

## PRODUCT DATA SHEET

## Sikasil® SG-20

## HIGH STRENGTH STRUCTURAL SILICONE ADHESIVE

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-component silicone
Color (CQP001-1)	Black
Cure mechanism	Moisture-curing
Cure type	Neutral
Density (uncured)	1.4 kg/l
Non-sag properties (CQP061-4 / ISO 7390)	1 mm
Application temperature	ambient 5 – 40 °C (41 – 104 °F)
Skin time (CQP019-1)	15 minutes <sup>A</sup>
Tack free time (CQP019-3)	180 minutes <sup>A</sup>
Curing speed (CQP049-1)	see diagram 1
Shore A hardness (CQP023-1 / ISO 7619-1)	39
Tensile strength (CQP036-1 / ISO 527)	2.2 MPa (320 psi)
100 % modulus (CQP036-1 / ISO 527)	0.9 MPa (130 psi)
Elongation at break (CQP036-1 / ISO 527)	450 %
Tear propagation resistance (CQP045-1 / ISO 34)	7 N/mm (40 pli)
Thermal resistance (CQP 513-1)	4 hours 200 °C (392 °F) 1 hour 220 °C (428 °F)
Service temperature	-40 – 150 °C (-40 – 302 °F)
Shelf life (CQP016-1)	9 months <sup>B</sup>

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C / 50 % r. h.<sup>B</sup>) storage below 25 °C (77 °F)

## 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 widely used in structural glazing applications.

## 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
- Structural silicone adhesive according to ETAG 002, DoP 61161179, certified by Factory Production Control Body 0757, certificate 0757-CPD-596-10-001 R1e, and provided with the CE-mark

## 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 experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available at <http://usa.sika.com/> or on request at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

## PRODUCT DATA SHEET

Sikasil® SG-20

Version 01.01 (02 - 2019), en\_US

012603130209001000

## CURE MECHANISM

Sikasil® SG-20 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).

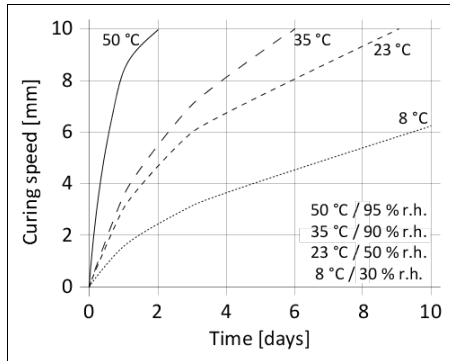


Diagram 1: Curing speed 1-C-Sikasil®

## METHOD OF APPLICATION

### Surface Preparation

Surfaces must be clean, dry and free from grease, oil 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 (59 °F) and 25 °C (77 °F).

Sikasil® SG-20 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 materials, the exposure of the building elements, their construction and size as well as external loads. Joints deeper than 15 mm (0.6 inch) must 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-20 press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents to 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 have to be washed immediately using hand wipes or a suitable industrial hand cleaner and water. Do not use solvents on skin!

## Overpainting

Sikasil® SG-20 cannot be overpainted.

## Application Limits

Recommended solution from Sika for structural glazing and window bonding are usually compatible to each other. These solutions consist of products such as Sikasil® SG, IG, WT as well as SikaHyflex®-300 and -600 series.

For specific information regarding compatibility between various Sikasil® and SikaHyflex® products contact the Technical Department of Sika Industry.

To exclude materials influencing Sikasil® SG-20, 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 sealants are used, allow the first to cure completely before applying the next.

The above mentioned 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 applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- General Guidelines Structural Silicone Glazing with Sikasil® Adhesives

## PACKAGING INFORMATION

Unipack	600 ml
---------	--------

## BASIS OF PRODUCT DATA

All technical data stated in this document 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 shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

## LIMITED PRODUCT WARRANTY

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available at <http://usa.sika.com/> or on request at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

PRODUCT DATA SHEET  
Sikasil® SG-20  
Version 01.01 (02 - 2019), en\_US  
012603130209001000

Sika Corporation  
30800 Stephenson Highway  
Madison Heights, MI 48071  
U.S.A.  
Telephone: +1 248-577-0020  
Email: [tsmh@us.sika.com](mailto:tsmh@us.sika.com)  
[www.sikausa.com](http://www.sikausa.com)

