Sikasil® SG-20
High strength structural silicone adhesive

Description
Sikasil® SG-20 is a neutral-curing silicone adhesive which combines mechanical strength with high elongation. It adheres excellent to a wide range of substrates. Sikasil® SG-20 is manufactured in accordance with ISO 9001 quality assurance system and the responsible care program.

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

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 professional experienced users only. Tests with original substrates and conditions have to be performed to ensure adhesion and material compatibility.
Cure Mechanism
Sikasil® SG-20 cures by reaction with atmospheric moisture. The reaction thus starts at the surface and proceeds to the core of the joint. The curing speed depends on the relative humidity and the temperature (see diagram 1 below). Heating above 50°C to speed-up the vulcanization is not advisable as it may lead to bubble formation. At low temperatures the water content of the air is lower and the curing process proceeds more slowly.

Application Limits
All Sikasil® WS, FS, SG, IG, WT and other engineering silicone sealants and adhesives are compatible with each other. Sikasil® SG, IG and WT sealants and adhesives are compatible with SikaGlaze® IG sealants. All other sealants have to be approved by Sika before using them in combination with Sikasil® SG-20. Where two or more different reactive sealants are used, allow the first to cure completely before applying the next. Sikasil® SG, IG and WT sealants and adhesives may only be used in structural glazing or window bonding applications by experienced professionals and after a detailed examination and written approval of the corresponding project details by the Technical Service Department of Sika Industry.

The compatibility of gaskets, backer rods, setting blocks and other accessory materials with Sikasil® SG-20 must be tested in advance.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

Method of Application
Surface preparation
Surfaces must be clean, dry and free from oil, grease and dust. Advice on specific applications and surface pretreatment methods is available from the Technical Service Department of Sika Industry.

Application
After suitable joint and substrate preparation, Sikasil® SG-20 is gunned into place. Joints must be properly dimensioned as changes are no longer possible after construction. 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 should be avoided.

For more information please contact the Technical Service Department of Sika Industry.

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 should 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 should be washed immediately using Sika® Handclean Towel or a suitable industrial hand cleaner and water. Do not use solvents!

Overpainting
Sikasil® SG-20 is an elastic adhesive and cannot be overpainted.

Further Information
Copies of the following publications are available on request:
- Material Safety Data Sheet
- Different “Application Guidelines”
- Calculation Value Sheet

Packaging Information
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Value Bases
All technical data stated in this Product Data Sheet 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 should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

Legal Notes
The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika’s current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika’s recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product’s suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.