Industry

Sikaflex®-256

The primerless windscreen adhesive system for direct glazing in Automotive Glass Replacement

Technical Product Data

Chemical base		1-C polyurethane
Color (CQP[1] 001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured) (CQP 006-4)		1,2 kg/l approx.
Non-sag properties (CQP 061-1)		Very good
Application temperature		5°C to 35°C
Tack-free time[2] (CQP 019-1)		40 min. approx.
Open time[2] (CQP 526-1)		30 min. approx.
Curing speed (CQP 049-1)		(see diagram)
Shore A hardness (CQP 023-1 / ISO 868)		50 approx.
Tensile strength (CQP 036-1 / ISO 37)		7 N/mm2 approx.
Elongation at break (CQP 036-1 / ISO 37)		400% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)		11 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)		5 N/mm2 approx.
Safe Drive-Away Time[2] (cars) according to FMVSS 212 / 208 (CQP 511-1)	with double side airbag without airbag	6 h 2 h
Volume resistivity (CQP 079-2 / ASTM D 257-99)		1 x 10^7 Ω cm approx.
Service temperature (CQP 513-1)	permanent	-40°C to +90°C
Shelf life (storage below 25°C) (CQP 016-1)		9 months

[1] CQP = Corporate Quality Procedures [2] 23°C / 50% relative humidity

Description

Sikaflex®-256 is a primerless 1-component direct glazing adhesive. It is easy to apply, with a paste-like consistency that cures on exposure to atmospheric moisture. Sikaflex®-256 provides a long tack-free time and ensures a safe application even under warm conditions.
Sikaflex®-256 offers quality combined with safety.
Sikaflex®-256 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- Primerless pre-treatment
- Good application behavior like bead stability / good non-sag properties
- Short cut-off string
- Cold application
- One-component formulation
- Automotive OEM quality

Areas of Application

Sikaflex®-256 is suitable for direct-glazing applications in the Automotive Glass Replacement business.
This product is to be used by professional experienced users only. If this product is used for other applications than Automotive Glass Replacement, test with current substrates and conditions have to be performed to ensure adhesion and material compatibility.

Cure Mechanism

Sikaflex®-256 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds somewhat more slowly (see diagram 1).

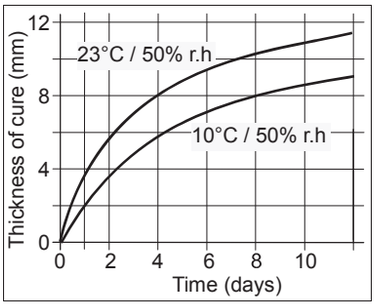

Diagram 1: Curing speed for Sikaflex®-256

Chemical Resistance

Sikaflex®-256 is resistant to fresh water, seawater, limewater, sewage effluent, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids and caustic solutions or 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 glass
Remove damaged glass in accordance with the vehicle manufacturer's instructions.

Surface preparation
Surfaces must be clean, dry and free from grease, oil and dust. The surfaces must be treated with a cleaning and activating agent or primed with the appropriate primer as follows:

Glass with uniform and continuous opaque, mineral based ceramic frit (valid for passenger cars only)	Sika® Aktivator
Old polyurethane direct glazing adhesive (cut face)	Sika® Aktivator
Metal with paint primer or with partial new painting (< 25% of bonding surface)	Sika® Aktivator
Metal with paint primer or with partial new painting (>= 25% of bonding surface)	Sika® Aktivator + Sika® Primer-206 G+P
Glass without ceramic or without large cover trim (valid for passenger cars only)	Sika® Aktivator + Sika® Primer-206 G+P

Detailed information on the use and application of these adhesion promoters will be found in the actual Product Data Sheets. These documents and instructions must be consulted prior the usage of Sikaflex®-256 .

Application
Cartridge: Pierce cartridge membrane.
Unipack: Place unipack in the application gun and snip off the closure clip.
Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations.
To ensure a uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see figure 1 below).
Do not apply at temperatures below 5°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C.

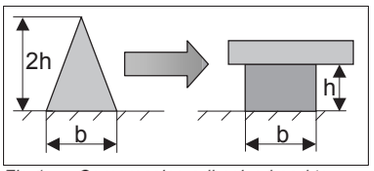

Fig 1: Compressing adhesive bead to final size

Removal
Uncured Sikaflex®-256 may be removed from tools 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

Copies of the following publications are available on request:
- Material Safety Data Sheets
- Mentioned Product Data Sheets

Packaging Information

Cartridge	300 ml
Unipack	400 ml 600 ml

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.

Important

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

Legal Note

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