

# Sikaflex<sup>®</sup>-250 PC

## Fast-cure OEM adhesive

### Technical Product Data

Chemical base	1-C polyurethane
Colour (CSQP <sup>1)</sup> 001-1)	Black
Cure mechanism	Humidity-curing
Density (uncured) (CSQP 006-4)	1,1 kg/l approx.
Non-sag properties	Very good
Application temperature	85°C
Tack-free time <sup>2)</sup> (CSQP 019-1)	10 min. approx.
Curing speed (CSQP 049-1)	(see diagram)
Shrinkage (CSQP 014-1)	2% approx.
Shore A hardness (CSQP 023-1 / ISO 868)	55 approx.
Tensile strength (CSQP 036-1/ ISO 37)	7 N/mm <sup>2</sup> approx.
Elongation at break (CSQP 036-1 / ISO 37)	450% approx.
Tear propagation resistance (CSQP 045-1 / ISO 34)	15 N/mm approx.
Tensile-shear strength (CSQP 046-1 / ISO 4587)	4,0 N/mm <sup>2</sup> approx.
Electrical resistance (CSQP 079-2 / ASTM D 257-99)	10 <sup>9</sup> Ω cm approx.
Service temperature (CSQP 513-1)	-40°C to +90°C
Shelf life (storage below 25°C) (CSQP 016-1)	6 months

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

### Description

Sikaflex<sup>®</sup>-250 PC is a high-performance elastic gap-filling 1-c polyurethane adhesive that cures on exposure to atmospheric humidity to form a durable elastomer. Sikaflex<sup>®</sup>-250 PC is applied at a temperature of 85°C ± 5°C and develops high initial strength. As such it is eminently well suited for medium to large production runs. Sikaflex<sup>®</sup>-250 PC is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

### Product Benefits

- 1-C formulation
- Suitable for automated application
- High initial strength
- Fast cure
- Very short cut-off string
- Rapid strength development
- Ideal for the OEM market
- Tested and approved by the German TÜV road safety testing authority

### Areas of Application

Sikaflex<sup>®</sup>-250 PC is suitable for bonding applications in automated processes.

Industry



### Cure Mechanism

Sikaflex®-250 PC is partially reacted by heating to 85°C. The final cure is a reaction of the adhesive with atmospheric humidity. Water from the atmosphere diffuses into the adhesive. The water content of the air and the rate of reaction are temperature-dependent. At low temperatures the water content of the air is generally lower and the curing reaction proceeds more slowly.

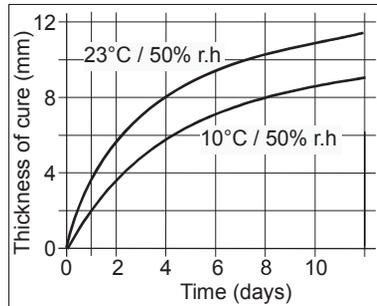


Diagram 1: Curing speed for Sikaflex®-250 PC

### Chemical Resistance

Sikaflex®-250 PC is resistant to fresh water, seawater, limewater, aqueous cleaning agents, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral 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

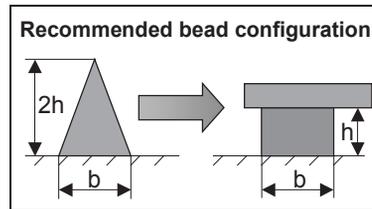
#### Surface preparation

Surfaces must be clean, dry and free from all traces of grease, oil and dust. The bond faces must be treated with a cleaning and activating agent or primed with the appropriate primer. Advice on specific applications is available from the Technical Service Department of Sika Industry.

### Application

Apply Sikaflex®-250 PC with a suitable pump system  
**Cartridges:** Pierce cartridge membrane.

Cut off the tip of the nozzle to suit joint. To ensure uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see illustration).



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

### Removal

Uncured Sikaflex®-250 PC can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean Towel or another suitable industrial hand cleaner and water. Do not use solvents.

### Further Information

Copies of the following publications are available on request:

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

### Packaging Information

Cartridge	310 ml
Hobcock	23 l
Drum	195 l

### 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.

### 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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