

## PRODUCT DATA SHEET

# Sikasil® SG-18

1-COMPONENT SILICONE STRUCTURAL GLAZING ADHESIVE, COMPLYING WITH ASTM STANDARDS

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

Chemical base		1-component silicone
Color (CQP001-1)		Black, grey S6
Cure mechanism		Moisture-curing
Cure type		Neutral
Density (uncured)		1.5 kg/l
Non-sag properties (CQP061-4 / ISO 7390)		2 mm
Application temperature	ambient	5 – 40 °C
Skin time (CQP019-1)		30 minutes <sup>A</sup>
Tack free time (CQP019-3)		140 minutes <sup>A</sup>
Curing speed (CQP049-1)		(see diagram)
Shore A hardness (CQP023-1 / ISO 7619-1)		44
Tensile strength (CQP036-1 / ISO 527)		1.9 MPa
100 % modulus (CQP036-1 / ISO 527)		1.1 MPa
Elongation at break (CQP036-1 / ISO 527)		270 %
Tear propagation resistance (CQP045-1 / ISO 34)		3 N/mm
Service temperature		-40 – 150 °C
Shelf life (CQP016-1)	cartridge / pail	12 months <sup>B</sup>
	unipack	15 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-18 is a 1-component, neutral-curing, high-modulus structural silicone adhesive. This product is designed to be used in structural glazing applications.

**PRODUCT BENEFITS**

- Meets requirements of ASTM C 1184 and ASTM C920 for Type S, Grade NS, Class 12.5 (movement capability ± 12.5 %)
- Design tensile strength for dynamic loads:  $\sigma_{des} = 0.14$  MPa or 20 psi (ASTM)
- Outstanding UV and weathering resistance
- Bonds well to glass, metals and coated metals

**AREAS OF APPLICATION**

Sikasil® SG-18 is ideal for structural glazing and other high-demanding industrial applications.

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

## CURE MECHANISM

Sikasil® SG-18 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).

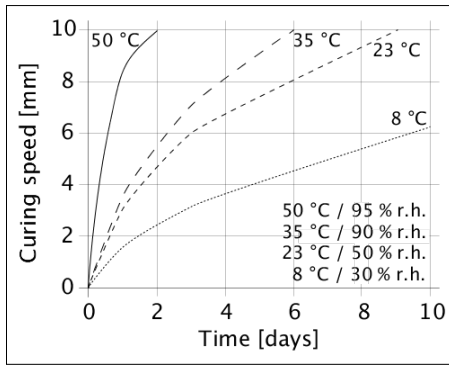


Diagram 1: Curing speed Sikasil® SG-18

## 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-18 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-18 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® SG-18 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. 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-18 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® SG-18, 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 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  
Structural Silicone Glazing with Sikasil® SG Adhesives

## PACKAGING INFORMATION

Cartridge	300 ml
Unipack	600 ml
Pail	26 kg

## 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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