

### Neutral, condensation-curing 2-component silicone adhesive and sealant based on alkoxy

For indoor and outdoor application

#### Characteristic:

- **Excellent weathering, ageing and UV-resistance**  
For long-lasting indoor and outdoor applications
- **High resistance to notches, tension and tearing**  
Resistant to high mechanical stresses
- **Very good adhesion on many substrates**  
Ensures a durable and secure bond
- **Non-corrosive**  
Does not cause corrosion on unprotected metal surfaces
- **High elongation stress value**  
High stability of the adhesion
- **Fast curing even in thick layers**  
Fast further processing
- **Low odour**  
Convenient processing
- **Design values available for the structural engineer**

#### Fields of application:

- Elastic bonding and sealing of various materials, e. g. glass, wood, metal and plastics
- Bonding of structural glazing units
- For adhesive bonding subject to building supervision approval
- Bonding and sealing of glass elements (e.g. partition walls, all-glass corners, glass parapets)

#### Standards and tests:

- Tested according to ETAG 002
- European Technical Assessment ETA-19/0692
- CE marked
- Tested fire behaviour in accordance with EN 13501: class E
- Certified according to SNJF-VEC



#### Important information:

Before applying this product the user has to ensure that the materials in the area of contact (solid, liquid and gaseous) are compatible with it and also amongst each other and do not damage or alter (e. g. discolour) each other. As for the materials that will be used at a later stage in the surrounding area of the product the user has to clarify beforehand that the substances of content or evaporations do not lead to an impairment or alteration (e. g. discolouration) of the product. In case of doubt the user should consult the respective manufacturer of the material.  
During curing small amounts of alcohol are released.

Ensure good ventilation during application and curing.

Technical properties:

**Single components:**

**Component A**

Colour	C01 white
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ]	~ 1,36
Shelf life at 23 °C/50 % RH [months]	12 (1)

1) from date of manufacture

**OTTOCURE S-CA 2375**

Colour	C04 black, coloured
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1, black [g/cm <sup>3</sup> ]	1,06
Density at 23 °C according to ISO 1183-1, coloured [g/cm <sup>3</sup> ]	1,32
Mixing ratio according to weight (base A : curing agent B)	12,8 : 1 (black); 10,3 : 1 (coloured)
Mixing ratio according to volume (base A : curing agent B)	10 : 1
Shelf life at 23 °C/50 % RH [months]	12 (1)

1) from date of manufacture

**Unvulcanised compound:  
with OTTOCURE S-CA 2375**

Colour	C04 black, coloured
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ]	~ 1,35
Processing temperature from/to [°C]	+ 5 / + 40
Shore-A-hardness after 4 hours	≥ 10
Shore-A-hardness after 24 hours	~ 30 - 40
Pot life at 23 °C/50 % RH [minutes]	~ 40 - 70

**Vulcanisate:**

Density at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ]	~ 1,35
Shore-A-hardness according to ISO 868	~ 50
Temperature resistance from/to [°C]	- 40 / + 150 (1)
Tensile strength according to ISO 37, type 3 [N/mm <sup>2</sup> ]	~ 2,5
Tensile expansion according to ISO 37, type 3 [%]	~ 200
Stress expansion modulus at 12,5 % according to ISO 8339 [N/mm <sup>2</sup> ]	~ 0,35
Permissible movement capability [%]	25

1) After complete curing a temperature resistance up to approx. +150°C can be reached. Constant use under high temperatures and /or high humidity (RH > 60%) may change the properties of the material or lead to an interaction with neighbouring materials.

These data are not suitable for the issue of specifications. Please contact OTTO-CHEMIE before issuing specifications.

Pretreatment:

All adherent surfaces must be clean and any contaminant such as release agents, preserving agents, grease, oil, dust, water, old adhesives or sealants and other substances which could affect adhesion, must be removed. Cleaning of non-porous substrates: Apply OTTO Cleaner T (airing time approx. 1 minute) using a clean, lint-free cotton cloth.

The adherent surfaces have to be clean, free from fat, dry and sustainable.

The demands on elastic sealings and bondings depend on the respective exterior influences. Extreme fluctuations in temperature, tensile or shear forces, repeated contact with water etc. demand high requirements of a bonding. In such cases it is advisable to apply primer in order to achieve a resilient bonding. Please consult our technical department.

**Application information:**

Maximum tolerance of mixing ratio: The mixing ratios may vary by a maximum of +/- 10 % in order to have an impact on the curing time.  
 Avoid entrapment of air during mixing. Therefore we recommend to use a mixing equipment.  
 If processing with the help of a mixing and dosing system, please consult the application technology department.  
 Please note that when using static mixing nozzles, the time until the mixer is rinsed is considerably shorter than the pot life.  
 To guarantee a constant supply of material of the feeding pumps of mixing - and dosing installations and to prevent material being pressed alongside the packaging of the following plate which leads to soiling the following plate, the pressure for this plate has to be set to:  
 Component A: 2-3 bar  
 Component B: < 1,5 bar  
 If the sealings of the mixing and dosing equipment are in direct contact with the sealant/adhesive we recommend to use EPDM-sealings (free from plasticizers). If it is the intention to use another sealing material please contact our technical department.  
 Component A does not react with air humidity and is stable under normal conditions (23 °C, 50 % RH).  
 Component B is sensitive to moisture and therefore must be protected from moisture.  
 The maximum ambient temperature of 60 °C must not be exceeded while curing.  
 In order to achieve optimal adhesion and good mechanical characteristics, the entrapment of air in the joint must be avoided.  
 Only remove dry, do not use smoothing agents.  
 Due to the many possible influences during and after application, the customer always has to carry out trials first.  
 Please observe the recommended shelf life which is printed on the packaging.  
 We recommend to store our products in unopened original packagings dry (< 60 % RH) at temperatures of +15 °C up to +25 °C. If the products are stored and / or transported at higher temperatures / air humidity for longer periods (some weeks), a diminution of durability or a change of material characteristics may arise.  
 To make sure the mixing is correct the user has to carry out accompanying quality checks during application. For the necessary tests and other general conditions to be observed, please refer to the document "Application Instructions OTTOCOLL® S 645". This is available for download on the homepage.  
 If the adhesive has to carry static and/or dynamic loads in the planned application, please consult the application technology department.

**Packaging:**

	490 ml side-by-side plastic cartridge	20 l hobcock (component A)	200 l Drum (component A)	20 l hobcock (component B)
black	S645-2375-43-C04	on request	on request	on request
<b>Packaging unit</b>	9/Box incl. 9 static mixing nozzles*	<b>1</b>	<b>1</b>	<b>1</b>
<b>Pieces per pallet</b>	<b>540</b>	<b>16</b>	<b>2</b>	<b>16</b>

\*OTTO Static mixing nozzle MFQX 10-24T  
 Other packagings and colours on request

**Safety precautions:**

Please observe the material safety data sheet.  
 After curing the product is completely odourless.

**Warranty information:**

All information in this publication is based on our current technical knowledge and experience. However, since conditions and methods of use and application of our products are beyond our control, we suggest that you test the product before final use. Information given in this technical data sheet and explanations of OTTO-CHEMIE in connection with this technical data sheet (e.g. service description, reference to DIN regulations etc.) is not to be seen as a warranty. Warranties require a separate written declaration of OTTO-CHEMIE to prove their validity. The characteristics stated in this data sheet define the characteristics of the article broadly and conclusively. Suggestions of use are not to be taken as confirmation of the appropriateness for the recommended intended use. We reserve the right to alter the product, adjusting it according to technical progress and new developments. We are at your disposal both for inquiries as well as specific application problems. If a governmental approval or clearance is necessary for the application of our products, the user is responsible for the obtainment of such. Our recommendations do not excuse the user from the obligation to take into consideration the possibility of infringement of third parties' rights and - if necessary - resolving it. For the rest our general terms and

conditions apply, in particular regarding a possible liability for defects. You can find our general terms and conditions on our homepage: <http://www.otto-chemie.de/en/terms-and-conditions>

