



**PRODUCT DATA SHEET**

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# Sikaflex®-268 PowerCure

## ACCELERATED ADHESIVE/SEALANT WITH EXCELLENT WEATHERING AND CLEANING AGENT RESISTANCE

Technical Data		
Chemical Base		Polyurethane
Colour (CQP <sup>1</sup> 001-1)		Black
Cure Mechanism		Moisture-curing <sup>2</sup>
Density (uncured) (CQP 006-4)		1.3 kg/L.
Non-Sag Properties (CQP 061-1)		Very Good
Application Temperature		10 °C to 35 °C
Open Time <sup>3</sup> (CQP 526-1)		30 minutes
Early Tensile Lap-shear Strength (CQP046-1 / ISO 4587)		See Table 1
Curing Speed (CQP 049-1)		See Diagram 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 Lap-Shear Strength (CQP 046-1/ISO4587)		4.5 MPa
Service Temperature (CQP 513-1)		-50 °C to 90 °C
Shelf Life (CQP 016-1) (Stored below 25 °C)		9 months
<sup>1</sup> CQP = Corporate Quality Procedure; <sup>2</sup> Provided by PowerCure <sup>3</sup> 23 °C and 50% Relative Humidity.		

**Description** Sikaflex®-268 PowerCure is an accelerated 1-component polyurethane adhesive and sealant especially designed for the rail vehicle market. The product is applied using the PowerCure Dispenser and cures largely independent from atmospheric conditions. Sikaflex®-268 PowerCure has an outstanding weathering resistance and unique resistivity against a wide range of cleaning agents used in the rail industry.

- Product Benefits**
- Accelerated curing speed
  - Resistant against a wide range of rail cleaning agents
  - Suitable for bonding and sealing
  - Excellent weathering stability
  - Very good processing and tooling characteristics
  - Solvent and PVC free

**Aeras of Application** Sikaflex®-268 PowerCure is designed for assembly and direct glazing applications in the rail industry as well as for other transportation vehicles. It exhibits good tooling and excellent application properties. With its superior resistance against a wide range of cleaning agents and the outstanding weathering resistance it can be used for exterior joints. It has to be considered that the tooling time is limited to 15 - 20 minutes (23 °C / 50 % r.h.). 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 PowerCure cures by reaction with the accelerator paste. For approx. strength build up values see table below.

**Table 1:**  
Tensile lap-shear strength at 3 °C / 50 % r.h.

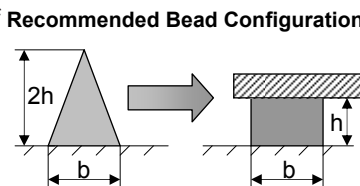
Time [h]	Lap shear Strength [MPa]
2	0.2
3	1
4	2
6	3.5

**Chemical Resistance** Sikaflex®-268 PowerCure 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 range of rail cleaning agents if used according to the guidelines of the manufacturer. Some rail cleaning agents contain aggressive chemicals such as phosphoric acids which may influence the durability of Sikaflex®-268 significantly. Therefore it is of highest importance to limit the exposure time to a minimum, observe correct dilution of cleaning agent and to perform a thorough rinsing after the cleaning process. Test newly introduced cleaning agents. 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. Therefore all recommendations must be determined by preliminary tests. Advice on specific applications is available from the Technical Department of Sika Industry.

**Application** Setup the PowerCure Dispenser according to the PowerCure User Manual. If the application is discontinued for more than 10 minutes, the mixer needs to be replaced. Sikaflex®-268 PowerCure can be processed between 10 °C and 35 °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).



**Tooling and Finishing** Fill exposed joints completely without voids until slightly overfilled, then remove excess product. Respect the tooling time! For smooth joint finishes use Sika® Tooling Agent N.

**Removal** Uncured Sikaflex®-268 PowerCure 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** Copies of the following publications are available upon request:

- Safety Data Sheet
- General Guidelines - Bonding and Sealing with Sikaflex® and SikaTack®
- PowerCure Dispenser
  - Operating Instructions
  - Quick Reference Guide

**Packaging** 600 ml PowerCure Pack

**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 most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.

KEEP OUT OF REACH OF CHILDREN  
FOR INDUSTRIAL USE ONLY

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 shelflife. 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 information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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