

# Product Details

## Typical Product Data

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Chemical base	Polyurethane
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing <sup>A</sup>
Density (uncured)	1.3 kg/l uncured
Non-sag properties (CQP061-1)	Very good
Application temperature	10 — 35 °C
Open time (CQP526-1)	30 minutes <sup>B</sup>
Early tensile lap-shear strength (CQP046-1 / ISO 4587)	(see table 1)
Shrinkage (CQP014-1)	1 %
Shore A hardness (CQP023-1 / ISO 48-4)	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 (CQP509-1 / CQP513-1)	-50 — 90 °C
Shelf life (CQP016-1)	9 months <sup>C</sup>

CQP = Corporate Quality  
Procedure

<sup>A)</sup> provided by PowerCure

<sup>B)</sup> 23 °C / 50 % r.h.

<sup>C)</sup> storage below 25 °C

# Application

## Application Information

### 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

Setup the PowerCure Dispenser according to the PowerCure User Manual. If the application is discontinued for more than 15 minutes, the mixer needs to be replaced.

Sikaflex®-268 PowerCure can be processed between 10 °C and 35 °C but changes in reactivity as well as application properties need to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C.

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.  
To ensure a uniform thickness of the bondline it is recommend to apply the adhesive in form of a triangular bead (see figure 1).

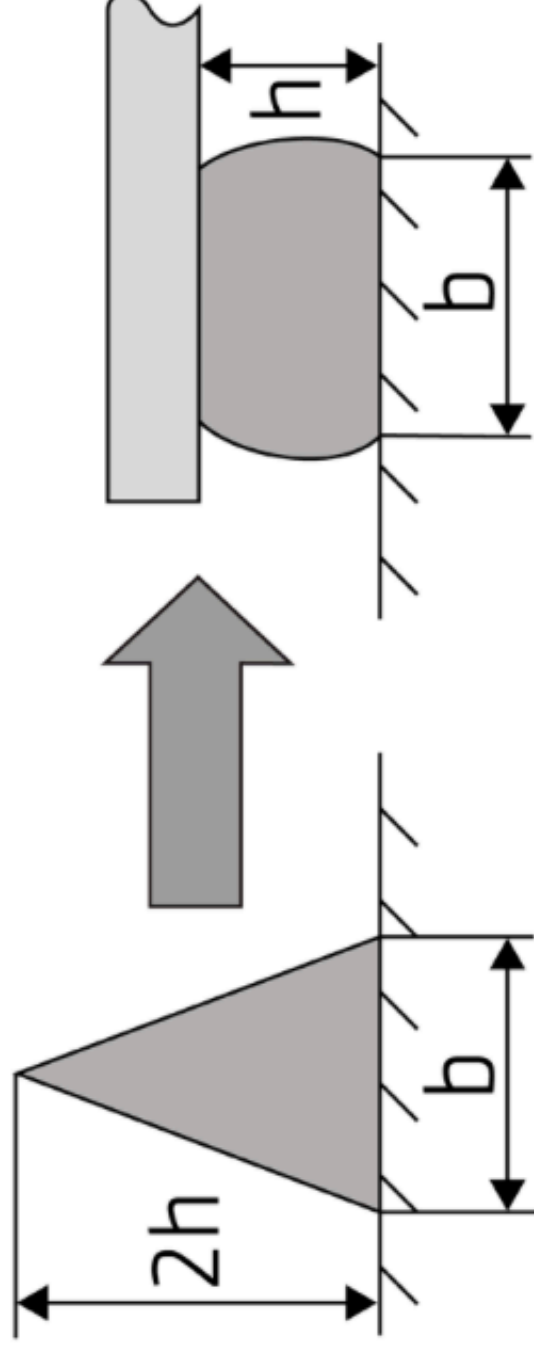


Figure 1: Recommended bead configuration

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### **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.

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### **Removal**

Uncured Sikaflex®-268 PowerCure 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!