BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-250 PC

Warm applied adhesive with exceptional application properties

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.1 kg/l
Non-sag properties		Very good
Application temperature	product ambient	85 °C 5 - 40 °C
Skin time (CQP019-1)		10 minutes [A]
Open time (CQP526-1)		6 minutes [A]
Curing speed (CQP049-1)		(see diagram)
Shrinkage (CQP014-1)		2 %
Shore A hardness (CQP023-1 / ISO 48-4)		55
Tensile strength (CQP036-1 / ISO 527)		7 MPa
Elongation at break (CQP036-1 / ISO 527)		450 %
Tear propagation resistance (CQP045-1 / ISO 34)		15 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4 MPa
Service temperature (CQP509-1 / CQP513-1)		-40 – 90 °C
Shelf life	drum / pail	6 months [B]

CQP = Corporate Quality Procedure

A) 23 °C / 50 % r. h.

B) storage below 25 °C

DESCRIPTION

Sikaflex®-250 PC is an elastic 1 component polyurethane adhesive that cures on exposure to atmospheric humidity. Sikaflex®-250 PC is applied at a temperature of 85 °C and develops extraordinary application properties and high initial strength. As such it is eminently well suited for medium to large production runs.

PRODUCT BENEFITS

- Excellent application properties
- Suitable for automated application
- High initial strength
- Very short cut-off string

AREAS OF APPLICATION

Sikaflex®-250 PC fits bonding applications in automated processes best. It can also be used for standard non automated lines.
Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-250 PC on materials prone to stress cracking.
Sikaflex®-250 PC is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

Sikaflex®-250 PC 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).

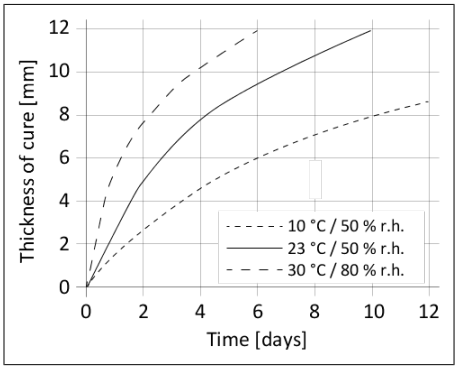

Diagram 1: Curing speed Sikaflex®-250 PC

CHEMICAL RESISTANCE

Sikaflex®-250 PC 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.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-250 PC can be processed at climate conditions between 5 °C and 40 °C, but changes in reactivity and application properties have to be considered. The optimum climate and substrate temperature is between 15 °C and 25 °C.

Sikaflex®-250 PC need to be heated up to 85 °C prior the application. Application equipment must be hence capable to heat up the required amount of adhesive to the required temperature.

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: Recommended bead configuration

Sikaflex®-250 PC can be processed with hand, pneumatic or electric driven piston guns as well as pump equipment. The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Removal

Uncured Sikaflex®-250 PC 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
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Pail	23 l
Drum	195 l

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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