

Sikaflex®-268

Adhesive and sealant with excellent weathering and cleaning agent resistance

Typical Product Data

Chemical base	Polyurethane
Colour (CQP ¹ 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.3 kg/l
Non-sag properties (CQP 061-1)	Very good
Application temperature	5 - 40 °C
Skin time ² (CQP 019-1)	60 min
Open time ² (CQP 526-1)	40 min
Curing speed (CQP 049-1)	(see diagram)
Shrinkage (CQP 014-1)	1 %
Shore A hardness (CQP 023-1 / ISO 868)	55
Tensile strength (CQP 036-1 / ISO 37)	6 MPa
Elongation at break (CQP 036-1 / ISO 37)	500 %
Tear propagation resistance (CQP 045-1 / ISO 34)	13 N/mm
Tensile-shear strength (CQP 046-1 / ISO 4587)	4.5 MPa
G-Modulus (CQP 081-1)	at 0.1 - 10 % shear strain 1.3 MPa
Service temperature (CQP 513-1)	-50 - 90 °C
Shelf life (storage below 25 °C) (CQP 016-1)	unipack 9 months pail / drum 6 months

¹⁾ CQP = Corporate Quality Procedures²⁾ 23 °C / 50 % r.h.**Description**

Sikaflex®-268 is a high-performance elastic gap-filling 1-C polyurethane adhesive/sealant especially designed for the rail vehicle market. It cures on exposure to atmospheric moisture to form a durable elastomer.

Sikaflex®-268 has an outstanding weathering resistance and unique resistivity against a wide variety of cleaning agents.

Product Benefits

- Resistant against a wide variety of rail cleaning agents
- Excellent weathering stability
- Very good processing and tooling characteristics
- Tested according to E DIN 6701-3: 2010-8
- Solvent and PVC free

Areas of Application

Sikaflex®-268 is designed for large component assembly and direct glazing applications in the rail industry and for the repair market. It exhibits excellent tooling and application properties. With its superior resistance against in rail commonly used cleaning agents combined with its outstanding weathering resistance it can be used for exterior joints.

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®-268 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).

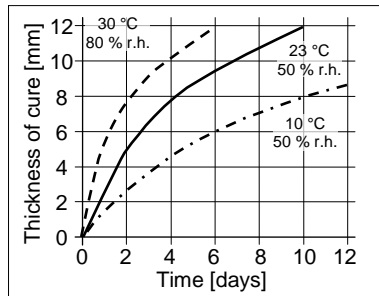


Diagram 1: Curing speed Sikaflex®-268

Chemical Resistance

Sikaflex®-268 is resistant to fresh water, aqueous cleaning agents (neutral, acid or alkaline types, chlorine free in normal concentrations); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids and caustic solutions and solvents.

It is resistant to a wide variety of rail cleaning agents if used according to the manufacturer's guidelines. Specifically dilution, exposure time, temperatures and a thorough rinsing process with fresh water at the end of the cleaning process need to be respected in any case. If these factors are not considered accordingly the product could be negatively influenced.

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. Additional surface treatment depends on the specific nature of the substrates and manufacturing process. Therefore all recommendations must be determined by preliminary tests.

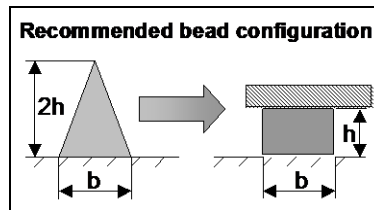
Advice on specific applications is available from the Technical Department of Sika Industry.

Application

For satisfactory results the adhesive must be applied with adequate equipment such as pump, dosing units or piston operated application guns.

Sikaflex®-268 can be processed between 5 °C and 40 °C but changes in reactivity as well as application properties need to be considered. The optimum process temperature (substrates, climate and product) is between 15 °C and 25 °C.

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



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

Removal

Uncured Sikaflex®-268 may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleanser and water. Do not use solvents on skin!

Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet.

Copies of the following publications are available on request:

- Safety Data Sheets
- General Guidelines - Bonding and Sealing with Sikaflex® and SikaTack®

Packaging Information

Unipack	600 ml
Pail	23 L
Drum	195 L

Bases of Product Data

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 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 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.

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