

## Recommended Procedure For Installation Of DuraShield Windscreens.

*Dry fit windscreen into frame first to check correct fit, and arrange rubber setting blocks to allow 6mm gap around all edges for correct urethane adhesion to frame and glass.  
Remove glass again leaving setting blocks in place.*

1. Rub down edges of windscreen and frame with Cleaner E clear primer, **taking care not to let any cleaner to come in contact with the edge of the laminate.** Use a paper towel or similar to wipe on, then wipe off immediately with a clean paper towel.
2. Paint on Simson Primer G Extra (U.V. Blackout primer) with a dabber or similar, to glass edge and frame and allow to dry for 30 minutes minimum. **Pay careful attention to keep primer off the laminate edge.** If using masking tape around edge of glass for a clean black line, leave masking tape on for 30 mins before removing.
3. Apply Simson ISR 70-08 Urethane to window frame, and fit windscreen into rebate within 5 minutes of application of urethane.
4. Fill in around the edges of the windscreen with Simson ISR 70-08 and tool off flush with the edges. In places where urethane will end up thicker than 6mm, leave first application to dry for 12 hours, before backfilling and tooling off. This is to allow the urethane to cure completely underneath. Neutral cure black silicone can be used for tooling off with, allowing urethane to completely cure first.
5. Butt joins in centre of windscreen can be sealed with clear or black neutral cure silicone or Simson ISR 70-08 directly onto the glass without the use of clear primer or blackout primer.
6. Clean up tools and residue with Cleaner E clear primer.



← Edge of laminate

#### NEW ZEALAND

Freephone: 0800 883 336  
Phone: +64 9 422 2565  
Email: [info@glasshape.com](mailto:info@glasshape.com)

#### AUSTRALIA

Freephone: 1800 042 716  
Brisbane: +61 7 3175 0501  
Melbourne: +61 3 9099 0200  
Perth: +61 8 9468 2722

Email: [info@glasshape.com.au](mailto:info@glasshape.com.au)

#### USA

Seattle: +1 206 538 5416  
New York: +1 332 255 6319  
Email: [info@glasshape.com](mailto:info@glasshape.com)

## SMP PRODUCTS FOR THE AUTOMOTIVE INDUSTRY

### Simson® ISR 70-08 (SMP) Silyl Modified Polymer

**CODE** **SMS1** 290ml Cartridge 12 per box

**CODE** **SMS1F6** 600ml Cartridge 12 per box

#### Features

- Primeless application
- Very simple pretreatment and excellent durable adhesion
- Free from isocyanates, solvents and PVC
- No staining of the skin or motor vehicle body
- Neutral odourless and fast curing
- Easy residue clean up
- Drive away time with twin airbags is one hour (crash tested)

#### Product

A one component, moisture curing, elastic glass adhesive based on Silyl modified Polymer (SMP) with a high UV-resistance. It is especially developed for bonding windscreens. Provides a rapid and efficient way to fasten many different materials for OEM, coach works, mobile units, etc, especially where immediately or shortly after installation objects have to be moved during the manufacturing process. Conforms to FMVSS 212.

#### Applications

- Bonding glass provided with a ceramic coating
- Bonding glass without ceramic coating in combination with the use of Simson® Primer G
- UV-resistant seal between windscreens and direct bonded automotive glass.

- High mechanical strength, permanently elastic behavior
- Excellent UV stability
- Paint compatible with most industrial paints
- Low electrical conductivity
- Low volume shrinkage
- Conforms to FMVSS 212 Crash Testing

#### Method of Use

Simson®ISR 70-08 can be easily extruded with a hand or air pressure gun at temperatures between (+5°C and +35°C). The speed of application can be improved by heating the product up to 70°C. For good adhesion a clean, dry and grease free surface is necessary. Cleaning of the ceramic coated layer can be done with Simson® wash Primer M (a one step pretreatment) or glass wipe frit band cleaner

(WBGW). The pretreatment with Simson® Primer M is also adequate for many closed surface such as aluminium, coated steel, polyester (GRP). Within a few minutes of applying Simson® Primer M or glass wipe frit band cleaner (WBGW), the screen can be bonded. The screen has to be bonded within 15 minutes of applying the ISR 70-08.

When no ceramic coating is available or the ceramic coating doesn't supply sufficient UV protection, Simson® Primer G is required after the screen has been cleaned with Simson® Primer M or glass wipe frit band cleaner (WBGW) unless a cover shields the glass adhesive interface from UV radiation.

Cleaning tools or removing uncured residue can be done with a clean colourless cloth wetted with glass wipe frit band cleaner (WBGW)

**Note: It is recommended to make a trial first to check possible attack of the substrate by these cleaners.**

TECHNICAL DATA		
Basic Material	Silyl Modified Polymer	
Curing Method	Moisture	
Specific Gravity	Ca. 1.4g/ml	
Skin Forming Time	Ca. 10min	(20oC/50% R.H)
Open Time	< 15 minutes	(20oC/50% R.H)
Curing Speed After 24hrs	Ca.3mm	(20oC/50% R.H)
Shore A Hardness	Ca. 65	(DIN 53505)
Volume Change	< 3%	(DIN 52451)
Green Strength	Ca.1800Pa	Physica Rheometer MC1000
Electrical Volume Resistivity	> 1011 0cm	(DIN 53482)
Tensile stress (100%)	Ca. 2.1 Mpa	(DIN 53504/ISO 37)
Tensile Stress At Break	Ca. 2.9 Mpa	(DIN 53504/ISO 37)
Elongation At Break	Ca. 225%	(DIN 53504/ISO 37)
Shear Stress	Ca. 2.5Mpa	(DIN 53283/ASTM D1002)
Tear propagation	Ca. 13 N/mm	(DIN 53515/ISO 34)
E-Modulus (10%)	Ca. 4.3 Mpa	(DIN 53504/ISO 37)
Solvent Percentage	0%	
Isocyanate Percentage	0%	
Temperature Resistance	-40°C till + 120°C	
Application Temperature	+5°C till + 35°C	
UV Resistance	Very Good	
Colour	Black	



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Perth: +61 8 9468 2722

Email: info@glassshape.com.au

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## Simson® Primer G

<b>CODE</b>	<b>SMSG</b>	250ml	Container
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- Developed as a black primer for use on glass (not having a ceramic coating) in order to provide a UV protecting coat, before applying special adhesives for bonding glass (also PMMA and PC) in the automobile, bus, ship and train industries
- Pretreatment of glass substrates without ceramic coating
- Repair of damaged paint layers on metallic supports



## Simson® Cleaner E - Primer

<b>CODE</b>	<b>SCE</b>	500ml	Container
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- A preparation agent ideally suitable for cleaning and degreasing substrates for bonding or sealing afterwards with Simson® ISR products
- Cleaning and degreasing metals such as steel, galvanized steel, aluminium and zinc
- Cleaning and degreasing joints in teakwood decks prior to application of primer
- Removing uncured sealant and adhesive from substrates and tools
- Degreasing and cleaning glass substrates



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