

Sikaflex®-255 FC

Black Primer-less Direct-Glazing Adhesive

Technical Data

Chemical Base	One-component polyurethane
Colour (CQP ¹ 001-1)	Black
Cure Mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.2 kg/L approx.
Non-Sag Properties	Very good
Application Temperature	10°C to 35°C
Skin Time ² (CQP 019-1)	40 min.
Open Time ² (CQP 526-1)	20 min.
Curing Speed (CQP 049-1)	See Diagram 1
Shrinkage (CQP 014-1)	3% approx.
Shore A Hardness (CQP 023-1/ISO 868)	60 approx.
Tensile Strength (CQP 036-1/ISO 37)	6 N/mm ² approx.
Elongation at Break (CQP 036-1/ISO 37)	450% approx.
Tear Propagation Resistance (CQP 045-1/ISO 34)	12 N/mm approx.
Tensile Lap-Shear Strength (CQP 046-1/ISO 4587)	4 N/mm ² approx.
Volume Resistivity (CQP 079-2/ASTM D 257-99)	10 ⁷ Ω cm approx.
Service Temperature (CQP 513-1)	-40°C to 90°C
Shelf Life (Stored below 25°C) (CQP 016-1)	9 months
¹ CQP = Corporate Quality Procedures	² 23°C and 50% Relative Humidity

Description

Sikaflex®-255 FC is a one-component, elastic, high-performance direct-glazing adhesive with gap-filling capabilities that cures on exposure to atmospheric humidity to form a durable elastomer. Sikaflex®-255 FC is manufactured in accordance with the ISO 9001/14001 quality assurance system.

Product Benefits

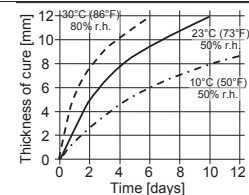
- Fast-curing;
- One-component adhesive;
- Excellent processing properties;
- Wide adhesion rate on most relevant substrates.

Areas of Application

Sikaflex®-255 FC is designed for direct-glazing applications with mineral glass-based windows in the Transportation OEM and repair markets. This product is suitable for professional users only. Tests with actual substrates under current conditions must be performed to ensure adhesion and material compatibility.

Cure Mechanism

Sikaflex®-255 FC cures by reaction to atmospheric moisture. At lower temperatures, the water content of the air is generally lower and the curing reaction slowed.



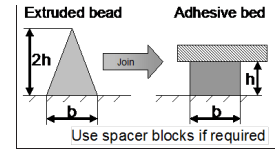
Curing speed of Sikaflex®-255 FC



Chemical Resistance Sikaflex®-255 FC is **resistant** to fresh water, seawater and proprietary aqueous cleaning solutions; **temporarily resistant** to fuels, mineral oils, and vegetable and animal fats; **not resistant** to organic acids, concentrated mineral acids and caustic solutions or solvents. The above information is offered for general guidance only. Advice on specific applications will be given upon request.

Surface Preparation Surfaces must be clean, dry and free from grease, oil and dust. Refer to the Sika Pre-Treatment Chart for additional information. Advice on specific applications is available from the Technical Services Department of Sika Industry.

Application The optimum temperature for substrate and adhesive is between 15°C and 25°C. To ensure uniform thickness of adhesive when compressed, we recommend applying the adhesive in the form of a triangular bead.



Tooling and Finishing Tooling and finishing must be carried out within the tack-free time of the sealant. We recommend the use of Sika® Tooling Agent N. Other finishing agents or lubricants must be tested for suitability and compatibility.

Removal Uncured Sikaflex®-255 FC 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® Hand Cleaner or suitable industrial hand cleaner and water. Do not use solvents!

Further Information Copy of the following publications is available upon request:

- Material Safety Data Sheet;
- Sika Pre-Treatment Chart for One-Component Polyurethanes.

Packaging 300 mL cartridges

Value Bases All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.

Health and Safety Information For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. All Product Data Sheets and Material Safety Data Sheets are available on our website at: www.sika.ca.

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, within their shelf life. 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 recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under www.sika.ca.

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