

**PRODUCT DATA SHEET**

Edition 07.2017 (06.2016)

# Sikaflex®-268

**ADHESIVE AND SEALANT WITH EXCELLENT WEATHERING AND CLEANING-AGENT RESISTANCE**

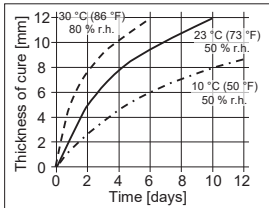
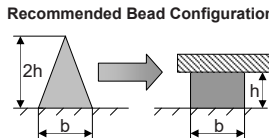
<b>Technical Data</b>	Chemical Base	Polyurethane
	Colour (CQP <sup>1</sup> 001-1)	Black
	Cure Mechanism	Moisture-curing
	Density (uncured) (CQP 006-4)	1.3 kg/L.
	Non-Sag Properties (CQP 061-1)	Very Good
	Application Temperature	5 °C to 40 °C
	Skin Time <sup>2</sup> (CQP 019-1)	60 minutes
	Open Time <sup>2</sup> (CQP 526-1)	40 minutes
	Curing Speed (CQP 049-1)	See Diagram 1
	Shrinkage (CQP 014-1)	1%
	Shore A Hardness (CQP 023-1/ISO 868)	55
	Tensile Strength (CQP 036-1/ISO 37)	6 MPa
	Elongation at Break (CQP 036-1/ISO 37)	500%
	Tear Propagation Resistance (CQP 045-1/ISO 34)	13 N/mm
	Tensile Lap-Shear Strength (CQP 046-1/ISO4587)	4.5 MPa
	G-Modulus (CQP 081-1)	at 0.1 - 10 % shear strain 1.3 MPa
	Service Temperature (CQP 513-1)	-50 °C to 90 °C
	Shelf Life (CQP 016-1) (Stored below 25 °C)	Cartridges and Sausages 9 months
		Pails and Drums 6 months
	<sup>1</sup> CQP = Corporate Quality Procedure; <sup>2</sup> 23 °C and 50% Relative Humidity.	

**Description** Sikaflex®-268 is a high-performance elastic gap-filling 1-C polyurethane adhesive/sealant specially designed for the rail vehicle market. It cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-268 offers an outstanding weathering resistance and unique resistivity to a wide range of cleaning agents.

**Product Benefits**

- Resistant to a wide range of rail industry cleaning agents;
- Excellent weathering stability;
- Very good processing and tooling characteristics;
- Tested according to E DIN 6701-3:2010-8;
- Solvent- and PVC-free.

**Areas of Application** Sikaflex®-268 is designed for large component assembly and direct glazing applications in the rail industry and for the repair market. It exhibits excellent tooling and application properties. With its superior resistance to a wide range of cleaning agents, combined with its outstanding weathering resistance, it can be used for exterior joints. This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

<b>Cure Mechanism</b>	<p>Sikaflex®-268 cures by reaction with atmospheric humidity. At low temperatures the water content of the air is generally lower and the curing reaction proceeds more slowly (See Diagram 1).</p>	
<p><b>Diagram 1:</b> Sikaflex®-268 - Curing speed</p>		
<b>Chemical Resistance</b>	<p>Sikaflex®-268 is <b>resistant</b> to fresh-water and aqueous cleaning agents (neutral, acid or alkaline types, chlorine-free - in normal concentrations); <b>temporarily resistant</b> to fuels, mineral oils, vegetable and animal fats and oils; <b>not resistant</b> to organic acids, concentrated mineral acids and caustic solutions or solvents. Sikaflex®-268 is resistant to a wide range of rail industry cleaning agents if used according to the manufacturer's guidelines. Some rail cleaning agents contain aggressive chemicals such as phosphoric acids which may influence the durability of Sikaflex®-268 significantly. Therefore, it is of highest importance to limit the exposure time to a minimum, observe correct dilution directions for cleaning agents and to perform a thorough rinsing after the cleaning process. Test newly-introduced cleaning agents. The above information is offered for general guidance only. Advice on specific applications will be given upon request.</p>	
<b>METHOD OF APPLICATION</b>		
<b>Surface Preparation</b>	<p>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 processes. Therefore, all recommendations must be determined by preliminary testing. Advice on specific applications is available from the Technical Department of Sika Industry.</p>	
<b>Application</b>	<p>For satisfactory results, the adhesive must be applied with adequate equipment such as a pump, dosing units, or piston-operated application guns. Sikaflex®-268 can be processed between 5 °C and 40 °C, but changes in reactivity as well as application properties need to be considered. The optimum process temperature (substrate, climate and product) is between 15 °C and 25 °C. To ensure uniform thickness of adhesive bead, we recommend the adhesive be applied in a triangular bead as shown below. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.</p>	
<b>Removal</b>	<p>Uncured Sikaflex®-268 may be removed from tools and equipment with Sika® Remover-208 or other suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Hand Cleaner towels or a suitable industrial hand cleaner and water. Do not use solvents on skin!</p>	
<b>Further Information</b>	<p>Copies of the following publications are available upon request:</p> <ul style="list-style-type: none"> <li>▪ <i>Safety Data Sheet</i></li> <li>▪ <i>General Guidelines - Bonding and Sealing with Sikaflex® and SikaTack®</i></li> </ul>	
<b>Packaging</b>	<p>300 ml cartridges; 600 ml sausages; 23 L pails and 195 L drums.</p>	
<b>Value Bases</b>	<p>All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.</p>	
<b>Health and Safety Information</b>	<p>For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.</p>	

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FOR INDUSTRIAL USE ONLY

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, within their shelflife. 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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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