

**PRODUCT DATA SHEET**

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STRUCTURAL SEALANT GLAZED CURTAIN WALLS

# Sikasil® IG-25 HM Plus<sup>US</sup>

## HIGH-MODULUS SEALANT FOR AIR- AND GAS-FILLED INSULATING GLASS

Technical Data	Component A		Component B	
	Chemical Base	2C Silicone		
Colour (CQP <sup>1</sup> 001-1)	White and Light Grey		Black and Dark Grey	
Colour mixed	Black and Grey S6			
Cure Mechanism	Polycondensation			
Cure Type	Neutral			
Density (CQP 006-04)	1.42 kg/L approx		1.12 kg/L approx	
	Mixed 1.40 kg/L approx			
Mixing Ratio	A:B by volume		10:1	
	A:B by weight		13:1	
Viscosity (CQP 029-6)	900 Pa's approx		550 Pa's approx	
Consistency	Paste			
Application Temperature	5 °C to 40 °C			
Snap Time <sup>2</sup> (CQP 554-1)	40 min approx			
Tack-Free Time <sup>2</sup> (CQP 019-1)	180 min approx			
Shore A Hardness (CQP 023-1/ISO 868/ASTM C-661)	60 approx			
Tensile Strength (CQP 036-1/ISO 37/ASTM D-412)	2.5 N/mm <sup>2</sup> approx			
Elongation at Break (CQP 036-1/ISO 37/ASTM D-412)	150 % approx			
Tear Propagation Resistance (CQP 045-1/ISO 34)	5.0 N/mm approx			
100 % Modulus (CQP 036-1/ISO 37/ASTM D-412)	2.1 N/mm <sup>2</sup> approx			
12.5 % Modulus (CQP 036-1/ISO 37/ASTM D-412)	0.5 N/mm <sup>2</sup> approx			
Thermal Resistance (CQP 513-1)	4 hours		200 °C approx	
	1 hour		220 °C approx	
Movement Accommodation Capability ASTM C-719	+/- 12.5 %			
Water Vapour Impermeability	18g H <sub>2</sub> O/m <sup>2</sup> 24 h 2 mm			
Service Temperature	-40 °C to 150 °C approx			
Shelf Life (Storage below 25 °C) (CQP 016-1)	15 months		12 months	
<sup>1</sup> CQP = Corporate Quality Procedure; <sup>2</sup> 23 °C and 50 % Relative Humidity.				

**Description** Sikasil® IG-25 HM Plus<sup>US</sup> is a two-part, neutral-cure, insulating glass sealant with structural capabilities. Sikasil® IG-25 HM Plus<sup>US</sup> is manufactured in accordance with ISO 9001 Quality Assurance System.

- Products Benefits**
- High-modulus, low movement sealant for optimum gas retention;
  - Suitable and approved for IG units in structural glazing façades;
  - Suitable for use in hot and cold climates;
  - Low IG gas loss rates for long service life;
  - Meets requirements of EN 1279 (including part 3), EOTA ETAG 002, EN 15434 and ASTM 2190;
  - CEKAL and SNJF VI-VEC recognized;
  - CE-marked.

<b>Areas of Application</b>	Sikasil® IG-25 HM Plus <sup>US</sup> is ideal as a secondary edge seal for air- and gas-filled insulating glass in structural glazing applications. This product is suitable for professional experienced users only. Tests with actual substrates and conditions must be performed to ensure adhesion and material compatibility.
<b>Cure Mechanism</b>	Sikasil® IG-25 HM Plus <sup>US</sup> 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 is not advisable as it may lead to bubble formation. 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. For more information, contact the Technical Services Department of Sika Industry.
<b>Application Limits</b>	Most Sikasil® WS, FS, SG, IG, WT, AS and other engineering silicone sealants manufactured by Sika are compatible with each other and with SikaGlaze® IG sealants. For specific information regarding compatibility between various Sikasil® and SikaGlaze® products, please contact the Technical Services Department of Sika Industry. All other sealants have to be approved by Sika before using them in combination with Sikasil® IG-25 HM Plus <sup>US</sup> . 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 Services Department of Sika Industry. The compatibility of gaskets, backer rods, setting blocks and other accessory materials with Sikasil® IG-25 HM Plus <sup>US</sup> must be tested in advance. The above information is offered for general guidance only. Advice on specific applications will be given upon request.
<b>Surface Preparation</b>	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 Services Department of Sika Industry.
<b>Mixing</b>	This is a two-component product that requires thorough mixing for proper performance; mix both components in the correct ratio (to an accuracy of +/- 10 %) to obtain a homogeneous and air-bubble-free mixture. Most commercially available metering and mixing equipment are suitable. Please contact Technical Services for specific advice. <b>Note:</b> While Component A is stable in air, Component B is moisture sensitive and must be exposed to air only very briefly.
<b>Application</b>	Joints must be properly dimensioned. The technical values of the adhesive and adjacent building materials, the exposure of the building elements, their construction and size, as well as external loads must form the basis for calculating the necessary joint dimensions. For more information, contact Technical Services.
<b>Tooling and Finishing</b>	Tooling and finishing must be carried out within the Snap Time of the adhesive.
<b>Removal</b>	Uncured sealant may be removed from tools and equipment with Sika® Remover-208 or other suitable solvent. The static mixer of the metering and mixing equipment can be cleaned with Sikasil® Mixer Cleaner or other suitable cleaner. Hands and exposed skin should be washed immediately using Sika® Hand Cleaner towels or other suitable industrial hand cleaner and water. Do not use solvents on skin!
<b>Over-Painting</b>	Sikasil® IG-25 HM Plus <sup>US</sup> is an elastic adhesive and cannot be over-painted.
<b>Further Information</b>	Copy of the following publication is available upon request: <ul style="list-style-type: none"> <li>▪ <i>Safety Data Sheet</i></li> </ul>
<b>Packaging</b>	<b>Component A:</b> 260 kg Drums; <b>Component B:</b> 20 kg Pails
<b>Value Bases</b>	All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.
<b>Health and Safety Information</b>	For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.

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FOR INDUSTRIAL USE ONLY

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, within their shelflife. 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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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