BUILDING TRUST

PRODUCT DATA SHEET

Sikaflex®-255 Ultra

OEM approved and low odor Auto Glass Adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		1-component polyurethane
Colour (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.31 kg/l
Non-sag properties (CQP061-1)		Good
Application temperature	product ambient	5 – 40 °C 5 – 40 °C
Skin time (CQP019-1)		40 minutes [A]
Open time (CQP526-1)		30 minutes [A]
Curing speed (CQP049-1)		(see diagram)
Shore A hardness (CQP023-1 / ISO 7619-1)		50
Tensile strength (CQP036-1 / ISO 527)		5 MPa
Elongation at break (CQP036-1 / ISO 527)		500 %
Tear propagation resistance (CQP045-1 / ISO 34)		12 N/mm
Tensile lap-shear strength (CQP046-1 / ISO 4587)		3 MPa
Minimum Drive Away Time (cars) according FMVSS 212 (CQP511-1)	with airbags	3 hours [A/B]
Shelf life (CQP016-1)		9 months [C]

CQP = Corporate Quality Procedure [A] 23 °C / 50 % r. h. [B] Details about MDAT contact Sika [C] storage below 25 °C

DESCRIPTION

Sikaflex®-255 Ultra is a cold applied windscreen adhesive, optimized for manual application. It provides a long open time and ensures safe application even under warm conditions.
Sikaflex®-255 Ultra is compatible with Sika's Black Primerless and All Black processes and may also be used as a primerless to glass adhesive in auto glass replacement applications.
Note: Primerless to glass application requires the glass to be prepared using an Automotive grade glass cleaner such as Sika® Clean Glass. The bonding surfaces must be free of contamination and have sufficient UV protection.

PRODUCT BENEFITS

- Easy to extrude with manual application gun
- Solvent free, no odour
- OEM approved adhesive system
- Fast adhesion build up
- Primerless to glass adhesion

AREAS OF APPLICATION

Sikaflex®-255 Ultra is suitable for experienced professional users only.
This product and related process information is designed for Automotive Glass Replacement. For other applications, tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

Sikaflex®-255 Ultra 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).

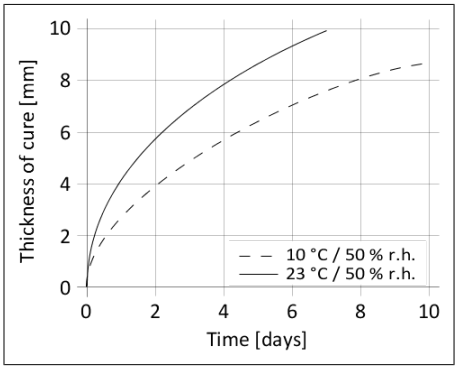

Diagram 1: curing speed Sikaflex®-255 Ultra

CHEMICAL RESISTANCE

Sikaflex®-255 Ultra 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.
The bond faces must be prepared with an Automotive grade glass cleaner such as Sika® Clean Glass.
Sikaflex®-255 Ultra is capable to bond on glass and ceramic frits without additional pre-treatment. It is compatible with Sika's Black-Primerless or All Black installation process for best results.
Further information on the application and use of pre-treatments, can be found in the corresponding Product Data Sheet.
Note: Glass without ceramic coatings need proper UV protection.

Application

Sikaflex®-255 Ultra can be processed between 5 °C and 40 °C but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and adhesive 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 recommend to apply the adhesive in form of a triangular bead (see figure 1).

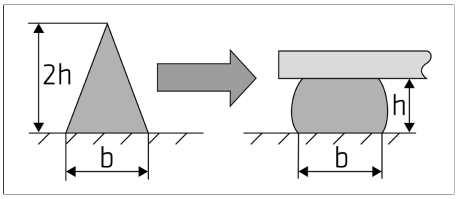

Figure 1: Recommended bead configuration

The open time is significantly shorter in hot and humid climates. The glass must always be installed within the open time. Never install a glass after the adhesive has built a skin.

Removal

Uncured Sikaflex®-255 Ultra may be removed from tools and equipment with Sika® Remover-208 or other suitable solvents. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H 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
- Black-Primerless installation process chart
- All Black installation process chart

PACKAGING INFORMATION

Cartridge	310 ml
Unipack	600 ml

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.

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.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse 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.