

# Sikaflex®-265

Direct glazing adhesive for buses, trucks and rail vehicles

## Technical Product Data (typical values)

Chemical base	1-C polyurethane
Color	Black
Cure mechanism	Moisture Cure
Density (uncured)	10.1 lb/gal
VOC (EPA method 24)	0.53 lb/gal (64 g/l)
Non-sag properties	Very Good
Application temperature	product 50°F - 95°F (10°C - 35°C)
Tack free time <sup>1</sup>	45 min
Open time <sup>1</sup>	30 min
Curing speed	(see diagram 1)
Shrinkage	<1%
Shore A-hardness (ASTM D 2240)	45
Tensile strength (ASTM D 412)	870 psi
Elongation at break (ASTM D 412)	450%
Tear propagation resistance (ASTM D 624)	57 pli
Tensile lap-shear strength (ASTM D 1002)	650 psi
Volume Resistivity (ASTM D 257-99)	10 <sup>6</sup> Wcm approx.
Service temperature	permanent -40°F-194°F (-40°C-90°C)
Shelf life (storage below 77°F (25°C))	9 months

<sup>1)</sup> 73°F (23°C) / 50% r.h.

### Description

Sikaflex®-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®-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 odor
- High Green Strength
- Excellent Sag Resistance
- Resistant to aging and weathering
- Solvent and PVC-free

### Areas of Application

Sikaflex®-265 is designed for direct glazing applications in both OEM and Aftermarket industries, and is suitable for use with mineral glass-based windows. **SURFACE PREPARATION INCLUDING APPROVED CERAMIC FRIT ON WINDOW PERIMETER IS REQUIRED TO PROTECT AGAINST UV DEGRADATION OF ADHESIVE.** 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 at 888 832-7452 for advice.

Industry



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

### Cure Mechanism

Sikaflex®-265 cures by atmospheric moisture. At low temperatures the water content of the air is lower. Curing reaction proceeds at a slower rate (See Diagram 1).

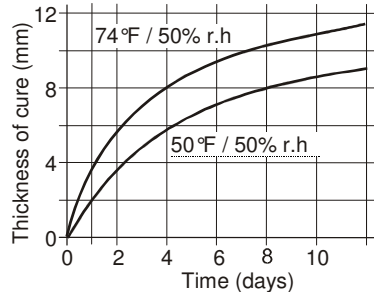


Diagram 1: Curing speed Sikaflex®-265

### 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. Detailed information on the use and application of Sika® adhesion promoters may 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

Unipacs: Place sausage in the application gun and snip off the

closure clip. 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 or battery powered gun. To ensure a uniform thickness of adhesive bead, we recommend that the adhesive be applied in the form of a triangular bead (see diagram below).

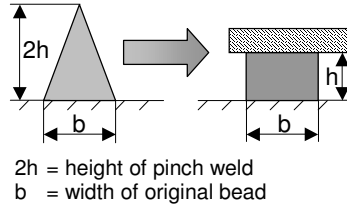


Figure 1: Recommended bead configuration

### Tooling and finishing

Tooling and finishing must be carried out within the tack free time of the adhesive. We recommend the use of Sika®-Slick. Other finishing agents or lubricants must be tested for suitability/compatibility.

### Removal

Uncured Sikaflex®-265 may be removed from tools and equipment with Sika® Remover-208, mineral spirits or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using a suitable industrial hand cleaner and water. Strictly follow solvent manufacturer's instructions for use and warnings. Do not use solvents on skin!

### Limitations

Do not apply at temperatures below 50°F (10°C) or above 95°F (35°C). The optimum temperature for substrate and adhesive is between 59°-77°F (15°-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.

- Do not apply on frozen surfaces or through standing water or under water.
- Do not apply over silicones or in the presence of curing silicones.
- Alcohol inhibits the cure of Sikaflex®-265 or any other polyurethane based material. Do not allow Sikaflex®-265 to contact alcohol and alcohol containing solvents during cure.
- Do not use to bond organic glass (i.e. polycarbonate and acrylic).

### CAUTION: IRRITANT.

Irritant;Sensitizer: Contains Polyisocyanate pre-polymer, xylene. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. Xylene may cause headaches, dizziness or other CNS effects; and may cause liver or kidney effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH/MSHA approved respirator. Remove contaminated clothing.

### HMIS

Health	*2
Flammability	1
Reactivity	0
Personal Protection	C

### First Aid Measures

**Eyes** – Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin** – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation** – Remove to fresh air. **Ingestion** – Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further information available at:  
[www.sikaindustry.com](http://www.sikaindustry.com)

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**Sika**®



### Further Information

Copies of the following publications are available on our website [www.sikaindustry.com](http://www.sikaindustry.com):  
-Material Safety Data Sheets  
-Product Data Sheet  
-Sika Primer Chart  
-General guidelines for bonding and sealing with Sika products

### In case of emergency call:

**Chemtrec: 800-424-9300**  
**International: 703-527-3887**

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

**-KEEP OUT OF REACH OF CHILDREN**  
**-NOT FOR INTERNAL CONSUMPTION**  
**-FOR INDUSTRIAL USE ONLY**  
**-KEEP CONTAINER TIGHTLY CLOSED**

### Packaging Information

Unipac	600 ml
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### Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

### Handling and Storage

Avoid direct contact. Wear personal protective equipment (chemical resistant gloves/goggles/clothing) to prevent direct contact with skin and eyes. Use only in well ventilated areas. Open doors and windows during use. Use a properly fitted NIOSH respirator if ventilation is poor. Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse. Store below 77°F (25°C) in a cool dry place away from sunlight.

### Clean Up

Use personal protective equipment (chemical resistant gloves/goggles/clothing). Without direct contact, remove spilled or excess product and place in suitable sealed container. Dispose of excess product and container in accordance with applicable environmental regulations.

### Limited Material Warranty

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at [www.sikacorp.com](http://www.sikacorp.com) or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at [www.sikaindustry.com](http://www.sikaindustry.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

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