

PRODUCT DATA SHEET

Sikaflex®-250 KH-4

Room temperature applied direct glazing adhesive for automotive OEM

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Polyurethane
Color	Black
Cure mechanism	Moisture-curing
Density (uncured)	1.28 kg/l
Non-sag properties	Very good
Application temperature	ambient, product 10 – 40 °C
Skin time (CQP019-4)	30 minutes ^A
Open time (CQP526-1)	10 minutes ^A
Curing speed (CQP049-1)	See diagram 1
Shore A hardness (CQP023-1 / ISO 48-4)	52
Tensile strength (CQP036-1 / ISO 527)	6.0 MPa
Elongation at break (CQP036-1 / ISO 527)	275 %
Tensile lap-shear strength (CQP046-1 / ISO 4587)	4.6 MPa
Shelf life	6 months ^B

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r.h.^B) stored below 25 °C in unopened container
DESCRIPTION

Sikaflex®-250 KH-4 is a 1-component polyurethane direct glazing adhesive with a high initial strength, which cures on exposure to atmospheric humidity.

This product is developed for direct glazing in the automotive industry.

PRODUCT BENEFITS

- Primerless to paint
- Good working characteristics
- 1-component application
- High initial strength
- Short cut-off string
- PVC and solvent free

AREAS OF APPLICATION

Sikaflex®-250 KH-4 is suitable for automated and manual direct glazing as well as permanent elastic bonding of components in the automotive industry. Common substrates are pre-treated ceramic frits and glasses with corresponding UV protection as well as cleaned e-coated and painted surfaces. For glasses and ceramic frits, a pre-treatment is mandatory.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-250 KH-4 on materials prone to stress cracking. This product is suitable for experienced professional users only.

Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

Sikaflex®-250 KH-4 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).

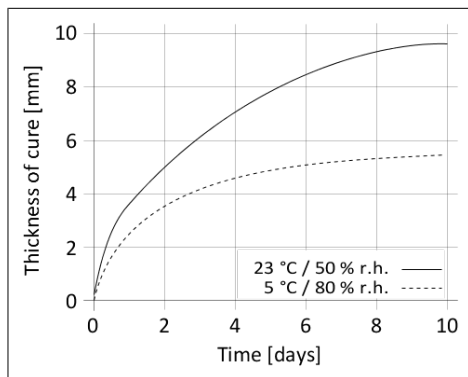


Diagram 1: Curing speed of Sikaflex®-250 KH-4

CHEMICAL RESISTANCE

Sikaflex®-250 KH-4 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®-250 KH-4 can be processed between 10 °C and 40 °C (climate and product) 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.

Consider that the viscosity will 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).

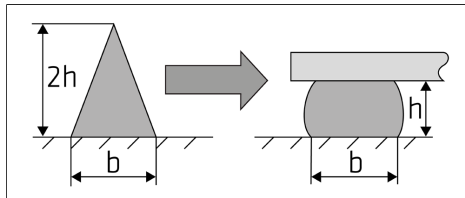


Figure 1: Recommended bead configuration

Sikaflex®-250 KH-4 can be processed with manual, pneumatic or electric driven piston guns as well as pump equipment.

The open time is significantly shorter in hot and humid climate. The glass must always be installed within the open time. Never bond in glass 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®-250 KH-4 may 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 hand wipes or 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
- Sika Pre-treatment Chart
 - For 1-component Polyurethanes
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Drum	53 gal (US)

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 or by contacting SIKA's Technical Service Department via email at 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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PRODUCT DATA SHEET

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