

PRODUCT DATA SHEET

SikaHyflex®-250 Facade

High-performance, professional, joint sealant for concrete, masonry and EIFS facades

DESCRIPTION

SikaHyflex®-250 Facade is a 1-component, moisture-curing, low-modulus elastic joint sealant.

USES

SikaHyflex®-250 Facade is designed for the elastic joint sealing and waterproofing of movement and connection joints in building envelopes. Due to its very low modulus, SikaHyflex®-250 Facade is also suitable for EIFS Facades.

CHARACTERISTICS / ADVANTAGES

- Very good weathering resistance
- Movement capability of +100 / -50% (ASTM C 719)
- Bubble-free curing
- Low stress to the substrate
- Very good extrusion and workability
- Good adhesion to many different substrates
- Solvent-free
- Very low emissions

PRODUCT INFORMATION

Chemical Base	i-Cure® Technology polyurethane	
Packaging	600 ml sausage, 20 sausage per box	
Shelf Life	SikaHyflex®-250 Facade has a shelf life of 15 months from the date of production, if it is stored in undamaged, original, sealed packaging, and if the storage conditions are met.	
Storage Conditions	SikaHyflex®-250 Facade shall be stored in dry conditions, where it is protected from direct sunlight.	
Colour	Dark Grey, Concrete Grey, Black, Dark Amber, White and Sandstone	
Density	~1.35 kg/l	(ISO 1183-1)

ENVIRONMENTAL INFORMATION

- EMICODE EC1PLUS R
- LEED v4 EQc 2: Low-Emitting Materials
- SikaHyflex®-250 Facade is listed on the Eco-Product Directory as environmentally friendly product choice for green building initiatives (application no.: PL-01469-2022)

APPROVALS / STANDARDS

- EN 15651-1 F EXT-INT CC 25 LM
- ISO 11600 F 25 LM
- DIN 18540 F
- ASTM C 920, class 100/50

TECHNICAL INFORMATION

Shore A Hardness	~20 (after 28 days)	(ISO 868)
Secant Tensile Modulus	~0.30 N/mm ² at 100% elongation (23 °C) ~0.60 N/mm ² at 100% elongation (-20 °C)	(ISO 8339)
Elongation at Break	~800%	(ISO 37)
Movement Capability	± 25% +100 / -50%	(ISO 9047) (ASTM C 719)
Elastic Recovery	~80%	(ISO 7389)
Tear Propagation Resistance	~5.0 N/mm	(ISO 34)
Service Temperature	-40 °C to +70 °C	
Resistance to Weathering	10	(ISO / DIS 19862)

Joint Design

The joint width must be designed to suit the joint movement required and the movement capability of the sealant. The joint width shall be ≥ 10 mm and ≤ 50 mm. A width to depth ratio of 2:1 must be maintained (for exceptions, see table below).

Standard joint widths for joints between concrete elements:

Joint distance [m]	Min. joint width [mm]	Min. joint depth [mm]
2	10	10
4	15	10
6	20	10
8	30	15
10	35	17

All joints must be correctly designed and dimensioned in accordance with the relevant standards, before their construction. The basis for calculation of the necessary joint widths are the type of structure and its dimensions, the technical values of the adjacent building materials and the joint sealing material, as well as the specific exposure of the building and the joints. For larger joints please contact Sika Technical Service.

APPLICATION INFORMATION

Consumption	Joint length [m] per 600 ml Sausage	Joint width [mm]	Joint depth [mm]
	6	10	10
	4	15	10
	3	20	10
	2	25	12
	1.3	30	15
Sag Flow	0 mm (20 mm profile, 50 °C)	(ISO 7390)	
Ambient Air Temperature	+5 °C to +40 °C		
Substrate Temperature	+5 °C to +40 °C, min. 3 °C above dew point temperature		
Backing Material	Use closed cell, polyethylene foam backing rods.		
Curing rate	~3 mm/24 hours (23 °C / 50% r.h.)	(CQP 049-2)	
Skin Time	~70 minutes (23 °C / 50% r.h.)	(CQP 019-1)	
Tooling Time	~65 minutes (23 °C / 50% r.h.)	(CQP 019-2)	

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.

LIMITATIONS

- SikaHyflex®-250 Facade can be overpainted with most conventional facade coating paint systems. However, paints must first be tested to ensure compatibility by carrying out preliminary trials (e.g. according to ISO technical paper: Paintability and Paint Compatibility of Sealants). The best over-painting results are obtained when the sealant is allowed to fully cure first. Note: non-flexible paint systems may impair the elasticity of the sealant and lead to cracking of the paint film.
- Colour variations may occur due to exposure to chemicals, high temperatures and/or UV-radiation (especially with the colour shade white). However, a change in colour is purely of aesthetic nature and does not adversely influence the technical performance or durability of the product.
- Before using SikaHyflex®-250 Facade on natural stone, advice to test the compatibility before use. please refer to Sika Technical Service for advice.
- Do not use SikaHyflex®-250 Facade on bituminous substrates, natural rubber, EPDM rubber or on any building materials which might bleed oils, plasticizers or solvents that could attack the sealant.
- Do not use SikaHyflex®-250 Facade to seal joints in and around swimming pools.
- Do not use SikaHyflex®-250 Facade for joints under water pressure or for permanent water immersion.
- Do not expose uncured SikaHyflex®-250 Facade to alcohol containing products as this may interfere with the curing reaction.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet (MSDS) containing physical, ecological, toxicological and other safety-related data.

VOC DATA

The maximum content of SikaHyflex®-250 Facade is 10 g/L VOC for ready to use product.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

The substrate must be clean, dry, sound and homogeneous, free from oils, grease, dust and loose or friable particles. SikaHyflex®-250 Facade adheres without primers and/or activators. However, for optimum adhesion and critical, high performance applications, such as on multi-story buildings, highly stressed joints, extreme weather exposure or water immersion, the following priming and/or pre-treatment procedures shall be followed:

Non-porous substrates

Aluminium, anodised aluminium, stainless steel, galvanised steel or glazed tiles have to be cleaned and pre-treated using Sika® Aktivator-100 wiped on and off with a clean towel. Before sealing, allow a flash-off time of > 15 minutes (< 6 hours). Other metals, such as copper, brass and titanium-zinc, also have to be cleaned and pre-treated using Sika® Aktivator-100 wiped on and off with a clean towel. After the necessary flash-off time, use a brush to apply Sika® Primer-3 N and allow a further flash-off time of > 30 minutes (< 8 hours) before sealing the joints. PVC has to be cleaned and pre-treated using Sika® Primer-215 applied with a brush. Before sealing, allow a flash-off time of > 30 minutes (< 8 hours). As quality of substrate vary, compatibility test before application is recommended.

Porous substrates

Concrete, aerated concrete and cement based renders, mortars and bricks shall be primed using Sika® Primer-3 N applied with a brush. Before sealing, allow a flash-off time of > 30 minutes (< 8 hours).

For more detailed advice and instructions please contact Sika Technical Services.

Note: Primers are adhesion promoters. They are neither a substitute for the correct cleaning of a surface, nor do they improve the strength of the surface significantly.

APPLICATION METHOD / TOOLS

SikaHyflex®-250 Facade is supplied ready to use. After the necessary substrate preparation, insert a suitable backing rod to the required depth and apply any primer if necessary. Insert a sausage into the sealant gun and extrude SikaHyflex®-250 Facade into the joint making sure that it comes into full contact with the sides of the joint and avoids any air entrapment. SikaHyflex®-250 Facade must be firmly tooled against the joint sides to ensure adequate adhesion. It is recommended to use masking tape where exact joint lines or neat lines are required. Remove the tape within the skin time. Use a compatible tooling agent to smooth the joint surfaces. Do not use tooling products containing solvents.

CLEANING OF TOOLS

Clean all tools and application equipment immediately after use with Sika® Remover-208. Once cured, residual material can only be removed mechanically.

LEGAL NOTES

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 war-

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