Technical Data Sheet

Sikaflex®-265
Direct glazing adhesive for buses, trucks and rail vehicles

Technical product data:

Chemical base	one-part polyurethane
Colour	black
Density (DIN 53479) (uncured)	1,20 kg/l approx.
Stability (non-sag properties)	very good, with no tendency to sag or slump
Cure mechanism	moisture-curing
Tack-free time*	45 minutes approx.
Rate of cure*	3 mm/24 hrs. approx. (see diagram)
Shrinkage (DIN 52451)	< 1%
Shore A hardness (DIN 53505)	45 approx.
Tensile strength (DIN 53504)	> 6 N/mm^2
Elongation at break (DIN 53504)	> 450%
Tear strength (DIN 53515)	10 N/mm approx.
Tensile-shear strength (EN 1465) for a 4 mm applied thickness	> 4,5 N/mm^2
Glass transition temperature (DIN 53445)	-45°C approx.
Service temperature (continuous) short term (up to 8 hrs.)	-40°C to +90°C 120°C
Volume resistivity (DIN 53482)	10^6 Ω cm approx.
Shelf life (stored below 25°C)	9 months for cartridge and unipac 6 months for drum and hobbock

* = at 23°C and 50% relative humidity

Description:
Sikaflex®-265 is a high-performance elastic gap-filling one-part polyurethane adhesive that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-265 is manufactured in accordance with the ISO 9001/14001 quality assurance system.

Product benefits:
- one-part 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

Cure mechanism:
Sikaflex®-265 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds at a slower rate (see diagram).

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 glass-based windows.
Before installing laminated safety glass windshields incorporating heating elements or radio aerials in the PVB sandwich layer, we recommend that you contact Sika's Technical Service Department for advice.
Because Sikaflex®-265 can be tooled to a very fine finish, and because it is specifically designed for enhancing its UV resistance, it is eminently suitable for use in exposed joints.

Chemical resistance:
Sikaflex®-265 is resistant to fresh water, aqueous, acid, neutral and alkaline chlorine free cleaning agents; temporarily resistant to fuels, mineral oils,vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids and caustic solutions, bleach 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, wax and dust. The bond faces must be treated with a cleaning as follows:

Glass with fitted cover trim or opaque painted border	Sika® Activator
Glass with black ceramic border, light transmission factor toughened safety glass: < 0,1%, 400 – 500 nm (for cars and BTR only) light transmission factor laminated safety glass: < 0,2%, 400 – 500 nm (for cars and BTR only)	Sika® Activator
Glass with black ceramic border, light transmission factor toughened safety glass: > 0,1%, 400 – 500 nm (for cars and BTR only) light transmission factor laminated safety glass: > 0,2%, 400 – 500 nm (for cars and BTR only)	Sika® Activator + Sika®-Primer-206 G+P
Sheet metal, painted (cataphoretic immersion coatings, two part finish lacquers)	Sika® Activator or Sika® Remover-208
Old polyurethane direct glazing adhesive (cut face)	Sika® Activator

Detailed information on the use and application of Sika® adhesion promotors will be found in the appropriate product data sheet.
The above information is offered for general guidance only. Advice on specific applications will be given on request.

Application: Pierce cartridge membrane and peel back completely. Place the 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 a uniform thickness of adhesive bed, we recommend that the adhesive be applied in the form of a triangular bead (see diagram).

Fill exposed joints with Sikaflex®-265 completely without voids until slightly proud, then remove excess adhesive with a suitable filling knife or spatula. If necessary, the surface of the adhesive may be tooled to a neat, smooth finish using Sika® Tooling Agent N as a lubricant.

Attention: Do not allow other finishing agents to come into contact with water-sensitive paint finishes. Soaps and detergents can cause carbon particles to be released from the surface of uncured adhesive, and are therefore unsuitable for this application.

Important: 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. Approximate drive-away times for vehicles following glass installation or replacement under optimum cure conditions (23°C/50% rh) are as follows:

Buses and trucks (windshield)	6 hours
Rail vehicles	12 hours

For advice on selecting and setting up a suitable pump system, as well as on the techniques of pump-operated application, please contact our System Engineering Department

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance.

Removal:
Uncured Sikaflex®-265 may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.
Hands and exposed skin should be washed immediately using a suitable industrial hand cleanser and water. Do not use solvents!

Further information:
Copies of the following publications are available on request:
– Sika Primer Chart
– Safety Data Sheet

Note: