

Sikaflex[®]-265 DG-3

Cold applied direct glazing adhesive with good non-sag properties

Technical Product Data

Chemical base	1-C polyurethane	
Colour (CQP ¹⁾ 001-1)	Black	
Cure mechanism	Humidity-curing	
Density (uncured) (CQP 006-4)	1.2 kg/l approx.	
Non-sag properties (CQP 061-1)	Good	
Application temperature	cold	
Tack-free time ²⁾ (CQP 019-1)	35 min. approx.	
Open time ²⁾ (CQP 526-1)	20 min. approx.	
Curing speed (CQP 049-1)	see diagram 1	
Shrinkage (CQP 014-1)	2% approx.	
Shore A hardness (CQP 023-1 / ISO 868)	50 approx.	
Tensile strength (CQP 036-1 / ISO 37)	8 N/mm ² approx.	
Elongation at break (CQP 036-1 / ISO 37)	500% approx.	
Tear propagation resistance (CQP 045-1 / ISO 34)	15 N/mm approx.	
Tensile-shear strength (CQP 046-1 / ISO 4587)	5 N/mm ² approx.	
G-Modulus (CQP 081-1)	1.6 N/mm ²	
Glass transition temperature (CQP 509-1 / ISO 4663)	-45°C (-49°F)	
Electrical resistance (CQP 079-2 / ASTM D 257-99)	10 ⁶ Ω cm approx.	
Service temperature (CQP 513-1)	-40 - 90°C (-40 - 195°F)	
Shelf life (storage below 25°C) (CQP 016-1)	unipack	9 months
	drum / pail	6 months

¹⁾ CQP = Corporate Quality Procedures ²⁾ 23°C / 50% r.h.

Description

Sikaflex[®]-265 DG-3 is a cold applied, 1-component polyurethane direct glazing adhesive with good initial grip to prevent glass slip-down and cures on exposure to atmospheric humidity. Sikaflex[®]-265 DG-3 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- 1-component formulation
- PVC-free
- Good working characteristics
- Room temperature application
- Short cut-off string
- Good standing and slip-down behavior
- Suitable for pump application

Areas of Application

Sikaflex[®]-265 DG-3 is adhesive for direct glazing applications. The adhesive shows good working characteristics and is well suited for automated processes in the in the OEM Transportation Industry. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Cure Mechanism
Sikaflex®-265 DG-3 cures by reaction with atmospheric humidity. At low temperatures the water content of the air is lower and the curing reaction proceeds at a slower rate (see diagram 1).

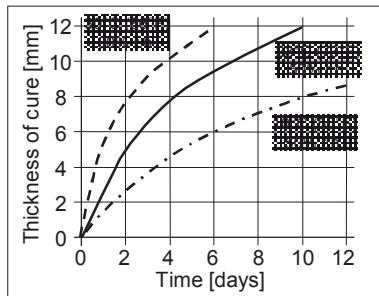


Diagram 1: Curing speed Sikaflex®-265 DG-2

Chemical Resistance

Sikaflex®-265 DG-3 is resistant to fresh water, aqueous cleaning agents (neutral, acid or alkaline types, chlorine free in normal concentrations); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids and caustic solutions and solvents.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application

Surface preparation

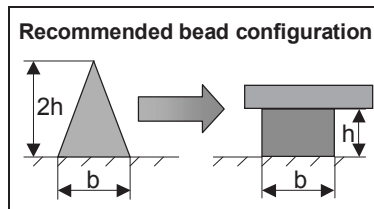
Surfaces must be clean, dry and free from grease, oil and dust. Additional surface treatment depends on the specific nature of the substrates and manufacturing process. Therefore all recommendations must be determined by preliminary tests discussed with Sika.

Consult actual Product Data Sheets for detailed information concerning pre-treatment agents. Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

For satisfactory results the adhesive must be applied with adequate pump or dosing units.

To ensure uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see illustration).



Do not apply the adhesive at temperatures below 10°C or above 40°C. The recommended temperature of the substrates is between 15°C and 30°C.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured Sikaflex®-265 DG-3 may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean or a suitable industrial hand cleanser and water. Do not use solvents!

Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet.

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Pre-treatment Chart
- General guidelines for bonding and sealing with Sikaflex® products.

Packaging Information

Unipac	600 ml
Pail	23 l
Drum	195 l

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.



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