

Sikaflex®-265

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

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	Very good
Application temperature	10°C to 35°C
Tack-free time ² (CQP 019-1)	45 min. approx.
Open time ² (CQP 526-1)	30 min. approx.
Curing speed (CQP 049-1)	(see diagram 1)
Shrinkage (CQP 014-1)	<1% approx.
Shore A hardness (CQP 023-1 / ISO 868)	45 approx.
Tensile strength (CQP 036-1 / ISO 37)	6 N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	450% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	10 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	4.5 N/mm ² approx.
G-Modulus (CSQP 081-1)	0.7 N/mm ² approx.
Glass transition temperature (CSQP 509-1 / ISO 4663)	-45°C approx.
Electrical resistance (CQP 079-2 / ASTM D 257-99)	10 ⁶ Ωcm approx.
Service temperature (CQP 513-1)	permanent -40°C to 90°C
Shelf life (storage below 25°C) (CQP 016-1)	cartridge and unipac drum and hobbock 9 months 6 months

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C (73°F) / 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 glassbased 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.

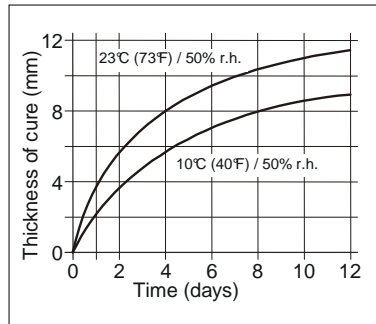


Diagram 1: Curing speed for Sikaflex®-265

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 206G+P
Old polyurethane direct glazing adhesive (cut face)	Sika® Aktivator
Metal with paint primer or with partial new painting (<25% of area)	Sika® Aktivator

Metal painted with two part finish lacquers	Sika® Aktivator + Sika® Primer 206G+P
Toughened glass with uniform and continuous opaque, mineral based ceramic frit with light transmission less than 0.1%	Sika® Aktivator

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).

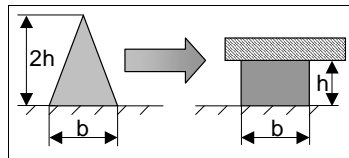


Figure 1: Recommended bead configuration

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
Unipack	400+600 ml
Hobbock	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 should 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.



Further information available at:
www.sika.co.uk
www.sika.com

Sika Limited
Industry
Watchmead, Welwyn Garden City
Hertfordshire, AL7 1BQ
United Kingdom
Tel: +44 (0)1707 394444
Fax: +44 (0)1707 329129

