

Sikasil® SG-10**Fast- and Neutral-Cure, One-Component Silicone Assembly Sealant****Technical Data**

	Pigmented	Translucent
Chemical Base	1-C Silicone	1-C Silicone
Colour	White, Black	Clear
Cure Mechanism	Moisture	Moisture
Cure Type	Oxime	Oxime
Density (uncured)	1.4 Kg/L approx	1 Kg/L approx
VOC	21 g/L	21 g/L
Non-sag Properties - Vertical @ 49°C (ASTM C-639)	Non-Sag	Non-Sag
Slump ASTM D-2202	Nil	Nil
Skin Time (MNA Method)	6 minutes	8 minutes
Tack-Free Time ² (ASTM D-679)	12 minutes	18 minutes
Extrusion Rate ASTM C-1183 modified	300 g/min 3mm orifice @ 90 psi	500 g/min 3mm orifice @ 90 psi
Curing Speed (MNA Method)	3 mm - 12 hours	3 mm - 12 hours
Shrinkage	Nil	Nil
Shore A Hardness (ASTM C-661)	35 +/- 5	12 +/- 5
Tensile Strength (ASTM D-412)	300 psi/2.07 MPa	190 psi/1.31 MPa
Elongation at Break (ASTM D-412)	400%	600%
Bond Durability ASTM C-793 (glass/aluminium/concrete)	+/- 25%	+/- 25%
Movement Capability (ASTM C-719)	+/- 25%	+/- 25%
Application Temperature ¹ product only substrate and air	-32°C to 40°C 5°C to 40°C	-32°C to 40°C 5°C to 40°C
Service Temperature	-62 to 176°C	-62 to 176°C
Shelf Life (Storage below 32°C)	12 months	12 months
¹ See "Application Limits" section for details; ² 25°C and 50% Relative Humidity		

Description

Sikasil® SG-10 is a fast-curing, one-component, non-sag, elastomeric, neutral-cure silicone sealant. Meets the requirements of ASTM C-920, Type S, Grade NS, Class 25, Use NT, T, M, G, A, O; TT-S-00230C, Type II, Class A; TT-S-001543A, Class A; CAN/CGSB-19.13-M87, AAMA 802.3 Type I and II, AAMA 803.3, Type I, AAMA 805.2, AAMA 808.3 and California Air Resources Board 2003 requirements for Volatile Organic Compound content. Sikasil® SG-10 is especially suitable for window fabrication and has passed the Florida Hurricane Glazing Code when used in designed systems.

Product Benefits

- Excellent weather-resistance and extremely long service-life;
- Faster production capability in assembly processes;
- High early green-strength and fast-cure;
- Excellent flexibility for dynamic joint movement;
- Bonds to most substrates without priming;
- Compatible with IG sealants;
- Enhanced adhesion to PVC/vinyl, glass, aluminium, metals, powder-coated surfaces, tiles, fibreglass, plastic, ceramic and wood;
- AAMA-Certified component for standard and impact glazing when used in designed systems.



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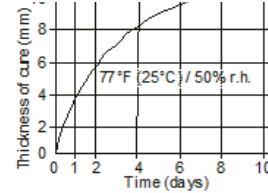
Sikasil® SG-10

Areas of Application

- Window and door fabrication;
- Back-bedding and cap, toe and heel beads;
- Perimeter sealing of windows, doors and skylights;
- Conventional- and impact-glazing;
- Kitchen and bathroom counter-tops/solid surfaces and sanitary seals;
- Marine cabins;
- Trucks, trailers, automobiles, RVs;
- Component assembly processes.

Typical Substrates: Vinyl, glass, aluminium, powder-coated aluminium, metals, tile, fibreglass, plastic, ceramic and wood.

Cure Mechanism Sikasil® SG-10 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly.



Sikasil® SG-10 Curing Speed

Chemical Resistance

Sikasil® SG-10 is **resistant** to UV radiation, fresh-water, sea-water and proprietary aqueous cleaning agents; **temporarily resistant** to fuels, mineral oils, vegetable and animal fats and oils; and **not resistant** to organic acids, concentrated mineral acids, caustic solutions and solvents. The above information is offered for general guidance only. Please consult Sika Canada Inc.'s Technical Services for advice on specific applications.

Application Limits

- Not intended for structural glazing;
- Do not allow the uncured material to come in contact with solvents or curing polyurethanes during cure;
- Lower temperature and humidity will extend Tack-Free and Cure Rates;
- Do not apply to damp or wet surfaces;
- Do not apply to surfaces that will be painted;
- May be applied below freezing temperatures if substrates are completely dry, frost free and clean. Contact Sika Canada Technical Services for more information;
- Not recommended for absorptive surfaces such as natural stone, particularly limestone or marble where staining may occur. Test before use;
- Do not apply to substrates that bleed oil, plasticizers or solvent;
- This material is not intended for long-term immersion in water;
- Test sensitive substrates, such as mirror backings, for compatibility before use;
- Brass and copper may discolour; test prior to application;
- Allow treated wood to age for at least six months before application of the sealant.

Surface Preparation

All surfaces must be clean, sound, dry, frost-free and free of any oils, grease or incompatible sealers, paints or coatings that may interfere with adhesion. Project-specific substrates must be submitted for testing before being considered for use in high-demand applications.

Porous substrates should be cleaned by mechanical methods to expose a sound surface, free of contamination.

Non-porous substrates should be cleaned using isopropyl alcohol, xylene or approved, clean, pure, undiluted industrial-grade solvent and the two-cloth cleaning method; allow the solvent to evaporate before installing the sealant. Strictly follow the solvent manufacturer's instructions on safe handling.

Priming

Sikasil® SG-10 is designed to obtain adhesion without the use of a primer; however, certain substrates may require priming. Consequently, prior testing of the sealant with and without priming is required to determine which method is appropriate. For assistance and advice regarding primer selection, contact Sika Technical Services.

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Application This product is suitable for bulk-dispensing straight from drums or pails by means of a pneumatic or hydraulic pump system. For recommendation on selecting and setting up a suitable pump system, please contact our Technical Services.
 Make sure joint design is correct. Use masking tape, if desired, to protect adjacent areas from contamination. Do not break cartridge seal until just before use. Surfaces should be dried before the sealant is applied. Apply sealant to dry, clean surfaces using an air-operated or hand-operated cartridge gun. Normally, sealant skins in 8 minutes, dries to the touch in 1 hour and bonds in 24 hours.
Expansion Joints: Apply the sealant using a professional caulking gun or dispensing equipment. Do not open product container until preparation work has been completed. Apply sealant using consistent, positive pressure to force sealant into the joint.
Adhesive Joints: Apply using professional caulking gun, dispensing equipment or trowel. Apply sufficient quantity of adhesive to one or both substrates to provide designed contact-area. Surfaces may be adjusted up to one hour after application without loss of adhesive strength.

Tooling and Finishing In the case of expansion joints, tool to a concave shape and ensure adequate pressure to achieve maximum adhesion to the joint walls. In all cases, dry tooling is recommended. Tool joint, if necessary, in one continuous stroke immediately after sealant is applied (within 5 minutes) and before a skin begins to form. **NOTE: DO NOT** use soap, water, oil or tooling agent! Remove masking tape immediately after tooling is completed.

Removal Clean all tools and equipment and remove excess sealant from substrates, while the material is uncured, using a commercial solvent, such as isopropyl alcohol or xylene. Strictly follow the manufacturer's instructions for use and warnings. Once hardened, product can only be removed mechanically. Wash soiled hands and skin thoroughly in hot soapy water or use Sika® Hand Cleaner towels. Do not use solvents on skin!

Over-Painting Sikasil® SG-10 cannot be over-painted.

Further Information Copy of the following publication is available upon request: *Material Safety Data Sheet*.

Packaging 24 x 295 ml Cartridges per Case; 17L Pails; and 197 Litre Drums

Value Bases All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.

Health and Safety Information For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. Product Data Sheets and Material Safety Data Sheets are available on our website at: www.sika.ca or via your local Technical Sales Representative.

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