

Sikaflex® -258

Direct glazing adhesive

Industry

Technical product data:

Chemical base	one-part polyurethane
Colour	black
Density (uncured)	1,2 kg/l approx.
Stability (non-sag properties)	good
Cure mechanism	moisture-curing
Tack-free time*	55 minutes approx.
Rate of cure*	3 mm per 24 hrs. (see diagram)
Shrinkage	-6% approx.
Shore A hardness	55 approx.
Tensile strength	>4,5 N/mm ²
Elongation at break (DIN 53504)	600% approx.
Tensile-shear strength for a 4 mm applied thickness	3,5 N/mm ²
Service temperature (continuous)	-40°C to +80°C
Shelf life (stored below 25°C)	9 months

* at 23°C and 50% relative humidity

Description:

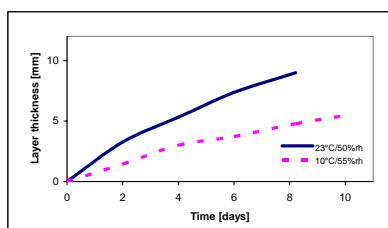
Sikaflex®-258 is a high-performance, elastic, gap-filling, one-part polyurethane adhesive that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-258 is manufactured in accordance with the ISO 9001 / 14001 quality assurance system.

Product benefits:

- one-part formulation
- primerless
- low odour
- fast cure
- short cut-off string
- good workability

Cure mechanism:

Sikaflex®-258 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds more slowly (see diagram).



Areas of application:

Sikaflex®-258 is suitable for direct glazing applications in both the OEM and repair markets.

Chemical resistance:

Sikaflex®-258 is resistant to fresh water, seawater, limewater, sewage effluent, dilute acids and caustic solutions; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, alcohol, concentrated mineral acids and caustic solutions 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 and dust. The bond faces must be treated with a cleansing and activating agent or primed with the appropriate primer as follows:

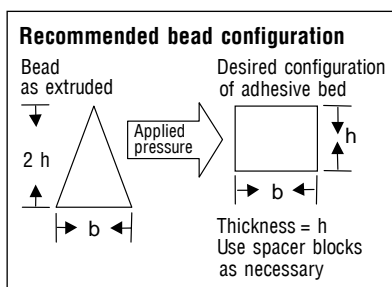
Glass without cover trim (for cars only)	Sika® Activator + Sika® Primer-206 G+P
Glass with cover trim	Sika® Activator
Glass with black ceramic border, light transmission factor, toughened safety glass: <math>< 0,1\%</math>, 400 – 500 nm, light transmission factor, laminated safety glass: <math>< 0,2\%</math>, 400 – 500 nm, (for cars only)	Sika® Activator
Sheet metal, painted (cataphoretic immersion coatings, two part finish lacquers)	Sika® Activator
Old polyurethane direct glazing adhesive (cut face)	Sika® Activator

Detailed information on the use and application of these products will be found in their relevant product data sheets.

Application: For cartridges: Pierce the cartridge membrane and peel back completely. For unipacs: place in the application gun and snip off the closure clip.

Cut off the tip of the nozzle in accordance with the vehicle manufacturer's recommendations. For satisfactory results the adhesive must be applied with a piston-type cartridge gun (hand-operated or compressed air).

To ensure uniform thickness of adhesive when compressed, we recommend to apply the adhesive in the form of a triangular bead (see illustration).



Important: Do not apply at temperatures below 5°C or above 35°C. The optimum temperature for substrate and sealant is between 15°C and 25°C.

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

Removal:

Uncured Sikaflex®- 258 may be removed from tools and equipment with Sika® Remover-208. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using a suitable industrial hand cleanser and water. Do not use solvents!

Further information:

Copies of the following publications are available on request:

- Instruction for auto glass replacement
- Safety Data Sheet

Note:

The information, and, in particular, the recommendations relating to the application and end-use 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 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 relation -ship, whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.



Sika Limited (Vietnam)

HEAD OFFICE: Nhơn Trạch I Industrial Zone, Đồng Nai, Tel: +84 61 848576, Fax: +84 61 848581, sikath@hcm.vnn.vn

SALES OFFICE: 8 Nguyễn Huệ, Fl.3, Dist.1, Hồ Chí Minh City, Tel: +84 8 8256040, Fax: +84 8 8256042, sikavn@hcm.vnn.vn

HÀ NỘI: 133 Thái Hà, Fl.2, Đống Đa, Hà Nội, Tel: +84 4 8572934, Fax: +84 4 4572936; sikavn@hn.vnn.vn

ĐÀ NẴNG: 155 Trần Phú, Fl.8, Hải Châu, Đà Nẵng, Tel: +84 511 873351-52; Fax: +84 511 873353, sikadanang@dng.vnn.vn

