

SAFETY DATA SHEET

Sikaflex®-250 PC



Version
1.0

Revision Date:
26.12.2025

SDS Number (Internal):
000000021205

Date of last issue: -
Date of first issue: 26.12.2025

1. PRODUCT AND COMPANY IDENTIFICATION

Product name : Sikaflex®-250 PC

Recommended use of the chemical and restrictions on use

Product use : Sealant/adhesive, Product is not intended for consumer use

Manufacturer or supplier's details

Company : Sika Korea Ltd.
724, Anseongmatchum-daero
Miyang-myeon
Anseong-si
Gyeonggi-do
Korea

Telephone : +82-31-8056-7777

Emergency telephone number : +82-31-8056-7777

E-mail address : ehs@kr.sika.com

Telefax : +82-31-8056-7788

2. HAZARDS IDENTIFICATION

GHS Classification

Flammable liquids : Category 4

Acute toxicity (Inhalation) : Category 1

Skin sensitisation : Category 1

Reproductive toxicity : Category 2

Specific target organ toxicity -
single exposure : Category 2

Specific target organ toxicity -
repeated exposure : Category 2

GHS label elements

Hazard pictograms :



Signal word : Danger

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Hazard statements : H227 Combustible liquid.
H317 May cause an allergic skin reaction.
H330 Fatal if inhaled.
H361 Suspected of damaging fertility or the unborn child.
H371 May cause damage to organs.
H373 May cause damage to organs through prolonged or repeated exposure.

Precautionary statements : **Prevention:**
P201 Obtain special instructions before use.
P202 Do not handle until all safety precautions have been read and understood.
P210 Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking.
P260 Do not breathe mist or vapours.
P264 Wash skin thoroughly after handling.
P270 Do not eat, drink or smoke when using this product.
P271 Use only outdoors or in a well-ventilated area.
P272 Contaminated work clothing should not be allowed out of the workplace.
P280 Wear protective gloves/ protective clothing/ eye protection/ face protection.
P284 Wear respiratory protection.

Response:

P302 + P352 IF ON SKIN: Wash with plenty of water.
P304 + P340 + P310 IF INHALED: Remove person to fresh air and keep comfortable for breathing. Immediately call a POISON CENTER/ doctor.
P308 + P311 IF exposed or concerned: Call a POISON CENTER/ doctor.
P308 + P313 IF exposed or concerned: Get medical advice/ attention.
P333 + P313 If skin irritation or rash occurs: Get medical advice/ attention.
P362 + P364 Take off contaminated clothing and wash it before reuse.
P370 + P378 In case of fire: Use dry sand, dry chemical or alcohol-resistant foam to extinguish.

Storage:

P403 + P233 Store in a well-ventilated place. Keep container tightly closed.
P405 Store locked up.

Disposal:

P501 Dispose of contents/ container according to waste-related laws

Other hazards which do not result in classification

No data available

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3. COMPOSITION/INFORMATION ON INGREDIENTS

Substance / Mixture : Mixture

Components

Chemical name	Common Name	CAS-No.	Concentration (% w/w)
1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich	1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich	68515-49-1	>= 20 - < 25
aliphatic prepolymer (t-polyether based)	aliphatic prepolymer (t-polyether based)	138626-39-8	>= 5 - < 10
aliphatic prepolymer (d-polyether based)	aliphatic prepolymer (d-polyether based)	39323-37-0	>= 1 - < 5
xylene	xylene	1330-20-7	>= 1 - < 5
Urea,N,N"-(methylenedi-4,1-phenylene)bis[N'-butyl-	Urea,N,N"-(methylenedi-4,1-phenylene)bis[N'-butyl-	77703-56-1	>= 1 - < 2.5
Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane	Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane	192526-20-8	0 - < 1
ethylbenzene	ethylbenzene	100-41-4	>= 0.1 - < 1
4,4'-methylenediphenyl diisocyanate	4,4'-methylenediphenyl diisocyanate	101-68-8	>= 0.1 - < 1
3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate	3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate	4098-71-9	>= 0.025 - < 0.25

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4. FIRST AID MEASURES

- General advice : Move out of dangerous area.
Consult a physician.
Show this safety data sheet to the doctor in attendance.
- In case of eye contact : Remove contact lenses.
Keep eye wide open while rinsing.
If eye irritation persists, consult a specialist.
- In case of skin contact : Take off contaminated clothing and shoes immediately.
Wash off with soap and plenty of water.
If symptoms persist, call a physician.
- If inhaled : Move to fresh air.
Consult a physician after significant exposure.
- If swallowed : Clean mouth with water and drink afterwards plenty of water.
Do not give milk or alcoholic beverages.
Never give anything by mouth to an unconscious person.
Obtain medical attention.
- Most important symptoms and effects, both acute and delayed : sensitising effects
Allergic reactions
See Section 11 for more detailed information on health effects and symptoms.
May cause an allergic skin reaction.
Fatal if inhaled.
Suspected of damaging fertility or the unborn child.
May cause damage to organs.
May cause damage to organs through prolonged or repeated exposure.
- Notes to physician : Treat symptomatically.
-

5. FIREFIGHTING MEASURES

Suitable and unsuitable extinguishing media

- Suitable extinguishing media : Carbon dioxide (CO₂)
- Unsuitable extinguishing media : Water
- Hazardous combustion products : No hazardous combustion products are known
- Specific extinguishing methods : Standard procedure for chemical fires.
- Special protective equipment for firefighters : In the event of fire, wear self-contained breathing apparatus.
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6. ACCIDENTAL RELEASE MEASURES

- Personal precautions, protective equipment and emergency procedures : Use personal protective equipment.
Deny access to unprotected persons.
- Environmental precautions : Do not flush into surface water or sanitary sewer system.
- Methods and materials for containment and cleaning up : Soak up with inert absorbent material (e.g. sand, silica gel, acid binder, universal binder, sawdust).
Keep in suitable, closed containers for disposal.

7. HANDLING AND STORAGE

- Advice on protection against fire and explosion : Normal measures for preventive fire protection.
- Advice on safe handling : Avoid exceeding the given occupational exposure limits (see section 8).
Do not get in eyes, on skin, or on clothing.
For personal protection see section 8.
Persons with a history of skin sensitisation problems or asthma, allergies, chronic or recurrent respiratory disease should not be employed in any process in which this mixture is being used.
Smoking, eating and drinking should be prohibited in the application area.
Follow standard hygiene measures when handling chemical products
- Conditions for safe storage : Store in original container.
Keep in a well-ventilated place.
Observe label precautions.
Store in accordance with local regulations.

8. EXPOSURE CONTROLS/PERSONAL PROTECTION

Components with workplace control parameters

Components	CAS-No.	Value type (Form of exposure)	Control parameters / Permissible concentration	Basis
xylene	1330-20-7	TWA	100 ppm	KR OEL
		STEL	150 ppm	KR OEL
ethylbenzene	100-41-4	TWA	20 ppm	ACGIH
		TWA	100 ppm	KR OEL
Further information: Limited evidence of carcinogenicity in humans or animals, which is not sufficiently convincing to place the substance in Category 1				

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		STEL	125 ppm	KR OEL
		TWA	20 ppm	ACGIH
4,4'-methylenediphenyl diisocyanate	101-68-8	TWA	0.005 ppm	KR OEL
	Further information: Limited evidence of carcinogenicity in humans or animals, which is not sufficiently convincing to place the substance in Category 1			
		TWA	0.005 ppm	KR PEL
		TWA	0.005 ppm	ACGIH
3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate	4098-71-9	TWA	0.005 ppm	KR OEL
	Further information: Substances designated by 'Skin' may be absorbed into the bloodstream through the skin, mucous membrane and eye and contribute to the overall effect. (Skin notation does not apply to the skin irritant)			

Other ingredients, which are listed in section 3 but not listed in this section, do not have established occupational exposure limit values.

Biological occupational exposure limits

Components	CAS-No.	Control parameters	Biological specimen	Sampling time	Permissible concentration	Basis
xylene	1330-20-7	Methylhippuric acids	Urine	End of shift (As soon as possible after exposure ceases)	1.5 g/g creatinine	ACGIH BEI
ethylbenzene	100-41-4	Sum of mandelic acid and phenyl glyoxylic acid	Urine	End of shift (As soon as possible after exposure ceases)	0.15 mg/g creatinine	ACGIH BEI

Personal protective equipment. Among the following personal protective equipment, the PPEs which require safety certification need to be certified by KOSHA.

- Respiratory protection : Use respiratory protection unless adequate local exhaust ventilation is provided or exposure assessment demonstrates that exposures are within recommended exposure guidelines. The filter class for the respirator must be suitable for the maximum expected contaminant concentration (gas/vapour/aerosol/particulates) that may arise when handling the product. If this concentration is exceeded, self-contained breathing apparatus must be used.
- Eye protection : Safety eyewear complying with an approved standard should be used when a risk assessment indicates this is necessary.
- Hand protection : Chemical-resistant, impervious gloves complying with an approved standard should be worn at all times when handling chemical products if a risk assessment indicates this is nec-

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essary.

Skin and body protection : Choose body protection in relation to its type, to the concentration and amount of dangerous substances, and to the specific work-place.

Hygiene measures : Handle in accordance with good industrial hygiene and safety practice.
When using do not eat or drink.
When using do not smoke.
Wash hands before breaks and at the end of workday.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance : paste

Colour : black

Odour : odourless

Odour Threshold : No data available

pH : Not applicable substance/mixture is non-soluble (in water)

Melting point/ range / Freezing point : No data available

Boiling point/boiling range : No data available

Flash point : ca. 65 °C (149 °F)
(Method: closed cup)

Evaporation rate : No data available

Flammability (solid, gas) : No data available

Upper/lower flammability or explosive limits

Upper explosion limit / Upper flammability limit : No data available

Lower explosion limit / Lower flammability limit : Lower flammability limit
1 %(V)

Vapour pressure : ca. 8 hPa (20 °C (68 °F))

Solubility(ies)

Water solubility : insoluble

Solubility in other solvents : No data available

Density : ca. 1.14 g/cm³ (20 °C)

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Partition coefficient: n-octanol/water	:	No data available
Auto-ignition temperature	:	No data available
Decomposition temperature	:	No data available
Viscosity	:	
Viscosity, dynamic	:	No data available
Viscosity, kinematic	:	> 20.5 mm ² /s (40 °C (104 °F))
Explosive properties	:	No data available
Oxidizing properties	:	No data available

10. STABILITY AND REACTIVITY

Chemical stability and possibility of hazardous reactions	:	Reactivity: No dangerous reaction known under conditions of normal use. Chemical stability: The product is chemically stable. Possibility of hazardous reactions: No hazards to be specially mentioned.
Conditions to avoid	:	No data available
Incompatible materials	:	No data available
Hazardous decomposition products	:	No hazardous decomposition products are known.

11. TOXICOLOGICAL INFORMATION

Information on likely routes of exposure	:	No data available
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Health hazard information

Acute toxicity

Fatal if inhaled.

Components:

xylene:

Acute oral toxicity	:	LD50 Oral (Rat): 3,523 mg/kg
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Urea,N,N''-(methylenedi-4,1-phenylene)bis[N'-butyl-:

Acute oral toxicity	:	LD50 Oral (Rat): > 2,000 mg/kg Method: OECD Test Guideline 401
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Acute dermal toxicity	:	LD50 Dermal (Rabbit): > 2,000 mg/kg
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Method: OECD Test Guideline 402

ethylbenzene:

Acute oral toxicity : LD50 Oral (Rat): 3,500 mg/kg

Acute dermal toxicity : LD50 Dermal (Rabbit): 5,510 mg/kg

4,4'-methylenediphenyl diisocyanate:

Acute oral toxicity : LD50 Oral (Rat): > 5,000 mg/kg
Method: OECD Test Guideline 401

Acute inhalation toxicity : LC50: 1.5 mg/l
Exposure time: 4 h
Test atmosphere: dust/mist
Method: Expert judgement

3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate:

Acute oral toxicity : LD50 Oral (Rat): 4,814 mg/kg

Acute inhalation toxicity : LC50 (Rat): 0.031 mg/l
Exposure time: 4 h
Test atmosphere: dust/mist

Acute dermal toxicity : LD50 Dermal (Rat): > 7,000 mg/kg

Skin corrosion/irritation

No data available

Serious eye damage/eye irritation

No data available

Respiratory or skin sensitisation

Respiratory sensitisation

No data available

Skin sensitisation

May cause an allergic skin reaction.

Carcinogenicity

No data available

Components:

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

No data available

aliphatic prepolymer (t-polyether based):

No data available

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aliphatic prepolymer (d-polyether based):

No data available

xylene:

No data available

Urea,N,N"-(methylenedi-4,1-phenylene)bis[N'-butyl-:

No data available

Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane:

No data available

ethylbenzene:

Suspected of causing cancer.

4,4'-methylenediphenyl diisocyanate:

Suspected of causing cancer.

3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate:

No data available

Germ cell mutagenicity

No data available

Components:

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

No data available

aliphatic prepolymer (t-polyether based):

No data available

aliphatic prepolymer (d-polyether based):

No data available

xylene:

No data available

Urea,N,N"-(methylenedi-4,1-phenylene)bis[N'-butyl-:

No data available

Genotoxicity in vivo

: Species: Bacteria
Method: OECD Test Guideline 471

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Result: negative

Method: TA98

Method: TA100

Method: TA1535

Method: TA1537

Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane:

No data available

ethylbenzene:

No data available

4,4'-methylenediphenyl diisocyanate:

No data available

Genotoxicity in vivo

: Species: Bacteria
Method: OECD Test Guideline 471
Result: negative

Method: TA98

Method: TA100

Method: TA1535

Method: TA1537

3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate:

No data available

Reproductive toxicity

Suspected of damaging fertility or the unborn child.

Components:

1,2-Benzenedicarboxylic acid, di-C9-11-branched alkyl esters, C10-rich:

Suspected of damaging fertility or the unborn child.

aliphatic prepolymer (t-polyether based):

No data available

aliphatic prepolymer (d-polyether based):

No data available

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xylene:

No data available

Urea,N,N''-(methylenedi-4,1-phenylene)bis[N'-butyl-:

No data available

Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane:

No data available

ethylbenzene:

No data available

4,4'-methylenediphenyl diisocyanate:

No data available

3-isocyanatomethyl-3,5,5-trimethylcyclohexyl isocyanate:

No data available

STOT - single exposure

May cause damage to organs.

STOT - repeated exposure

May cause damage to organs through prolonged or repeated exposure.

Repeated dose toxicity

No data available

Aspiration toxicity

No data available

Experience with human exposure

No data available

Toxicology, Metabolism, Distribution

No data available

Neurological effects

No data available

Further information

No data available

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12. ECOLOGICAL INFORMATION

Ecotoxicity

Components:

aliphatic prepolymer (t-polyether based):

Toxicity to algae/aquatic plants : EC50 (algae): 100 mg/l
Exposure time: 72 h

NOEC (algae): 100 mg/l
Exposure time: 72 h

aliphatic prepolymer (d-polyether based):

Toxicity to daphnia and other aquatic invertebrates : EC50 (Daphnia (water flea)): > 100 mg/l

NOEC (Daphnia (water flea)): > 100 mg/l

Toxicity to algae/aquatic plants : EC50 (algae): > 100 mg/l
Exposure time: 72 h

xylene:

Toxicity to fish (Chronic toxicity) : NOEC (Oncorhynchus mykiss (rainbow trout)): > 1.3 mg/l
Exposure time: 56 d

Toxicity to daphnia and other aquatic invertebrates (Chronic toxicity) : NOEC (Daphnia (water flea)): 1.17 mg/l
Exposure time: 7 d

Urea,N,N''-(methylenedi-4,1-phenylene)bis[N'-butyl-:

Toxicity to fish : LC50 (Brachydanio rerio (zebrafish)): > 250 mg/l
Exposure time: 96 h

Toxicity to daphnia and other aquatic invertebrates : EC50 (Daphnia magna (Water flea)): > 100 mg/l
Exposure time: 48 h

Toxicity to algae/aquatic plants : EC50 (Raphidocelis subcapitata (freshwater green alga)): > 100 mg/l
Exposure time: 72 h

Reaction product of Hexamethylene diisocyanate, oligomers with Mercaptopropyltrimethoxysilane:

Toxicity to fish : LC50 (Brachydanio rerio (zebrafish)): > 100 mg/l
Exposure time: 96 h
Method: OECD Test Guideline 203

Toxicity to daphnia and other aquatic invertebrates : EC50 (Daphnia magna (Water flea)): > 100 mg/l
Exposure time: 48 h
Method: OECD Test Guideline 202

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Toxicity to algae/aquatic plants : EC50 (Pseudokirchneriella subcapitata (algae)): > 100 mg/l
Exposure time: 72 h
Method: OECD Test Guideline 201

Persistence and degradability

No data available

Bioaccumulative potential

No data available

Mobility in soil

No data available

Other adverse effects

Product:

Additional ecological information : There is no data available for this product.

13. DISPOSAL CONSIDERATIONS

Disposal methods

Waste from residues : Send to a licensed waste management company.

Do not contaminate ponds, waterways or ditches with chemical or used container.

Contaminated packaging : Empty remaining contents.
Dispose of as unused product.

Do not re-use empty containers.
Do not burn, or use a cutting torch on, the empty drum.

Disposal precautions

Dispose of contents and container according to wastes control act.

14. TRANSPORT INFORMATION

International Regulations

UNRTDG

Not regulated as a dangerous good
UN number : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
Environmentally hazardous : no

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IATA-DGR

Not regulated as a dangerous good
UN/ID No. : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
Packing instruction (cargo aircraft) : Not applicable
Packing instruction (passenger aircraft) : Not applicable

IMDG-Code

Not regulated as a dangerous good
UN number : Not applicable
Proper shipping name : Not applicable
Class : Not applicable
Subsidiary risk : Not applicable
Packing group : Not applicable
Labels : Not applicable
EmS Code : Not applicable
Marine pollutant : no

Transport in bulk according to Annex II of MARPOL 73/78 and the IBC Code

Not applicable for product as supplied.

National Regulations

Refer to section 15 for specific national regulation.

Special precautions for user

Not applicable

15. REGULATORY INFORMATION

National regulatory information

Regulation under the Occupational Safety and Health Act

Harmful Substances Prohibited from Manufacturing

Not applicable

Harmful Substances Required Permission for Manufacture

Not applicable

Harmful Agents to be kept below Occupational Exposure Limits

Chemical name	CAS-No.
Carbon black	1333-86-4
Xylene (all isomers)	1330-20-7
Ethyl benzene	100-41-4
Methylene bisphenyl isocyanate	101-68-8
Isophorone diisocyanate	4098-71-9

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Harmful Agents Required to be kept below Permission Levels

Chemical name	CAS-No.
Methylene bis(phenyl isocyanate)	101-68-8

Hazardous substances requiring management

Not applicable

Special Management Materials

Not applicable

Controlled Substances Subject to Environment Monitoring

Chemical name	CAS-No.	Threshold limits (%)
Xylene	1330-20-7	>= 1 %

Controlled Substances Subject to Health Examination

Chemical name	CAS-No.	Threshold limits (%)
Xylene	1330-20-7	>= 1 %

Hazardous Substances Subject to Process Safety Management (PSM) Reporting Obligation

Not applicable

K-OSHA Hazardous Substances (Occupational Safety and Health Regulations, Table 1)

Category
Flammable liquid
Acute toxic substances (inhalation)

K-OSHA Hazardous Substances (Occupational Safety and Health Regulations, Table 9)

Category	Manufacturing or handling quantity
Flammable liquid	1000 litre
Acute toxic substances (inhalation)	5 kilogram

Regulation under the Chemicals Control Act

Toxic Chemicals

Not applicable

Restricted Chemicals

Not applicable

Prohibited Chemicals

Not applicable

Toxic Release Inventory

Chemical name	CAS-No.	Group	Threshold limits (%)
Xylene (o-,m-,p- isomer mixture)	1330-20-7	Group II	>= 1 %
Ethylbenzene	100-41-4	Group II	>= 0.1 %

Accident Precaution Chemicals

Not applicable

Dangerous Substances Safety Management Act

Classification : Group 4, Flammable liquids, Type 2 petroleums, Water insolu-

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ble liquid

Hazard rank : Hazardous rank III

Designated Quantity : 1000 litre

Safety Warning : Keep away from fire

International Chemical Weapons Convention (CWC) Schedules of Toxic Chemicals and Precursors : Not applicable

라. Wastes Control Act

Industrial general wastes
Follow article 13 of the act to dispose the product waste

Korea. Enforcement Rule of Clean Air Conservation Act, Schedule 2, Specific Air Pollutants

Chemical name
Ethylbenzene
Polyaromatic hydrocarbons

마. Other requirements in domestic and other countries

The components of this product are reported in the following inventories:

ENCS : Not in compliance with the inventory

ISHL : Not in compliance with the inventory

KECI : Not in compliance with the inventory

16. OTHER INFORMATION

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Revision number and date

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Date format : yyyy/mm/dd

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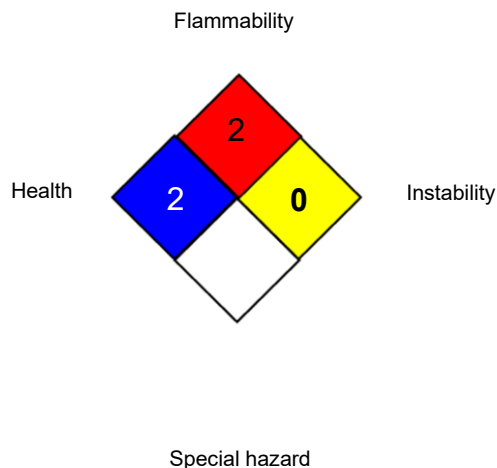
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NFPA:



Full text of other abbreviations

ACGIH	:	USA. ACGIH Threshold Limit Values (TLV)
ACGIH BEI	:	ACGIH - Biological Exposure Indices (BEI)
KR OEL	:	Harmful Agents to be kept below Occupational Exposure Limits
KR PEL	:	Harmful Agents Required to be kept below Permission Levels
ACGIH / TWA	:	8-hour, time-weighted average
KR OEL / TWA	:	Time Weighted Average
KR OEL / STEL	:	Short Term Exposure Limit
KR PEL / TWA	:	TWA
ADR	:	European Agreement concerning the International Carriage of Dangerous Goods by Road
CAS	:	Chemical Abstracts Service
DNEL	:	Derived no-effect level
EC50	:	Half maximal effective concentration
GHS	:	Globally Harmonized System
IATA	:	International Air Transport Association
IMDG	:	International Maritime Code for Dangerous Goods
LD50	:	Median lethal dose (the amount of a material, given all at once, which causes the death of 50% (one half) of a group of test animals)
LC50	:	Median lethal concentration (concentrations of the chemical in air that kills 50% of the test animals during the observation period)
MARPOL	:	International Convention for the Prevention of Pollution from Ships, 1973 as modified by the Protocol of 1978
OEL	:	Occupational Exposure Limit
PBT	:	Persistent, bioaccumulative and toxic
PNEC	:	Predicted no effect concentration
REACH	:	Regulation (EC) No 1907/2006 of the European Parliament and of the Council of 18 December 2006 concerning the Reg-

SAFETY DATA SHEET

Sikaflex®-250 PC



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SVHC :
vPvB :

istration, Evaluation, Authorisation and Restriction of Chemicals (REACH), establishing a European Chemicals Agency
: Substances of Very High Concern
: Very persistent and very bioaccumulative

The information contained in this Safety Data Sheet corresponds to our level of knowledge at the time of publication. All warranties are excluded. Our most current General Sales Conditions shall apply. Please consult the product data sheet prior to any use and processing.

KR / EN