

PRODUCT DATA SHEET

Sikaflex[®]-250 MKV-3i1

Cold applied 1-component polyurethane adhesive for assembly line applications

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Polyurethane
Color (CQP001-1)		Black
Cure mechanism		Moisture-curing
Density (uncured)		1.39 kg/l
Non-sag properties (CQP061-1)		Excellent
Application temperature	adhesive ambient	18 – 50 °C 15 – 35 °C
Skin time (CQP019-4)		60 minutes ^A
Curing speed (CQP049-1)	at 24 hours	4 mm ^A
Shore A hardness (CQP023-1 / ISO 48-4)		60
Tensile strength (CQP036-1 / ISO 527)		6.0 MPa
Elongation at break (CQP036-1 / ISO 527)		400 %
Tensile lap-shear strength (CQP046-1 / ISO 4587)		4.5 MPa
Shear modulus (CQP081-1)	at 10%	1.3 MPa
Insulation resistance (CQP079-2 / DIN IEC 60167)	at 10 V	> 10 ⁶ Ωcm
Shelf life		6 months ^B

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r.h.^B) stored below 25 °C in unopened container
DESCRIPTION

Sikaflex[®]-250 MKV-3i1 is a 1-component polyurethane adhesive for assembly line bonding applications such as trim part or DVD bonding. This material is characterized by a long open time. The good application properties make Sikaflex[®]-250 MKV-3i1 to a truly various applied adhesive.

Sikaflex[®]-250 MKV-3i1 is manufactured in accordance with ISO 9001 / 14001 quality assurance system.

PRODUCT BENEFITS

- 1-component application
- Cold applied
- PVC and solvent free
- Good non-sag properties
- Short cut-off string
- Good working characteristics

AREAS OF APPLICATION

Sikaflex[®]-250 MKV-3i1 is suitable for various assembly line applications such as cockpit bonding, roof stiffening (DVD bonding) or spare wheel-house bonding in the automotive OEM markets.

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.

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Sikaflex[®]-250 MKV-3i1

Version 04.01 (09 - 2023), en_DEAUTO

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CURE MECHANISM

Sikaflex®-250 MKV-3i1 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.

CHEMICAL RESISTANCE

Sikaflex®-250 MKV-3i1 is generally resistant to fresh water, seawater, diluted acids and diluted caustic solutions; temporarily resistant to fuels, mineral oils, ethanol, vegetable and animal fats and oils; not resistant to organic acids, glycolic alcohol, concentrated mineral acids and caustic solutions or solvents.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application

Sikaflex®-250 MKV-3i1 can be processed between 15 °C and 35 °C (ambient) but changes in reactivity and application properties have to be considered.

Consider that the viscosity will increase at low temperature. For easy application, condition the adhesive at ambient temperature prior to use. To ensure a uniform thickness of the bondline it is recommended to apply the adhesive in form of a triangular bead (see figure 1).

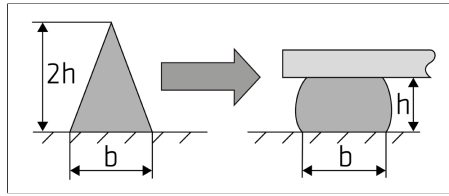


Figure 1: Recommended bead configuration

Sikaflex®-250 MKV-3i1 is processed with a corresponding pump equipment.

The skin time is significantly shorter in hot and humid climate. Never join bonding parts if the adhesive has built a skin.

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

For transparent substrates, bond faces must be fully UV protected by suitable design or means.

Removal

Uncured Sikaflex®-250 MKV-3i1 may 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 cleaning towels 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
- General Guideline Bonding and Sealing with 1-component Sikaflex®

PACKAGING INFORMATION

Cartridge	300 ml
Drum	195 l

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

The information, and, in particular, the recommendations relating to the application and enduse 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.