

## PRODUCT DATA SHEET

# Sikasil® SG-20

HIGH-STRENGTH, 1-COMPONENT SILICONE STRUCTURAL GLAZING ADHESIVE, CE MARKED

## TYPICAL PRODUCT DATA

Chemical base		1-component silicone
Color (CQP001-1)		Black, grey S6, white S3
Cure mechanism		Moisture-curing
Cure type		Neutral
Density (uncured)		1.4 kg/l
Non-sag properties (CQP061-4 / ISO 7390)		Very good
Application temperature	ambient	5 – 40 °C
Skin time (CQP019-1)		25 minutes <sup>A</sup>
Tack free time (CQP019-3)		180 minutes <sup>A</sup>
Curing speed (CQP049-1)		(see diagram)
Shore A hardness (CQP023-1 / ISO 7619-1)		39
Tensile strength (CQP036-1 / ISO 527)		2.2 MPa
100 % modulus (CQP036-1 / ISO 527)		0.9 MPa
Elongation at break (CQP036-1 / ISO 527)		450 %
Tear propagation resistance (CQP045-1 / ISO 34)		7 N/mm
Thermal resistance (CQP 513-1)	4 hours	200 °C
	1 hour	220 °C
Service temperature		-40 – 150 °C
Shelf life (CQP016-1)		9 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C / 50 % r. h.<sup>B</sup>) storage below 25 °C

## DESCRIPTION

Sikasil® SG-20 is a 1-component, neutral-curing structural glazing silicone adhesive, which combines mechanical strength with high elongation. It is complying with EOTA ETAG 002 and provided with the CE-mark. It adheres excellent to a wide range of substrates.

## PRODUCT BENEFITS

- Meets requirements of EOTA ETAG 002 (carries ETA), EN 13022, ASTM C1184, ASTM C920 for Type S, Grade NS, Class 25 (movement capability ± 25 %)
- Structural silicone adhesive according to EOTA ETAG 002, DoP 61161179, certified by Factory Production Control Body 0757, certificate 0757-CPD-596-10-001 R1e, and provided with the CE-mark
- Design tensile strength for dynamic loads:  $\sigma_{des} = 0.17$  MPa (ETA)
- Fire rated class B1 (DIN 4102-1)
- Outstanding UV and weathering resistance
- Bonds excellent to glass, metals, coated metals, plastics and wood
- SNJF-VEC recognized (product code: 2436)

## AREAS OF APPLICATION

Sikasil® SG-20 is ideal for structural glazing and other bonding applications where high mechanical performance with silicone is required.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

## CURE MECHANISM

Sikasil® SG-20 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 (see diagram 1).

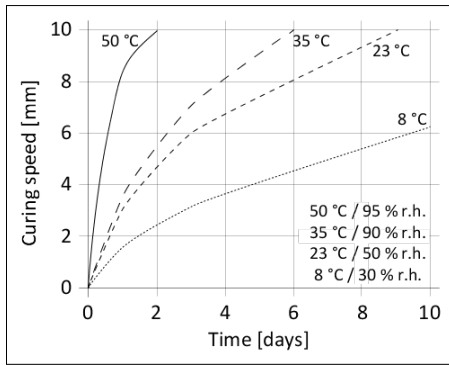


Diagram 1: Curing speed Sikasil® SG-20

## 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.

### Application

The optimum temperature for substrate and sealant is between 15 °C and 25 °C. Sikasil® SG-20 can be processed with hand, pneumatic or electric driven piston guns as well as pump equipment. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Joints must be properly dimensioned. Basis for calculation of the necessary joint dimensions are the technical values of the adhesive and the adjacent building materials, the exposure of the building elements, their construction and size as well as external loads. Joints deeper than 15 mm must be avoided.

### Tooling and finishing

Tooling and finishing must be carried out within the skin time of the sealant or adhesive. When tooling freshly applied Sikasil® SG-20 press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents to be used.

## Removal

Uncured Sikasil® SG-20 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.

## Overpainting

Sikasil® SG-20 cannot be overpainted.

## Application Limits

Recommended solutions from Sika for structural glazing and window bonding are usually compatible to each other. These solutions consist of products such as Sikasil® SG, IG, WS and WT series.

For specific information regarding compatibility between various Sikasil® products and other Sika products contact the Technical Department of Sika Industry.

To exclude materials influencing Sikasil® SG-20, all materials such as gaskets, tapes, setting blocks, sealants, etc., in direct and indirect contact have to be approved by Sika in advance.

Where two or more different reactive sealants are used, allow the first to cure completely before applying the next.

The above mentioned Sika process materials may only be used in structural glazing or window bonding applications after a detailed examination and written approval of the corresponding project details by Sika Industry.

## 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 Structural Silicone Glazing with Sikasil® SG Adhesives

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml

## 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

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