

Sikaflex®-255 Extra

Windscreens Adhesive

Technical Data

Chemical base	1-C polyurethane
Colour (CQP ¹) 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.1 kg/l approx.
Non-sag properties	Good
Application temperature	5 – 40 °C (40°F-105°F)
Skin time ²⁾ (CQP 019-1)	40 min approx.
Open time ²⁾ (CQP 526-1)	30 min approx.
Curing speed (CQP 049-1)	(see diagram 1)
Volume Shrinkage (CQP 014-1)	5 % approx.
Shore A hardness (CQP 023-1 / ISO 868)	55 approx.
Tensile strength (CQP 036-1 / ISO 37)	5.5 N/mm ² approx.
Elongation at break (CQP 036-1 / ISO 37)	600 % approx.
Tear propagation resistance (CQP 045-1 / ISO 34)	10 N/mm approx.
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	3.5 N/mm ² approx.
Safe Drive-Away Time ²⁾ (cars) according to FMVSS 212 / 208	with double side airbags without airbags
	6 hours 2 hours
Volume resistivity (CQP 079-2 / ASTM D 257-99)	10 ⁷ Ω cm approx.
Shelf life (storage below 25°C) (CQP 016-1)	9 months

¹⁾ Corporate Quality Procedure

²⁾ 23°C (73°F) / 50% r.h.

Product Description

Sikaflex®-255 Extra is a cold applied wind shield adhesive with a safe drive away time of 6 hours. It is easy to gun with manual guns and exhibits excellent properties such as suitability for black primerless application; it offers quality combined with safety. Sikaflex®-255 Extra is designed for glass replacement of direct glazed vehicles.

Product Benefits

- Black primerless Adhesion
- Easy to gun
- Easy and clean application
- Good non-sag properties
- Short cut-off string
- Tested according FMVSS 212/208 (with double-side airbags ,no seatbelts)

Areas of Application

Sikaflex®-255 Extra has been specifically designed for the Automotive Glass Replacement business. It is ideal for mobile and in-house installations in areas with warm and humid climatic conditions. This product is to be used by professional experienced fitters only. If this product is used for other applications than Automotive Glass Replacement, trials must be carried out prior to use.



Cure Mechanism

Sikaflex®-255 Extra cures by reaction with atmospheric moisture. At low temperatures the absolute water content of the air is lower and the curing reaction proceeds more slowly (see diagram 1).

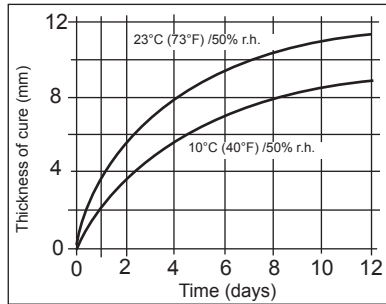


Diagram 1: Curing speed for Sikaflex®-255 Extra

Chemical Resistance

Sikaflex®-255 Extra is resistant to water and aqueous cleaning agents (including windshield cleaners containing alcohol); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to paint thinners.

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 dust, oil and grease. The bond faces must be treated with a cleaning and activating agent or primed with the appropriate primer. Glass surfaces must be pre-treated with Sika®Aktivator PRO or Sika®Aktivator-100 to limit adhesion failures due to the wide variety of Aftermarket glasses. Adhesion loss could result in displacement of glass in the event of a crash.

Detailed information on the application and use of activating agents, etc. can be found in the corresponding Product Data Sheet. Advice on specific applications is available from the Technical Service Department of Sika Industry.

Application

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations and screw onto the cartridge or the unipack adapter.

It is recommended to apply the adhesive with a piston-type application gun. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive be applied in the form of a triangular bead (see fig.1 below). With Sika®Aktivator PRO the substrate temperature must be between -10 °C and 40 °C, for other pre-treatments the lower limit is 5 °C.

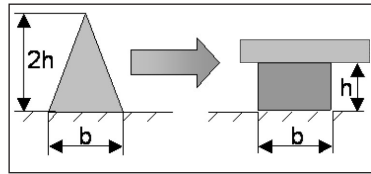


Figure 1: Compressing adhesive bead to final size

Removal

Uncured Sikaflex®-255 Extra 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 cleaner and water. Do not use solvents!

Further Information

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Technician's Handbook

Packaging Information

Cartridge	310ml x 20pc / box
Unipack	400ml x 20pc / box 600ml x 20pc / box

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.

Health and Safety Information

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 Notes

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.