

## PRODUCT DATA SHEET

# Sikasil® IG-25 HM Plus

2-component silicone insulating glass secondary sealant for air- / gas-filled IG units

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	Sikasil® IG-25 HM Plus (A)	Sikasil® IG-25 HM Plus (B)
<b>Chemical base</b>	2-component silicone	
<b>Color (CQP001-1)</b>	White, light grey	Black, dark grey
	mixed	Black, grey S6
<b>Cure mechanism</b>	Polycondensation	
<b>Cure type</b>	Neutral	
<b>Density</b>	1.4 kg/l	1.1 kg/l
	mixed	1.4 kg/l
<b>Mixing ratio</b>	A:B by volume	10:1
	A:B by weight	13:1
<b>Viscosity (CQP029-6)</b>	900 Pa·s	500 Pa·s
<b>Consistency</b>	Paste	
<b>Application temperature</b>	ambient	5 – 40 °C (40 - 105 °F)
<b>Snap time (CQP554-1)</b>	60 minutes <sup>A</sup>	
<b>Tack free time (CQP019-3)</b>	120 minutes <sup>A</sup>	
<b>Shore A hardness (CQP023-1 / ISO 7619-1)</b>	60	
<b>Tensile strength (CQP036-1 / ISO 527)</b>	2.5 MPa (363 psi)	
<b>100 % modulus (CQP036-1 / ISO 527)</b>	2.1 MPa (305 psi)	
<b>Elongation at break (CQP036-1 / ISO 527)</b>	150 %	
<b>Tear propagation resistance (CQP045-1 / ISO 34)</b>	3 N/mm (17 pli)	
<b>Service temperature (CQP513-1)</b>	-40 – 150 °C (-40 – 302 °F)	
<b>Shelf life (CQP016-1)</b>	15 months <sup>B</sup>	12 months <sup>B</sup>

CQP = Corporate Quality Procedure

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

Sikasil® IG-25 HM Plus is a 2-component, neutral-curing insulating glass secondary sealant with structural capabilities. With its high modulus at short elongation it is especially designed for air- and noble gas-filled IG-units. It is complying with EOTA ETAG 002 and provided with the CE-mark.

**PRODUCT BENEFITS**

- Meets requirements of EN 1279-4, EOTA ETAG 002 (carries ETA) and EN 15434 as well as ASTM C 1184 and ASTM C 1369
- Structural silicone adhesive according to EOTA ETAG 002, DoP 70119976, certified by Factory Production Control Body 0757, certificate No. 0757-CPD-596-12-002e, and provided with the CE-mark
- Design tensile strength for dynamic loads:  $\sigma_{des} = 0.19$  MPa (ETA)
- CEKAL and SNJF VI-VEC recognized (product code: 2968)
- Excellent UV and weathering resistance

**AREAS OF APPLICATION**

Sikasil® IG-25 HM Plus is ideal as a secondary edge seal for air and noble gas-filled insulating glass in structural glazing applications. 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.

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Sikasil® IG-25 HM Plus  
Version 02.01 (08 - 2019), en\_US  
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## CURE MECHANISM

Sikasil® IG-25 HM Plus starts to cure immediately after mixing the two components.

The speed of the reaction depends mainly on the temperature, i.e. the higher the temperature the faster the curing process. Heating above 50 °C could lead to bubble formation and is therefore not allowed.

The mixer open time, i. e. the time the material can remain in the mixer without flushing or extrusion of product, is significantly shorter than the snap time indicated above.

## 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.

Before processing Sikasil® IG-25 HM Plus both components have to be mixed homogeneously and air-bubble-free in the correct ratio as indicated with an accuracy of ± 10 %. Most commercially available metering and mixing equipment are suitable. For advice on selecting and setting up a suitable pump system, contact the System Engineering Department of Sika Industry.

Consider that the B-component is moisture-sensitive and must therefore only be exposed briefly to air.

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.

### Tooling and finishing

Tooling and finishing must be carried out within the snap time of the adhesive.

When tooling freshly applied Sikasil® IG-25 HM Plus, press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents must be used.

## Removal

Uncured Sikasil® IG-25 HM Plus may be removed from tools and equipment with Sika® Remover-208 or an-other suitable solvent. Once cured, the material can only be removed mechanically.

Re-usable, usually metallic, static mixer can be cleaned with Sika® Mixer Cleaner.

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® IG-25 HM Plus cannot be overpainted.

## Application Limits

Recommended solution 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® IG-25 HM Plus, all materials such as gaskets, 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 one.

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  
Insulating Glass Edge Sealing with Sikasil® IG Sealants & Adhesives

## PACKAGING INFORMATION

Sikasil® IG-25 HM Plus (A)

Drum	260 kg
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Sikasil® IG-25 HM Plus (B)

Pail	20 kg
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## 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.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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## Sika Corporation

30800 Stephenson Highway  
Madison Heights, MI 48071  
U.S.A.  
Telephone: +1 248-577-0020  
Email: [tsmh@us.sika.com](mailto:tsmh@us.sika.com)  
[www.sikausa.com](http://www.sikausa.com)

