

# Sikaflex<sup>®</sup>-265

## Direct glazing adhesive for buses, trucks and rail vehicles

### Technical Product Data

Chemical base	1-C polyurethane
Colour	Black
Density (DIN 53479) (uncured)	1.20 kg/L approx.
Non-sag properties	Very good, with no tendency to sag or slump
Cure mechanism	Moisture-curing
Tack-free time <sup>1)</sup>	45 minutes approx.
Rate of cure <sup>1)</sup>	3 mm / 24 hrs. approx. (see diagram)
Shrinkage (DIN 52451)	1% approx.
Shore A hardness (DIN 53505)	45 approx.
Elongation at break (DIN 53504)	450% approx.
Tensile strength (DIN 53504)	6 N/mm <sup>2</sup> approx.
Tear strength (DIN 53515)	10 N/mm approx.
Tensile lap-shear strength (EN 1465) for a 4 mm applied thickness	4.5 N/mm <sup>2</sup> approx.
Glass transition temperature (DIN 53445)	-45°C approx.
Volume resistivity (DIN 53482)	10 <sup>6</sup> Ω cm approx.
Service temperature	continuous short term (up to 8 hrs.)
Shelf life (stored below 25°C)	cartridge pail or drum
	-40°C to 90°C 120°C
	9 months 6 months

<sup>1)</sup> at 23°C and 50% relative humidity

### Description

Sikaflex<sup>®</sup>-265 is a high-performance elastic gap-filling one-part polyurethane adhesive that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex<sup>®</sup>-265 is manufactured in accordance with the ISO 9001/14001 quality assurance system.

### Product Benefits

- One-part formulation
- Excellent working characteristics
- Fast cure time and low odour
- Resistant to ageing and weathering
- Solvent and PVC-free

### Areas of Application

Sikaflex<sup>®</sup>-265 is designed for direct glazing applications in both the OEM and repair markets, and is suitable for use with mineral glass-based windows. Before installing laminated safety glass windshields incorporating heating elements or radio aerials in the PVB sandwich layer, we recommend that you contact Sika's Technical Service Department for advice.

Because Sikaflex<sup>®</sup>-265 can be tooled to a very fine finish, and because it is specifically designed for enhancing its UV resistance, it is suitable for use in exposed joints.

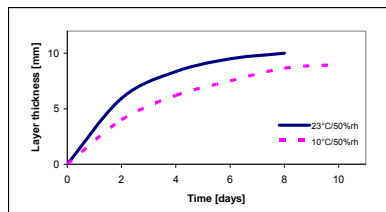
This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



## Cure Mechanism

Sikaflex®-265 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds at a slower rate (see diagram).



## Chemical Resistance

Sikaflex®-265 is resistant to fresh water, aqueous, acid, neutral and alkaline chlorine free cleaning agents; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids and caustic solutions, bleach or solvents. 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 all traces of grease, oil, wax and dust. The bond faces must be properly treated (see table on the right). Detailed information on the use and application of Sika® adhesion promoters will be found in the appropriate product data sheet. The above information is offered for general guidance only. Advice on specific applications will be given on request.

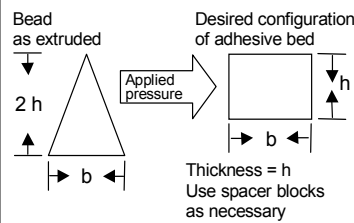
### Application

Pierce cartridge membrane and peel back completely. Cut off the tip of the nozzle to give desired adhesive bead geometry.

For satisfactory results the adhesive must be applied with a hand-operated cartridge gun, piston-type compressed-air gun or pump-operated bulk dispensing equipment.

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

## Recommended bead configuration



Glass with fitted cover trim or opaque painted border	Sika® Aktivator
Glass with black ceramic border, light transmission factor toughened safety glass: < 0.1%, 400 – 500 nm (for cars and BTR only) light transmission factor laminated safety glass: < 0.2%, 400 – 500 nm (for cars and BTR only)	Sika® Aktivator
Glass with black ceramic border, light transmission factor toughened safety glass: > 0.1% 400 – 500 nm (for cars and BTR only) light transmission factor laminated safety glass: > 0.2%, 400 – 500 nm (for cars and BTR only)	Sika® Aktivator + Sika® Primer-206 G+P
Sheet metal, painted (cathaphoretic immersion coatings, two part finish lacquers)	Sika® Aktivator or Sika® Remover-208

Fill exposed joints with Sikaflex®-265 completely without voids until slightly overfilled, then remove excess adhesive with a suitable putty knife or spatula. If necessary, the surface of the adhesive may be tooled to a neat, smooth finish using Sika® Tooling Agent N as a lubricant.

## Important

Do not apply at temperatures below 10°C or above 35°C. The optimum temperature for substrate and adhesive is between 15°C and 25°C.

Approximate drive-away times for vehicles following glass installation or replacement under optimum cure conditions (23°C / 50% R.H.) are as follows:

Buses and trucks (windshield)	6 hours
Rail vehicles	12 hours

For advice on selecting and setting up a suitable pump system, as well as on the techniques of pump-operated application, please contact our System Engineering Department.

## Clean up

Uncured Sikaflex®-265 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 a suitable industrial hand cleanser and water. Do not use solvents!

## Further Information

Copies of the following publications are available on request:

- Sika Primer Chart
- Material Safety Data Sheet

## Value Basis

All technical data stated in this Product Data Sheet and laboratory test based. Current measured values may vary due to factors beyond our control.

## 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.

All Product Data Sheets and Material Safety Data Sheets are also available on our web site.

## 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, 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.

Further information available at:  
[www.sika.ca](http://www.sika.ca)

Sika Canada Inc.  
601 Delmar Avenue  
Pointe-Claire, QC H9R 4A9  
Tel : 514-697-2610  
1-800-689-7452  
Fax : 514-697-3910

An ISO 9001:2000 certified company  
Pointe-Claire : ISO 14001:2004 certified EMS

# Industry

