

Sikaflex®-260 N

High-performance, multi purpose adhesive

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 - 35°C (50 - 95°F)
Tack-free time ² (CQP 019-1)	40 min approx.
Open time ² (CQP 526-1)	30 min approx.
Curing speed (CQP 049-1)	(see diagram 1)
Shrinkage (CQP 014-1)	2.5% approx.
Shore A hardness (CQP 023-1 / ISO 868)	50 approx.
Tensile strength (CQP 036-1 / ISO 37)	7 N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	300% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	8 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	4 N/mm ² approx.
Volume resistivity (CQP 079-2 / ASTM D 257-99)	1 x 10 ⁷ Ωcm approx.
Service temperature (CQP 513-1)	permanent -40 - 90°C (-40 - 195°F)
Shelf life (storage below 25°C) (CQP 016-1)	cartridge / unipack 9 months drum / hobbock 6 month

¹⁾ CQP = Corporate Quality Procedure²⁾ 23°C (73°F) / 50% r.h.**Description**

Sikaflex®-260 N is a primerless 1-component, multi purpose adhesive. It is easy to apply, with a paste-like consistency that cures on exposure to atmospheric moisture. Sikaflex®-260 N provides a long tack-free time and ensures a safe application even under warm conditions. The material offers quality combined with safety. Sikaflex®-260 N is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Product Benefits

- Wide adhesion range
- Good application behavior and workability
- Short cut-off string
- Good bead stability and non-sag property
- Cold application
- Manual- and pump application
- One-component formulation
- Automotive OEM quality

Areas of Application

Sikaflex®-260 N is suitable for various applications such as structural bonding or direct glazing within the Mass-Transportation business.

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.



Cure Mechanism

Sikaflex®-260 N cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly (see diagram).

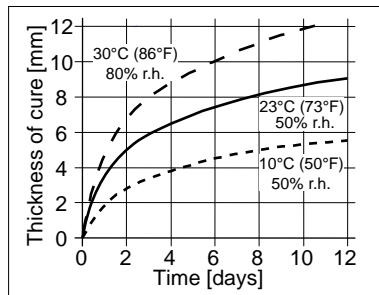


Diagram 1: Curing speed Sikaflex®-260 N

Chemical Resistance

Sikaflex®-260 N is resistant to fresh water, seawater, lime water, sewage effluent, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic 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 grease, oil and dust. The surfaces 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

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.

To ensure a uniform thickness of adhesive bead, we recommend that the adhesive is applied in form of a triangular bead (see figure 1 below).

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 please contact the System Engineering Department of Sika Industry.

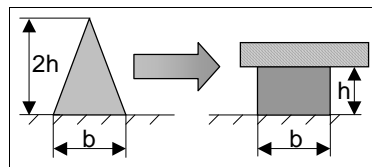


Figure 1: Recommended bead configuration

Removal

Uncured Sikaflex®-260 N may 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 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
- Sika Pre-Treatment Chart
- General Guidelines - Bonding and Sealing with Sikaflex®

Packaging Information

Cartridge	300 ml
Unipack	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 shall 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:

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