Sikasil® SG-18
STRUCTURAL SILICONE ADHESIVE

Technical Data

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical Base</td>
<td>1-C silicone</td>
</tr>
<tr>
<td>Colour (CQP 001-1)</td>
<td>Black and Grey S6</td>
</tr>
<tr>
<td>Cure Mechanism</td>
<td>Moisture-curing</td>
</tr>
<tr>
<td>Cure Type</td>
<td>Neutral</td>
</tr>
<tr>
<td>Density (uncured)</td>
<td>1.5 kg/L</td>
</tr>
<tr>
<td>Non-Sag Properties (CQP 061-4/ISO 7390)</td>
<td>2 mm</td>
</tr>
<tr>
<td>Application Temperature</td>
<td>Ambient</td>
</tr>
<tr>
<td>Skin Time (CQP 019-1)</td>
<td>30 minutes</td>
</tr>
<tr>
<td>Tack Free Time (CQP 019-3)</td>
<td>90 minutes</td>
</tr>
<tr>
<td>Curing Speed (CQP 049-1)</td>
<td>See Diagram 1</td>
</tr>
<tr>
<td>Shore A Hardness (CQP 023-1/ISO 868)</td>
<td>44</td>
</tr>
<tr>
<td>Tensile Strength (CQP 036-1/ISO 37)</td>
<td>2 MPa</td>
</tr>
<tr>
<td>100% Modulus (CQP 036-1/ISO 37)</td>
<td>1.1 MPa</td>
</tr>
<tr>
<td>Elongation at Break (CQP 036-1/ISO 37)</td>
<td>300 %</td>
</tr>
<tr>
<td>Tear Propagation Resistance (CQP 045-1/ISO 34)</td>
<td>4 N/mm</td>
</tr>
<tr>
<td>Thermal Resistance (CQP 513-1)</td>
<td>4 hours 1 hour</td>
</tr>
<tr>
<td>Service Temperature</td>
<td>-40 °C to 150 °C</td>
</tr>
<tr>
<td>Shelf Life (CQP 016-1) Cartridge/pail Unipack</td>
<td>12 months¹</td>
</tr>
<tr>
<td></td>
<td>15 months²</td>
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</tbody>
</table>

CQP = Corporate Quality Procedure; ¹ 23 °C and 50 % Relative Humidity ²Storage below 25 °C

Description
Sikasil® SG-18 is a neutral-curing silicone adhesive with excellent adhesion to a wide range of substrates.

Product Benefits
- Meets requirements of ASTM C 1184, and ASTM C 920 class 12.5;
- Outstanding UV and weathering resistance;
- Bonds well to glass, metals and coated metals.

Areas of Application
Sikasil® SG-18 can be used as a structural glazing adhesive and for other bonding applications where superior resistance to UV radiation, high temperatures and weathering is required. This product is suitable for professional experienced users only. Tests with original substrates and conditions must 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).
METHOD OF APPLICATION
Surfaces must be clean, dry and free from oil, grease 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 elements, their construction and size as well as external loads. Joints deeper than 15 mm should 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 into the joint flanks to achieve proper wetting of the bond surface. No tooling agents to be used.

Removal
Uncured Sikasil® SG-18 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® Hand Cleaner towels or suitable industrial hand cleaner and water. Do not use solvents on skin!

Over-painting
Sikasil® SG-18 cannot be over-painted.

Application Limits
Recommended solution from Sika for structural gazing and window bonding are usually compatible to each other. These solutions consist of products such as Sikasil® SG, IG, WT as well as Sikaflex®-300 and -600 series. For specific information regarding compatibility between various Sikasil® and Sikaflex® 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 sealant are used, allow the first to cure completely before applying the next. The above mentionned 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 application is available on request from the Technical Department of Sika Industry. Copies of the following publications are available upon request:
- Safety Data Sheets
- General Guidelines “Structural Silicone Glazing with Sikasil® Adhesive”

Packaging information
Cartridge of 300 mL; Unipack of 600 mL; Pail of 26 kg

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 most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.

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FOR INDUSTRIAL USE ONLY

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Pointe-Claire: ISO 14001 certified EMS

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Sikasil® SG-18
CSC Master Format™ 08 44 23 (08 80 00)
STRUCTURAL SEALANT GLAZED CURTAIN WALLS

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