# Sikasil® SG-20

## HIGH STRENGTH STRUCTURAL SILICONE ADHESIVE

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

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Chemical base</strong></td>
<td>1-component silicone</td>
</tr>
<tr>
<td><strong>Color (CQP001-1)</strong></td>
<td>Black</td>
</tr>
<tr>
<td><strong>Cure mechanism</strong></td>
<td>Moisture-curing</td>
</tr>
<tr>
<td><strong>Cure type</strong></td>
<td>Neutral</td>
</tr>
<tr>
<td><strong>Density</strong></td>
<td>1.4 kg/l</td>
</tr>
<tr>
<td><strong>Non-sag properties (CQP061-4 / ISO 7390)</strong></td>
<td>1 mm</td>
</tr>
<tr>
<td><strong>Application temperature</strong></td>
<td>ambient 5 – 40 °C (41 – 104 °F)</td>
</tr>
<tr>
<td><strong>Skin time (CQP019-1)</strong></td>
<td>15 minutes Â³</td>
</tr>
<tr>
<td><strong>Tack free time (CQP019-3)</strong></td>
<td>180 minutes Â³</td>
</tr>
<tr>
<td><strong>Curing speed (CQP049-1)</strong></td>
<td>see diagram 1</td>
</tr>
<tr>
<td><strong>Shore A hardness (CQP023-1 / ISO 7619-1)</strong></td>
<td>39</td>
</tr>
<tr>
<td><strong>Tensile strength (CQP036-1 / ISO 527)</strong></td>
<td>2.2 MPa (320 psi)</td>
</tr>
<tr>
<td><strong>100 % modulus (CQP036-1 / ISO 527)</strong></td>
<td>0.9 MPa (130 psi)</td>
</tr>
<tr>
<td><strong>Elongation at break (CQP036-1 / ISO 527)</strong></td>
<td>450 %</td>
</tr>
<tr>
<td><strong>Tear propagation resistance (CQP045-1 / ISO 34)</strong></td>
<td>7 N/mm (40 pli)</td>
</tr>
<tr>
<td><strong>Thermal resistance (CQP 513-1)</strong></td>
<td>200 °C (392 °F)</td>
</tr>
<tr>
<td><strong>Service temperature</strong></td>
<td>220 °C (428 °F)</td>
</tr>
<tr>
<td><strong>Shelf life (CQP016-1)</strong></td>
<td>9 months Â³ Â²</td>
</tr>
</tbody>
</table>

CQP = Corporate Quality Procedure

### DESCRIPTION

Sikasil® SG-20 is a neutral-curing silicone adhesive which combines mechanical strength with high elongation. It adheres excellently to a wide range of substrates widely used in structural glazing applications.

### PRODUCT BENEFITS

- Meets requirements of EOTA ETAG 002 (carries ETA), EN 13022, ASTM C 1184
- Fire rated (EN 11925-2 / DIN 4102-B1)
- Outstanding UV and weathering resistance
- Bonds excellent to glass, metals, coated metals, plastics and wood
- Structural silicone adhesive according to ETAG 002, DoP 61161179, certified by Factory Production Control Body 0757, certificate 0757-CPD-596-10-001 R1e, and provided with the CE-mark

### AREAS OF APPLICATION

Sikasil® SG-20 can be used for structural sealant glazing, bonding of solar modules and other high-demanding industrial 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.
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).

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 sealtant is between 15 °C (59 °F) and 25 °C (77 °F). 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.

Tooling and finishing must be carried out within the skin time of the sealant or adhesive. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using hand wipes or a suitable industrial hand cleaner and water. Do not use solvents on skin!

Overpainting
Sikasil® SG-20 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, WT as well as SikaHyflex®-300 and -600 series.

For specific information regarding compatibility between various Sikasil® and SikaHyflex® 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 Guidelines Structural Silicone Glazing with Sikasil® Adhesives

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.

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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.