

## PRODUCT DATA SHEET

# Sikaflex®-271

Glazing adhesive with acceleration option

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Chemical base		1-component polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)	Adhesive	1.20 kg/l (10.0 lb/gal)
Non-sag properties		Very good
Application temperature	ambient	10 – 45 °C (50 – 113 °F)
Skin time (CQP019-1)		20 minutes <sup>A</sup>
Open time (CQP526-1)		15 minutes <sup>A</sup>
Shrinkage (CQP014-1)		1 %
Shore A hardness (CQP023-1 / ISO 48-4)		65
Tensile strength (CQP036-1 / ISO 527)		7 MPa (1000 psi)
Elongation at break (CQP036-1 / ISO 527)		300 %
Tear propagation resistance (CQP045-1 / ISO 34)		10 N/mm (55 pli)
Tensile lap-shear strength (CQP046-1 / ISO 4587)		5 MPa (720 psi)
Service temperature (CQP509-1 / CQP513-1)		-40 – 90 °C (-40 – 194 °F)
	4 hours	120 °C (248 °F)
	1 hour	140 °C (284 °F)
Shelf life	drum	6 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C (73 °F) / 50 % r. h.<sup>B</sup>) Storage below 25 °C (77 °F)
**DESCRIPTION**

Sikaflex®-271 is an elastic polyurethane adhesive system for glazing applications. Suited for bonding materials relevant for direct glazing such as paints, glass, ceramic frits, painted and e-coated surfaces in commercial-vehicle production and repair.

Sikaflex®-271 is compatible with Sika's black-primerless bonding process and can be accelerated with Sika's Booster and PowerCure systems.

**PRODUCT BENEFITS**

- Excellent application properties
- Curing can be accelerated with Sika Booster and Sika PowerCure
- High mechanical strength
- Solvent-free

**AREAS OF APPLICATION**

The Sikaflex®-271 system is designed especially for manual and automated direct-glazing application out of bulk packaging in the Transportation OEM market.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-271 on materials prone to stress cracking.

Sikaflex®-271 is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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Sikaflex®-271

Version 03.01 (04 - 2023), en\_US  
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## CURE MECHANISM

Sikaflex®-271 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.

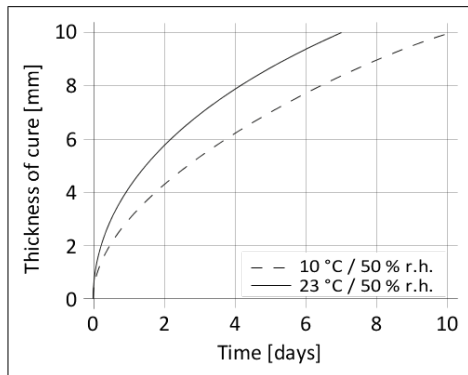


Diagram 1: Curing speed Sikaflex®-271

## CHEMICAL RESISTANCE

Sikaflex®-271 is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

### Application

Sikaflex®-271 can be processed at temperatures (climate and product) between 10 °C and 45 °C (50 °F and 113 °F) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C (59 °F and 77 °F).

Consider the viscosity increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

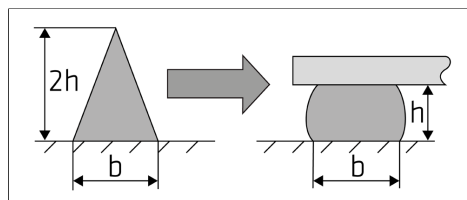


Figure 1: Recommended bead configuration

Sikaflex®-271 can be processed with pump equipment. The open time is significantly shorter in hot and humid climate. The parts must always be installed within the open time. The glass must always be installed within the open time. Never join bonding parts if the adhesive has built a skin.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

### Removal

Uncured Sikaflex®-271 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 have to be washed immediately using a suitable industrial hand cleaner and water.

Do not use solvents on skin!

## FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Pre-treatment Chart
  - For 1-component polyurethanes
- General Guidelines
  - Bonding and Sealing with 1-component Sikaflex®

## PACKAGING INFORMATION

Drum	195 l
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## BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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