

# Sikaflex®-255 FC

## Black-primerless direct glazing adhesive

### Technical Product Data

Chemical base	1-C polyurethane
Color (CQP <sup>1</sup> 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 - 35°C (50 - 95°F)
Skin time <sup>2</sup> (CQP 019-1)	40 min approx.
Open time <sup>2</sup> (CQP 526-1)	20 min approx.
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 <sup>2</sup> 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 <sup>2</sup> approx.
Volume resistivity (CQP 079-2 / ASTM D 257-99)	10 <sup>7</sup> Ω cm approx.
Service temperature (CQP 513-1)	-40 - 90°C (-40 - 195°F)
Shelf life (storage below 25°C) (CQP 016-1)	9 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23°C (73°F) / 50% r.h.

### Description

Sikaflex®-255 FC is a 1-component elastic high-performance direct glazing adhesive with gap-filling capabilities that cures on exposure to atmospheric humidity and form a durable elastomer.

Sikaflex®-255 FC is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

### Product Benefits

- Fast-curing
- 1-component adhesive
- Excellent processing properties
- Wide adhesion range 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 experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



### Cure Mechanism

Sikaflex®-255 FC 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).

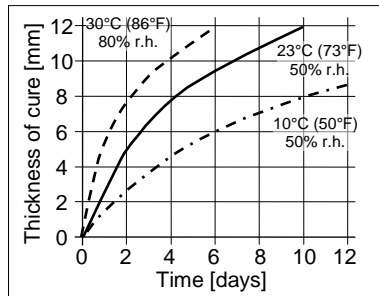


Diagram 1: Curing speed Sikaflex®-255 FC

### Chemical Resistance

Sikaflex®-255 FC is resistant to fresh water, seawater, and proprietary aqueous cleaning agents; temporarily resistant to fuels, mineral oils, 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 on request.

### Method of Application

#### Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. As a guideline for surface preparation the corresponding Sika Pre-Treatment Chart should be used. Advice on specific applications is available from the Technical Service 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 (see figure 1).

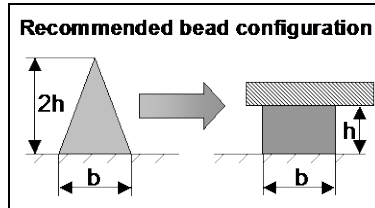


Figure 1: Recommended bead configuration

### 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 / compatibility.

### Removal

Uncured Sikaflex®-255 FC can be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean Towel 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 Pre-treatment Chart
- 1-component Polyurethanes
- General Guidelines - Bonding and Sealing with Sikaflex®

### Packaging Information

Cartridge	300 ml
Unipack	400 ml
	600 ml

### 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 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.

Further information available at:  
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