

# Sikaflex®-263

Direct glazing adhesive with good ageing and weathering resistance for commercial vehicles

## Typical Product Data

Chemical base	1-C polyurethane
Colour (CQP <sup>1</sup> 001-1)	Black
Cure mechanism	Moisture-curing
Density (uncured) (CQP 006-4)	1.28 kg/l
Non-sag properties (CQP 061-1)	Very good
Application temperature	5 - 40 °C
Tack-free time <sup>2</sup> (CQP 019-1)	45 min.
Open time <sup>2</sup> (CQP 526-1)	30 min.
Curing speed (CQP 049-1)	See diagram 1
Shrinkage (CQP 014-1)	2 %
Shore A hardness (CQP 023-1 / ISO 868)	60
Tensile strength (CQP 036-1 / ISO 37)	7 MPa
Elongation at break (CQP 036-1 / ISO 37)	500 %
Tear propagation resistance (CQP 045-1 / ISO 34)	15 N/mm
Tensile lap-shear strength (CQP 046-1 / ISO 4587)	4.5 MPa
Electrical resistance (CQP 079-2 / ASTM D 257-99)	10 <sup>6</sup> Ωcm
Service temperature (CQP 513-1)	-40 - 90 °C
Shelf life (storage below 25 °C) (CQP 016-1)	unipack drum / pail
	9 months 6 months

<sup>1)</sup> CQP = Corporate Quality Procedure <sup>2)</sup> 23 °C / 50 % r.h.

### Description

Sikaflex®-263 is a 1-component elastic high-performance direct glazing adhesive with gap-filling capabilities based on humidity-curing polyurethane technology. It has been designed for bonding and sealing applications in the commercial vehicles business.

### Product Benefits

- Suitable for bonding and sealing
- Good weathering resistance
- Excellent non-sag and slip-down behavior
- Exceptional processing and tooling characteristics
- Short cut-off string

### Areas of Application

Sikaflex®-263 is designed for direct glazing, general bonding and sealing applications in the transportation industry. The good tooling properties and the enhanced weathering resistance allow the realization of exposed joints. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



## Cure Mechanism

Sikaflex®-263 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).

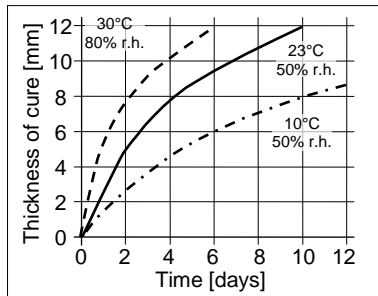


Diagram 1: Curing speed Sikaflex®-263

## Chemical Resistance

Sikaflex®-263 is resistant to fresh water, aqueous cleaning agents (neutral, acid or alkaline types, chlorine free in normal concentrations); temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids and caustic solutions and 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 grease, oil and dust. Additional surface treatment depends on the specific nature of the substrates and manufacturing process. Therefore all recommendations must be determined by preliminary tests.

Advice on specific applications is available from the Technical Department of Sika Industry.

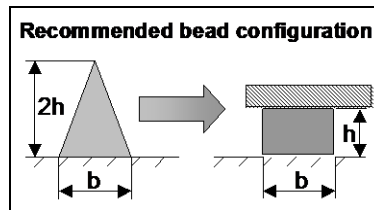
## Application

For application from unipacks, it is recommended to use an electric or compressed air piston type gun.

For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Do not apply at ambient temperatures below 10 °C or above 35 °C. The optimum temperature for the substrate is between 15 °C and 25 °C. For a better extrudability the adhesive can be heated up to 40 °C.

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



## Removal

Uncured Sikaflex®-263 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 Sika® Handclean towels or a suitable industrial hand cleanser and water. Do not use solvents!

## Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet.

Copies of the following publications are available on request:

- Safety Data Sheets
- Sika Pre-treatment Chart For 1C Polyurethane
- General Guidelines Bonding and Sealing with Sikaflex® and SikaTack®

## Packaging Information

Unipack	600 ml
Drum	195 l

## Basis of Product Data

All technical data stated in this Product Data Sheet 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 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 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.

Further information available at:  
[www.sika.co.uk](http://www.sika.co.uk)

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