

## PRODUCT DATA SHEET

# Sikaflex<sup>®</sup>-255 FC

Fast curing direct glazing adhesive for commercial vehicles

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

Chemical base	1-component polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured)	1.2 kg/l (10.0 lb/gal)
Non-sag properties	Very good
Application temperature	10 – 35 °C (50 – 95 °F)
Skin time (CQP019-1)	40 minutes <sup>A</sup>
Open time (CQP526-1)	20 minutes <sup>A</sup>
Curing speed (CQP049-1)	(see diagram)
Shrinkage (CQP014-1)	3 %
Shore A hardness (CQP023-1 / ISO 48-4)	60
Tensile strength (CQP036-1 / ISO 527)	6 MPa (870 psi)
Elongation at break (CQP036-1 / ISO 527)	450 %
Tear propagation resistance (CQP045-1 / ISO 34)	12 N/mm (70 pli)
Tensile lap-shear strength (CQP046-1 / ISO 4587)	4 MPa (580 psi)
Service temperature (CQP509-1 / CQP513-1)	-40 – 90 °C (-40 – 194 °F)
Shelf life (CQP016-1)	cartridge / unipack
	drums
	9 months <sup>B</sup>
	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<sup>®</sup>-255 FC is a 1-component, high-strength adhesive for commercial-vehicle glazing and glass replacement applications. It provides a long open time and ensures safe application even in warm conditions. Sikaflex<sup>®</sup>-255 FC is compatible with Sika's black-primerless bonding process.

**PRODUCT BENEFITS**

- Fast-curing
- Very good processing properties
- Wide adhesion range on most relevant substrates

**AREAS OF APPLICATION**

Sikaflex<sup>®</sup>-255 FC is designed for direct glazing applications with mineral glass-based windows in the Transportation OEM and vehicle glass replacement markets.

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

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Sikaflex<sup>®</sup>-255 FC

Version 02.01 (04 - 2022), en\_US  
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## CURE MECHANISM

Sikaflex®-255 FC 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).

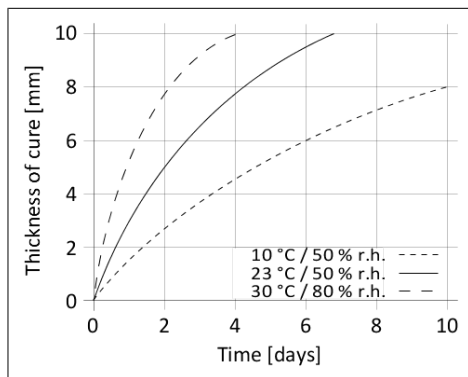


Diagram 1: Curing speed Sikaflex®-255 FC

## CHEMICAL RESISTANCE

Sikaflex®-255 FC 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®-255 FC can be processed at temperatures (climate and product) between 10 °C and 35 °C (50 °F and 95 °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).

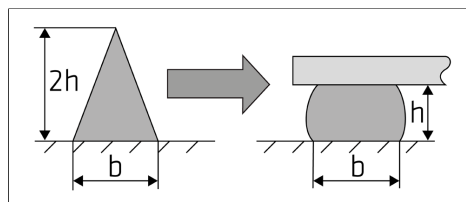


Figure 1: Recommended bead configuration

Sikaflex®-255 FC 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 install a glass after 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®-255 FC 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
- Sika Pre-treatment Chart
  - For 1-component Polyurethanes
- General Guidelines
  - Bonding and Sealing with 1-component Sikaflex®

### PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Drum	200 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.

## 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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## Sika Corporation

30800 Stephenson Highway  
Madison Heights, MI 48071  
U.S.A.  
Telephone: +1 248-577-0020  
Email: [tsmh@us.sika.com](mailto:tsmh@us.sika.com)  
[www.sikausa.com](http://www.sikausa.com)

