

PRODUCT DATA SHEET

Sikaflex®-268 + SikaBooster® P-50

By Booster accelerated assembly and glazing adhesive and sealant for rail applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

| | | |
|--|------------------------|------------------------------|
| Chemical base | | Polyurethane |
| Color (CQP001-1) | | Black |
| Cure mechanism | | Moisture-curing ^A |
| Density (uncured) | Adhesive | 1.3 kg/l |
| | SikaBooster® P-50 | 1.1 kg/l |
| Booster content | by volume | 2.0 % |
| | by weight | 1.7 % |
| Non-sag properties | | Good |
| Application temperature | ambient | 10 – 35 °C |
| Open time (CQP526-1) | | 30 minutes ^B |
| Early tensile lap-shear strength (CQP046-1 / ISO 4587) | | (see table 1) |
| Shrinkage (CQP014-1) | | 1 % |
| Shore A hardness (CQP023-1 / ISO 7619-1) | | 55 |
| Tensile strength (CQP036-1 / ISO 527) | | 6 MPa |
| Elongation at break (CQP036-1 / ISO 527) | | 500 % |
| Tear propagation resistance (CQP045-1 / ISO 34) | | 13 N/mm |
| Tensile lap-shear strength (CQP046-1 / ISO 4587) | | 4.5 MPa |
| Service temperature (CQP513-1) | | -50 – 90 °C |
| Shelf life (CQP016-1) | Adhesive (pail / drum) | 6 months ^C |
| | SikaBooster® P-50 | 9 months ^C |
| Mixer | | Statomix MS 13/18 G |

CQP = Corporate Quality Procedure

^{A)} provided by SikaBooster® P-50^{B)} 23 °C / 50 % r. h.^{C)} storage below 25 °C
DESCRIPTION

Sikaflex®-268 + SikaBooster® P-50 is an accelerated adhesive system specifically designed for the rail industry. It is suitable for assembly bonding and glazing applications; its outstanding weathering resistivity and unique resistance to a wide variety of cleaning agents make it an ideal solution for use in exterior joints in the rail industry.

Sikaflex®-268 + SikaBooster® P-50 is compatible with Sika's black-primerless bonding process.

Owing to the use of SikaBooster® it cures largely independently of atmospheric conditions.

PRODUCT BENEFITS

- Resistant to a wide variety of cleaning agents
- Passes EN45545 R1/R7 HL3
- Fast-curing by Booster Technology
- Excellent weathering stability
- Very good processing and tooling characteristics
- Solvent-free

AREAS OF APPLICATION

Sikaflex®-268 + SikaBooster® P-50 is designed for assembly and direct-glazing applications in the rail and commercial vehicle industry. It exhibits excellent tooling and application properties. With its superior resistance to a wide range of cleaning agents combined with outstanding weathering resistance, it can be used for exterior joints.

The use of SikaBooster® P-50 provides rapid attainment of strength and early adhesion development.

Seek manufacturer's advice and perform tests on original substrates before using Sikaflex®-268 + SikaBooster® P-50 on materials prone to stress cracking. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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Sikaflex®-268 + SikaBooster® P-50
Version 03.01 (08 - 2021), en_DK
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CURE MECHANISM

Sikaflex®-268 + SikaBooster® P-50 cures by reaction with moisture provided by SikaBooster® P-50 and largely independent from atmospheric moisture. For typical strength build up data see table below.

| Time [h] | Tensile lap-shear strength at 23 °C [MPa] |
|----------|---|
| 2 | 0.2 |
| 3 | 1 |
| 4 | 2 |
| 6 | 3.5 |

Table 1: Strength build-up of Sikaflex®-268 + SikaBooster® P-50

CHEMICAL RESISTANCE

Sikaflex®-268 + SikaBooster® P-50 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.

It is resistant to a wide range of rail cleaning agents if used according to the guidelines of the manufacturer. Some rail cleaning agents contain aggressive chemicals such as phosphoric acids which may influence the durability of Sikaflex®-268 + SikaBooster® P-50 significantly. Therefore it is of highest importance to limit the exposure time to a minimum, observe correct dilution of cleaning agent 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 on request.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. All pre-treatment steps must be confirmed by preliminary tests on original substrates considering specific conditions in the assembly process.

Application

Sikaflex®-268 + SikaBooster® P-50 need to be processed with an adequate dispensing system. The mixer type needs to be respected (see table Typical Product Data).

Sikaflex®-268 + SikaBooster® P-50 can be applied between 10 °C and 35 °C 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. To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

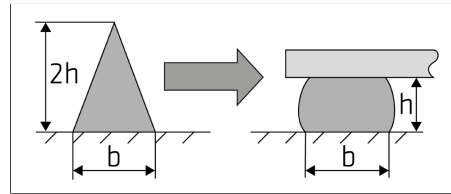


Figure 1: Recommended bead configuration

The open time is significantly shorter in hot and humid climate. The parts must always be joint within the open time. As a rule of thumb, a change of + 10 °C reduces the open time by half.

Sikaflex®-268 + SikaBooster® P-50 can be processed with pump equipment. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Tooling and finishing

Tooling and finishing must be carried out within the open time of the adhesive. We recommend the use of Sika® Tooling Agent N. Other finishing agents of lubricates must be tested for suitability and compatibility.

Removal

Uncured Sikaflex®-268 + SikaBooster® P-50 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 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
- Pre-treatment Chart
 - For 1-component polyurethanes
- General Guidelines
 - Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Sikaflex®-268

| | |
|------|-------|
| Pail | 23 l |
| Drum | 195 l |

SikaBooster® P-50

| | |
|---------|--------|
| Unipack | 600 ml |
| Pail | 23 l |

Please contact our customer service, for information of what packaging sizes are sold in Denmark.

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

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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