Method Statement

ROCKFIX AUTOMOTIVE GLASS

(One Component, RTV – Room Temperature Vulcanizing, Neutral Silicone Sealant)

Rev.: A, Date: 03.11.2026

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Section A: General Considerations

Tools & Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement.

Equipment Type	Equipment Description
Protective clothing	▪ Protective overalls ▪ Chemical-resistant (nitrile) gloves ▪ Safety goggles / eye protection
Mixing equipment	▪ N/A – one component, ready to use
Surface Preparation Equipment	▪ Lint-free, clean cotton cloths ▪ STAR cleaning solvent ▪ Power blower / oil-free compressed air ▪ Sharp scraper, knife and gasket remover
Application Equipment	▪ Masking tape ▪ Cutter for nozzle, tooling spatula ▪ Manual cartridge (caulking) gun ▪ Power extrusion gun / drum pump

High temperature working

It is suggested that, for temperatures above 35˚C, the following guidelines are adopted as good working practice:

1. Store cartridges and drums in their original sealed packing, clear of the ground, in a dry, shaded place below 25°C, avoiding exposure to direct sunlight.

2. Keep equipment cool; it is especially important to keep cool those surfaces of the equipment which will come into direct contact with the material itself.

3. Avoid application during the hottest times of the day or on glass and body panels heated by direct sun; work in a shaded or covered bay. Do not apply above +40°C.

4. Have the glass, sealant and tools ready before starting, so that the bead is applied continuously and the glass is set in place before a skin forms (within approx. 10 minutes).

Application - points of note

STAR operates a policy to encourage the use, where possible, of approved or licensed applicators. This ensures that applications are completed satisfactorily so that the long term performance of the materials is assured.
For contractors who wish to apply the materials themselves STAR is also able to offer technical assistance and training. Either on-site or at its Training Centre in the Kingdom of Saudi Arabia.

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Section B: Application Instructions

1. Surface Preparation

1.1 Surfaces (glass, pinch weld / frame flange, sunroof or vinyl top seating) must be clean, dry, sound and free from oil, grease, wax, dust, loose particles, mould, release agents and any other contamination.

1.2 Remove old sealant from the frame with a sharp scraper or knife. If old material has skinned over, break the film with a dry cloth, remove as much as possible, and remove any remaining material with a gasket remover.

1.3 Blow off dust and loose particles using a power blower or clean, oil-free compressed air.

1.4 Clean non-porous substrates with STAR cleaning solvent and a clean, lint-free cotton cloth. Wipe dry immediately with a second clean cloth before the solvent evaporates from the surface.

1.5 Soap, detergent or water treatments are not recommended for surface preparation. Apply masking tape along the edges where a clean sealant line is required.

2. Priming

2.1 Priming is generally not required on clean, properly prepared glass and non-porous substrates.

2.2 For unknown or difficult substrates, carry out an adhesion and substrate compatibility test before use, and consult the STAR Technical Department for a suitable primer.

3. Application

3.1. Cut the tip off the **ROCKFIX AUTOMOTIVE GLASS** cartridge and puncture the internal foil seal with the nozzle.

3.2. Fit the nozzle and cut it at a 45° angle to the desired bead width. Insert the cartridge into the caulking gun, or position the power extrusion gun for drum supply.

3.3. Apply a continuous, uniform bead onto the prepared substrate, avoiding gaps and air entrapment. For full mechanical properties, apply at temperatures between +5°C and +40°C.

3.4. Assemble and press the glass, sunroof or vinyl top into position before the end of the skin formation time (within 10 minutes). Tool the bead to ensure complete contact, then pull off the masking tape in the direction of the joint before the skin forms.

3.5 **ROCKFIX AUTOMOTIVE GLASS** forms a skin in approx. 5 minutes, is tack-free in approx. 10 minutes and cures at approx. 3 mm per 24 hours. Support or tape the glass in position and do not stress the joint until the sealant has cured. Use opened cartridges within 24 hours.

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4. Notes

4.1 This material is not paintable.
4.2 May not be suitable for sensitive natural stones such as marble, granite or quartz, as staining may occur.
4.3 Not to be used in contact with sensitive metals such as lead, copper, brass, zinc, carbon steel, galvanized iron or magnesium, as corrosion may occur.
4.4 A substrate compatibility test is always recommended before use.
4.5 Do not apply on wet, damp or contaminated surfaces, or when the substrate temperature is below +5°C or above +40°C.
4.6 Opened cartridges should be used within 24 hours.
4.7 Shelf life is 12 months in the original sealed packing, stored clear of the ground in a dry, shaded place below 25°C.

5. Cleaning

5.1 **Uncured ROCKFIX AUTOMOTIVE GLASS:** remove excess sealant carefully with a soft scraper, then with a cloth just moistened with white spirit or soapy water. Repeat with another clean, moistened cloth in one continuous stroke. Remove masking tape immediately after tooling.
5.2 **Cured ROCKFIX AUTOMOTIVE GLASS:** cut away excess cured material with a very sharp knife. Cured material can only be removed mechanically.
5.3 **Skin contact:** do not use solvent to remove the product from skin; use soap and water. For safe handling, storage and disposal, refer to the latest STAR MSDS.

Section C: Approval and Variations

This method statement is offered by STAR Technology as a 'standard proposal' for the application of ROCKFIX AUTOMOTIVE GLASS. It remains the responsibility of the Engineer to determine the correct method for any given application.
Where alternative methods are to be used, these must be submitted to STAR Technology for approval, in writing, prior to commencement of any work. STAR Technology will not accept responsibility or liability for variations to the above method statement under any other condition.