Product Data Sheet
Version 2 (02/2011)

Sikaflex®-255 Extra

Direct Glazing Adhesive

Industry

Technical Product Data:

Chemical base	One-component polyurethane
Colour (CQP [1] 001-1)	Black
Density (uncured) (CQP 006-4)	1,2 kg/l
Non-sag properties	Good
Cure mechanism	Moisture-curing
Application temperature	5 - 40ºC
Skin time[2] (CQP 019-1)	60 min. approx.
Open time[2] (CQP 526-1)	50 min. approx.
Curing speed (CQP 049-1)	(see diagram 1)
Volume shrinkage (CQP 014-1)	7% approx.
Shore A hardness (CQP 023-1 / ISO 37)	50 approx.
Tensile strength (CQP 036-1 / ISO 37)	5 N/mm^2 approx.
Elongation at break (CQP 036-1 ISO 37)	500% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	9 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	3.5 N/mm^2 approx.
Safe Drive Away Time[2] (cars) according to FMVSS 212 / 208 — with double side airbags without airbags	16 h 8 h
Volume resistivity (CQP 079-2 / ASTM d 257-99)	10^7 Ωcm approx.
Thermal resistance (CQP 513-1) — 24 hours	140ºC
Shelf life (stored below 25°C) (CQP 016-1)	9 months

[1] CQP = Corporate Quality Procedure [2] 23ºC / 50% r.h.

Description:

Sikaflex®-255 Extra is a high performance, elastic, gap-filling, one part polyurethane adhesive that cures on exposure to atmospheric moisture to form a durable elastomer.

Sikaflex®-255 Extra is manufactured in accordance with the ISO 9001/14001 quality assurance system and the responsible care program.

Product benefits:

- One part formulation
- Low odour
- Fast cure
- Short cut off string
- Good workability

Areas of application:

Sikaflex®-255 Extra is suitable for direct glazing application in both the OEM and repair markets.

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®-255 Extra cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds more slowly (see diagram 1).

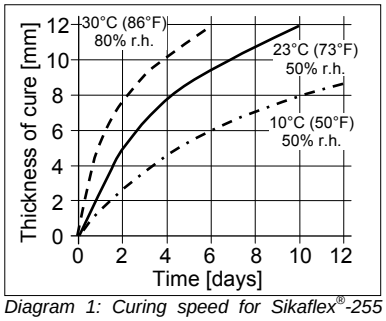

Diagram 1: Curing speed for Sikaflex®-255 Extra

Chemical resistance:

Sikaflex®-255 Extra is resistant to water, proprietary aqueous cleaning agents (incl. windshield washing fluids containing alcohol); 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 paint thinners.
The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of application:

Removal of old window
Remove damaged glass in accordance with the vehicle manufacturer's instructions.

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 as follows:

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

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

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. Apply the adhesive with a suitable piston gun. To ensure uniform thickness of adhesive bead, we recommend that the adhesive is applied in the form of a triangular bead (see figure 1).
In combination with Sika®Aktivator PRO the substrate temperature must be between -10°C and 35°C, for other pre-treatments the lower limit is 5°C.

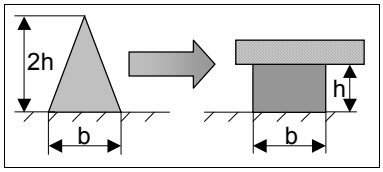

Figure 1: Recommended bead configuration

Removal
Uncured Sikaflex®-255 Extra may be removed from tools and equipment with Sika® Remover-208 or an-other suitable solvent. Once cured, the material can only be removed mechanically.
Hands and exposed skin should be washed immediately using Sika® Handclean Towel or a 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
- Mentioned Product Data Sheets

Packaging Information

Cartridge	310 ml
Unipack	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.

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.

Note:

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