BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-250 DB-2

High green strength direct glazing adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.33 kg/l
Non-sag properties		Good
Application temperature	adhesive ambient	60 °C 15 – 35 °C
Skin time (CQP019-4)		20 minutes [A]
Curing speed (CQP049-1)	at 24 hours	3mm [A]
Shore A hardness (CQP023-1 / ISO 48-4)		65
Tensile strength (CQP036-1 / ISO 527)		8.0 MPa
Elongation at break (CQP036-1 / ISO 527)		200 %
Tear propagation resistance (CQP045-1 / ISO 34)		10.0 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4.5 MPa
Shear modulus (CQP081-1)	at 10 %	2.7 MPa
Insulation resistance (CQP079-2 / DIN IEC 60167)	at 1 V	> 10^9 Ωcm
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 DB-2 is a 1-component high modulus polyurethane direct glazing adhesive with good initial strength, which cures on exposure to atmospheric humidity. This product is developed for direct glazing in the automotive industry.

Sikaflex®-250 DB-2 is manufactured in accordance with ISO 9001 / 14001 quality assurance system.

PRODUCT BENEFITS

- 1-component application
- With most automotive glass only activation step required
- High modulus
- Primerless to many paints
- High initial grip
- No contact corrosion on aluminum
- Short cut-off string
- Good working characteristics

AREAS OF APPLICATION

Sikaflex®-250 DB-2 is suitable for automated and manual direct glazing as well as permanent elastic bonding of components in the automotive industry. Sikaflex®-250 DB-2 bonds well to numerous substrates. Common substrates are pre-treated ceramic frits and glasses with corresponding UV protection as well as cleaned e-coated and painted surfaces.

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 DB-2 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.

CHEMICAL RESISTANCE
Sikaflex®-250 DB-2 is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, ethanol, 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. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application
Sikaflex®-250 DB-2 can be processed between 15 °C and 35 °C (ambient) but changes in reactivity and application properties have to be considered.
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).

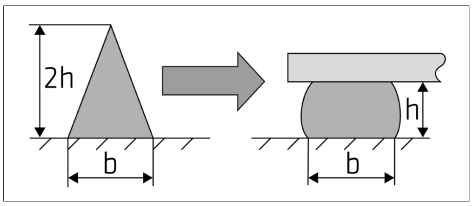

Figure 1: Recommended bead configuration

Sikaflex®-250 DB-2 is processed with a corresponding pump equipment.
The skin time is significantly shorter in hot and humid climate. 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.
For transparent substrates, bond faces must be fully UV protected by suitable design or means.

Removal
Uncured Sikaflex®-250 DB-2 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
- General Guideline
  Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION
Drum	200 l
Hobbock	23 l

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.

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Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
U.S.A.
Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com