

Sikaflex[®]-265

Direct glazing and UV-resistant joint sealant adhesive for buses, trucks and rail vehicles

Technical Product Data

Chemical base	1-C polyurethane
Colour (CSQP ¹⁾ 001-1)	Black
Cure mechanism	Humidity-curing
Density (uncured) (CSQP 006-4)	1,2 kg/l approx.
Non-sag properties (CSQP 061-1)	Very good, with no tendency to sag or slump
Application temperature	+ 10°C to + 35°C
Tack-free time ²⁾ (CSQP 019-1)	45 min. approx.
Open time ²⁾ (CSQP 526-1)	30 min. approx.
Curing speed (CSQP 049-1)	(see diagram)
Shrinkage (CSQP 014-1)	< 1%
Shore A hardness (CSQP 023-1 / ISO 868)	45 approx.
Tensile strength (CSQP 036-1 / ISO 37)	6 N/mm ² approx.
Elongation at break (CSQP 036-1 / ISO 37)	450% approx.
Tear propagation resistance (CSQP 045-1 / ISO 34)	10 N/mm approx.
Tensile-shear strength (CSQP 046-1 / ISO 4587)	4,5 N/mm ² approx.
G-Modulus (CSQP 081-1)	0,7 N/mm ²
Glass transition temperature (CSQP 509-1 / ISO 4663)	-45°C, approx.
Electrical resistance (CSQP 079-2 / ASTM D 257-99)	10 ⁶ Ω cm approx.
Service temperature (CSQP 513-1)	permanent -40°C to +90°C
Shelf life (storage below 25°C) (CSQP 016-1)	cartridge and unipac drum and hobbock 9 months 6 months

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

Description

Sikaflex[®]-265 is a high-performance elastic gap-filling 1-c polyurethane adhesive that cures on exposure to atmospheric humidity to form a durable elastomer.

Sikaflex[®]-265 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- 1-C formulation
- Low odour
- Excellent working characteristics
- Fast cure time
- Resistant to ageing and weathering
- Solvent- and PVC-free
- Equally suitable for manual application and bulk dispensing
- Primerless application possible

Areas of Application

Sikaflex[®]-265 is designed for direct glazing applications in both the OEM and repair markets, and is suitable for use with mineral glass-based windows. Before installing laminated safety glass windshields incorporating heating elements or radio aerials in the PVB sandwich layer, we recommend to contact Sika's Technical Service Department for advice. Sikaflex[®]-265 can be tooled to a very fine finish. It contains special stabilizing ingredients to enhance its UV resistance, therefore it is suitable for use in exposed joints.

Industry



Cure Mechanism

Sikaflex®-265 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).

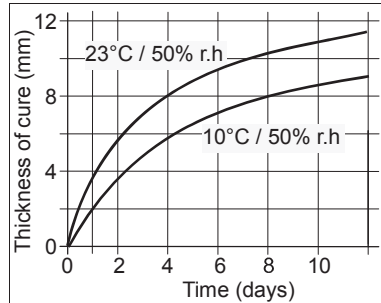


Diagram 1: Curing speed for Sikaflex®-265

Chemical Resistance

Sikaflex®-265 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

Removal of old windows

Remove damaged glass in accordance with the vehicle manufacturer's instructions.

Surface preparation

Surface must be clean, dry and free from all traces of grease, oil and dust. The bond faces must be treated as follows:

Toughened glass with uniform and continuous opaque, mineral based ceramic frit with light transmission* more, than 0,1%**.	Sika® Aktivator + Sika® Primer-206 G+P
Toughened glass with uniform and continuous opaque, mineral based ceramic frit with light transmission* less, than 0,1%**.	Sika® Aktivator

Metal with paint primer or with partial new painting (< 25%)	Sika® Aktivator
Metal painted with two part finish lacquers	Sika® Aktivator + Sika® Primer-206 G+P
Old polyurethane direct glazing adhesive (cut face)	Sika® Aktivator

* Getag 200D, visible range

**For laminated glass this limit is 0,2%.

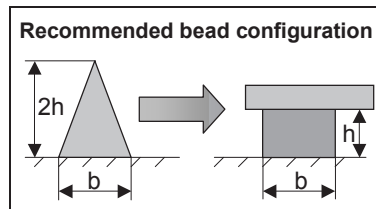
Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

Cartridge: Pierce cartridge membrane.

Unipac: Place unipac in the application gun and snip off the closure clip.

Cut off the tip of the nozzle to give desired adhesive bead geometry. For satisfactory results the adhesive must be applied with a hand-operated cartridge gun, piston-type compressed-air gun or pump operated bulk dispensing equipment. To ensure uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see illustration).



Fill exposed joints with Sikaflex®-265 completely without voids until slightly overfilled, then remove excess adhesive with a suitable filling knife or spatula. If necessary, the surface of the adhesive can be tooled to a neat, smooth finish using Sika® Tooling Agent N as a lubricant.

Do not apply at temperatures below 10°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C.

For advice on selecting and setting up a suitable pump system, as well

as on the techniques of pump operated application, please contact the System Engineering Department of Sika Industry.

Further Information

Copies of the following publications are available on request:

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

Packaging Information

Cartridge	300 ml
Unipac	400 + 600 ml
Hobbock	23 l
Drum	195 l

Important

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.

Note

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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.



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