

## PRODUCT DATA SHEET

## Sikaflex®-256

Autoglass replacement adhesive

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

|                                                               |                                        |
|---------------------------------------------------------------|----------------------------------------|
| Chemical base                                                 | 1-component polyurethane               |
| Color (CQP001-1)                                              | Black                                  |
| Cure mechanism                                                | Moisture-curing                        |
| Density (uncured)                                             | 1.2 kg/l                               |
| Non-sag properties                                            | Good                                   |
| Application temperature                                       | product 5 – 40 °C<br>ambient 5 – 40 °C |
| Skin time (CQP019-1)                                          | 40 minutes <sup>A</sup>                |
| Open time (CQP526-1)                                          | 30 minutes <sup>A</sup>                |
| Curing speed (CQP049-1)                                       | See diagram 1                          |
| Shore A hardness (CQP023-1 / ISO 48-4)                        | 50                                     |
| Tensile strength (CQP036-1 / ISO 527)                         | 7 MPa                                  |
| Elongation at break (CQP036-1 / ISO 527)                      | 400 %                                  |
| Tear propagation resistance (CQP045-1 / ISO 34)               | 11 N/mm                                |
| Tensile lap-shear strength (CQP046-1 / ISO 4587)              | 5 MPa                                  |
| Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1) | with airbag 6 hours <sup>A/B</sup>     |
| Shelf life                                                    | 12 months <sup>C</sup>                 |

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r. h.<sup>B)</sup> details about MDA contact Sika<sup>C)</sup> storage below 25 °C

## DESCRIPTION

Sikaflex®-256 is a cold applied Automotive Glass Replacement adhesive which can be easily applied with manual application guns. Sikaflex®-256 has a long open time and thus it ensures a safe application even under warm conditions.

## PRODUCT BENEFITS

- Easy to extrude with manual application gun
- Good bead stability and non-sag properties
- Automotive OEM Quality

## AREAS OF APPLICATION

Sikaflex®-256 is suitable for experienced users only.

This product and related process information is designed for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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Sikaflex®-256

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012001212563001000

## CURE MECHANISM

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

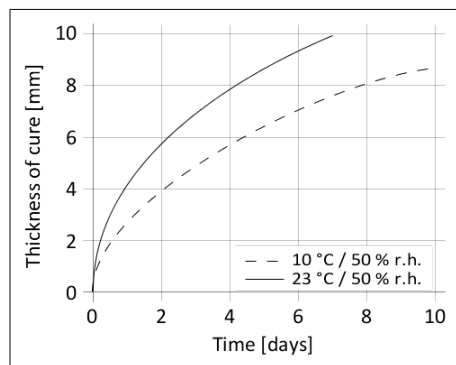


Diagram 1: Curing speed Sikaflex®-256

## CHEMICAL RESISTANCE

Sikaflex®-256 is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

## METHOD OF APPLICATION

### Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. The bond faces must be treated according to Sika's Black-Primerless or All Black installation process. Further information on the application and use of Pre-treatments, can be found in the corresponding Product Data Sheet. Glass without ceramic coatings need proper UV protection.

## Application

It is recommended to apply the adhesive with a piston-type application gun. Sikaflex®-256 can be applied with quality manual application guns.

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use.

To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

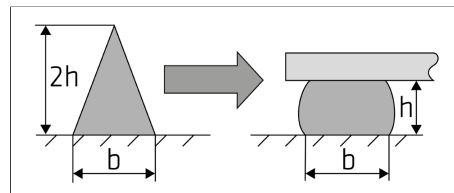


Figure 1: Compressing adhesive bead to final size

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never install a glass after the product has built a skin.

## Removal

Uncured Sikaflex®-256 can 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 have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin!

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry. Copies of the following publications are available on request:

- Safety Data Sheets
- Black-Primerless installation process chart
- All Black installation process chart

## PACKAGING INFORMATION

|           |        |
|-----------|--------|
| Cartridge | 300 ml |
| Unipack   | 400 ml |
|           | 600 ml |

## BASIS OF PRODUCT DATA

All technical data stated in this document 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 Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse 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.

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