

PRODUCT DATA SHEET

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STRUCTURAL SEALANT GLAZED CURTAIN WALLS

Sikasil® SG-10

FAST- AND NEUTRAL-CURE, ONE-COMPONENT SILICONE ASSEMBLY SEALANT

Technical Data	Colour	Pigmented	Translucent
	Chemical Base	1-C Silicone	
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 @ 120 °F (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 g/min (ASTM C-1183 modified) 1/8" orifice @ 90 psi	300	500	
Curing Speed (MNA Method)	1/8 inch - 12 hours	1/8 inch - 12 hours	
Shrinkage	Nil	Nil	
Shore A Hardness (ASTM C-661)	35 +/- 5	12 +/- 5	
Tensile Strength psi (MPa) (ASTM D-412)	2.07 MPa	1.31 MPa	
Elongation at Break (ASTM D-412)	400 %	600%	
Bond Durability- (glass/aluminium/concrete) (ASTM C-793)	+/- 25 %	+/- 25 %	
Movement Capability (ASTM C-719)	+/- 25 %	+/- 25 %	
Application Temperature ¹ product only	-32 °C to 40 °C (-35 °F to 140 °F)	-32 °C to 40 °C (-35 °F to 140 °F)	
Service Temperature	-62.2 °C to 176 °C (-80 °F to 350 °F)	-62 °C to 176 °C (-80 °F to 350 °F)	
Shelf Life (Storage below 32 °C) Cartridge and Unipac Drum and Pail	12 months	12 months	
¹ Substrate and Air Temperature must be between 40 and 105 °F (5 °C to 40 °C). See "Application Limits" section for details; ² 77 °F (25 °C) /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.

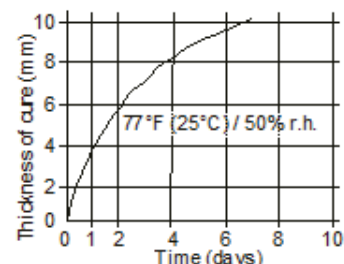
Product Benefits

- 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.

Aeras 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.



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 poly-urethanes 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.



Application	<p>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.</p> <p>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. Tool sealant to create a concave joint shape and ensure maximum adhesion. Dry tooling is recommended.</p> <p>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.</p>
Tooling and Finishing	<p>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.</p>
Removal	<p>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!</p>
Over-Painting	<p>Sikasil® SG-10 cannot be over-painted.</p>
Further Information	<p>Copy of the following publication is available upon request:</p> <ul style="list-style-type: none"> ▪ <i>Safety Data Sheet</i>
Packaging	<p>24 x 295 ml Cartridges per Case; 17L Pails; and 197 Litre Drums</p>
Value Bases	<p>All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.</p>
Health and Safety Information	<p>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.</p>

KEEP OUT OF REACH OF CHILDREN
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

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