

Sikaflex®-265

All in one Adhesive/Sealant solution with good ageing and weathering resistance for commercial vehicles

Technical Product Data

Chemical base	1-C polyurethane
Colour (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)	Good
Application temperature	+ 10°C to + 35°C
Skin time ²⁾ (CQP 019-1)	45 min. approx.
Curing speed (CQP 049-1)	3.5 mm / 24 h approx.
Shrinkage (CQP 014-1)	< 1%
Shore A hardness (CQP 023-1 / ISO 868)	50 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)	14 N/mm approx.
Tensile-shear strength (CQP 046-1 / ISO 4587)	4,5 N/mm ² approx.
Electrical resistance (CQP 079-2 / ASTM D 257-99)	10 ⁸ Ω cm approx.
Service temperature (CQP 513-1)	-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% r.h.

Description

Sikaflex®-265 is a 1-component elastic high-performance direct glazing adhesive with gap-filling capabilities based on humidity-curing polyurethane technology. Sikaflex®-265 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- 1-C formulation
- Low odour
- Excellent working characteristics
- Resistant to ageing and weathering
- Solvent- and PVC-free
- Equally suitable for manual application and bulk dispensing
- Wide adhesion range
- Suitable for bonding and sealing

Areas of Application

Sikaflex®-265 is designed for direct glazing, general bonding and sealing applications. Good tooling properties and the enhanced weathering resistance allows use for exposed joints.

This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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).

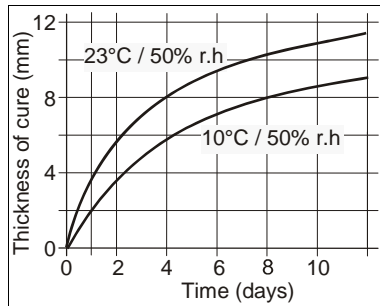


Diagram 1: Curing speed for Sikaflex®-265

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. Additional surface treatment depends on the specific nature of the substrates and the manufacturing process. Therefore, all recommendations must be determined by preliminary test.

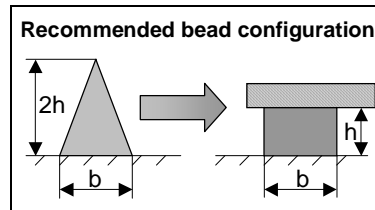
Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

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 adhe-

sive must be applied with a hand-operated cartridge gun, piston-type compressed-air gun. To ensure uniform thick-ness 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 a tested 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.

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

Unipac	600 ml
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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 Australian version of the Product Data Sheet for the product concerned, copies of which will be supplied on request.

