

Sikaflex[®]-256

The black-primerless windscreen adhesive system for direct glazing in automotive glass replacement

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)	Very good
Application temperature	5 - 40°C (40 – 105°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)
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)	400% approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	11 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	5 N/mm ² approx.
Safe Drive-Away Time ² (cars) according to FMVSS 212 / 208 (CQP 511-1)	with double side airbag without airbag 6 hours 2 hour
Volume resistivity (CQP 079-2 / ASTM D 257-99)	1 x 10 ⁷ Ω cm approx.
Shelf life (storage below 25°C) (CQP 016-1)	12 months

¹⁾ CQP = Corporate Quality Procedures

²⁾ 23°C (73°F) / 50% relative humidity

Description

Sikaflex[®]-256 is a black-primerless 1-component direct glazing adhesive. It is easy to apply, with a paste-like consistency that cures on exposure to atmospheric moisture. Sikaflex[®]-256 provides a long tack-free time and ensures a safe application even under warm conditions.

Sikaflex[®]-256 offers quality combined with safety.

Sikaflex[®]-256 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the responsible care program.

Product Benefits

- Black-primerless pre-treatment
- Good application behaviour like bead stability / good non-sag properties
- Short cut-off string
- Cold application
- One-component formulation
- Automotive OEM quality

Areas of Application

Sikaflex[®]-256 is suitable for direct-glazing applications in the Automotive Glass Replacement business.

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.

Industry



Cure Mechanism

Sikaflex®-256 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds somewhat more slowly (see diagram 1).

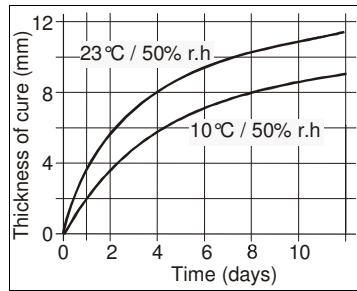


Diagram 1: Curing speed for Sikaflex®-256

Chemical Resistance

Sikaflex®-256 is resistant to fresh water, seawater, limewater, 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

Removal of old glass

Remove damaged glass in accordance with the vehicle manufacturer's instructions.

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 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 bonding surface)	Sika® Aktivator PRO

Metal with paint primer or with partial new painting (>= 25% of bonding surface)	Sika® Aktivator PRO+ Sika® Primer-206 G+P
Glass without ceramic or without large 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-treatment agents the lower limit is 5°C.

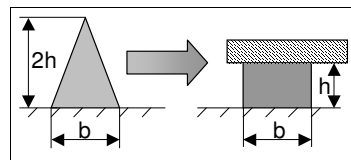


Figure 1: Compressing adhesive bead to final size

Removal

Uncured Sikaflex®-256 may be removed from tools 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 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	300 ml
Unipack	400 ml 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.

Important

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 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 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.



Sika South Africa (PTY) Ltd
9 Hocking Place
Westmead, 3608
South Africa

E-mail: headoffice@za.sika.com
Phone +27 31 792 6500
Telefax +27 31 700 1760
www.sika.co.za

