-step deterioration of the adhesion promotion characteristics of the product.

The necessity to frequently re-open a bottle is an indication that a small size bottle from our range should be selected. Cleaner which has obviously thickened or changed in appearance after opening must not be used. Do not open bottle until use.

Packaging:

Soudal Universal Cleaner 165 is available in 10ml or 1 Liter metal bottles.

Remark: The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.





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Check List:

- Shake the bottles well before use.
- Always keep the mouth of the bottle closed & tight, do not leave it open.
- Keep the material in original container for storage, do not change aluminum bottle.
- Take the cleaner out as and when needed in desired quantity.
- Do not put unused cleaner back in bottle.
- Keep it away from the fire/welding area. Do not smoke, do not drink, do not inhale.
- Use cleaner and give 2-3 minutes to dry it completely.
- Use primer and give 5-10 minutes to dry it completely.



Testing Procedure:

- Open the Soudal Universal Cleaner 165 bottle.
- Clean the metal surface with lint free fabric & apply Soudal Universal Cleaner 165.
- Clean the glass surface with lint free fabric & apply Soudal Universal Cleaner 165.
- Clean the body structures surface with lint free fabric & apply Soudal Universal Cleaner 165.

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Removal:

Uncured sealant may be removed from tools and equipment, worker hands with McCoy Soudal Swipex.

(A specially designed tissue paper compatible with sealant chemicals and which cleans the sealant 100% without leaving any mark and without damaging painted surface). Contains skin friendly aloe vera & sweet fragrance.

Once cured, the material can only be removed mechanically.



General Information:

The information contained in this technical data sheet is to the best of our knowledge based on our knowledge and experience till 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.

McCoy Soudal guarantees constant product quality. McCoy Soudal 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.

Other accessories available in McCoy Soudal basket



Vacuum Cup Lifters | Pneumatic & Manuel Guns | Spatula | Clamp | Wind Screen Removal Kit

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SEALANT APPLICATION CHECKLIST

To ensure perfect sealing and bonding application, you can use this check list for your internal audit.

Masking:

- Clear the surface with lint free cotton fabric to remove dust.
- Apply masking tape at distance of 1mm from the application area.
- Press the masking tape firmly for better finish.
- Complete the masking-sealant sealing-tooling-de-masking with in 3 hrs.
- Remove masking tape immediately after tooling and before the sealant skins over.
- For better finish use five line sealant masking tape.

Mouth opening:

- Sausage lock- removes this lock completely by cutting it.
- Open sausage/ cartridge just before the application (max.5 minutes before).
- Aluminum cartridge – puncture its mouth with thick round nail/ tool, puncture it with max diameter for the smooth flow of sealant.
- Do not hit the bottom of cartridge to avoid the damage of bottom plunger.

Nozzle cutting:

- Plastic nozzle - cut it as per the groove of filling (in cross direction)
- Adjust the nozzle depth as per the groove, change nozzle if required.(A) Round bead for sealing, (B) triangular bead for glass bonding with base of 10 mm & height of 12-15mm.
- For bead size refer to the table given by McCoy Soudal as per size and weight of component.

Sealing:

- Adjust the pneumatic gun air pressure. (6 Bar).
- Fill the sealant in constant bead.
- Do not over fill or under fill sealant.
- Try to make joint less bead.

Tooling:

- Finish tooling before skin formation.
- Please check skin formation during season variation.
- Do not leave tooling during lunch or day close.

De-masking:

- Remove the masking tape after tooling and finishing.
- Try to complete tape application & removing activity within 3 hrs.
- Avoid hand touch to the body to avoid sealant marks.

Finishing:

- Do finishing in two parts (A)- before de-masking (B) after de-masking.
- Use soapy water solution.
- Avoid excess bubble formation due to soap.

Cleaner & primer:

- Shake the bottles well before use.
- Always keep the mouth of the bottle close and tight, do not leave it open.
- Keep the material in original container for storage, do not change aluminum bottle.
- Take the primer out as and when needed in desired quantity.
- Do not put unused primer back in bottle.
- Keep it away from fire/welding area. Do not smoke, do not drink, do not inhale.
- Use cleaner and give 2-3 minutes to dry it completely.
- Use primer and give 5-10 minutes to dry it completely.

Glass bonding:

- Check the glass & body aperture / frame by just keeping it together for size & its variation (if needed it varies company to company policy & practice).

- Remove paint particles from frame.
- Remove tape spacers from glass.
- Clean both glass & frame perimeter by Soudal Universal Cleaner 165. Cleaning width 50mm, wait for 2-3 minutes till chemical evaporates completely.
- Apply Soudal Universal Primer 175 on the periphery of glass & frame, application width 20 mm. Wait for 5-10 minutes till it dries completely.
- Apply sealant on the frame in V-shape cut nozzle to achieve triangular bead of 10mm base x 12- 15mm height.
- Fix the glass by lifting it with vacuum cup lifter, hold the glass on the spacer, also put small spacer throughout the sealant periphery of sealant to keep it away from the body frame. (spacer shore A-hardness should be 30-45).
- Keep the glass on hold with the help of tape & other support for 4-8 hours minimum.

NOTE IT

- Wash your hands completely before taking food.
- Read the instructions mentioned on the packing carefully.
- Always check the product expiry date before use.
- Read all safety instructions carefully and follow them.
- Keep the product in the original packing.
- For more information refer to material safety data sheet.
- Follow the storage conditions for long lasting life & best use of the material.

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