

PRODUCT DATA SHEET

Sikasil® AS-61

(formerly Sikasil® AS-60 IN)

Industrial assembly sealant & adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	1-Component Silicone
Color (CQP001-1)	White, Black
Cure mechanism	Moisture curing
Cure type	Oxime
Density (uncured)	1.39 kg/l approx.
Non-sag properties (CQP061-4 / ISO 7390)	Good
Application temperature	5 - 40°C
Skin time (CQP019-1)	9 min. approx. ²
Curing speed (CQP049-1)	(see diagram)
Shore A hardness (CQP023-1 / ISO 48-4)	45 approx.
Tensile strength (CQP036-1 / ISO 527)	2.3 MPa approx.
Elongation at break (CQP036-1 / ISO 527)	400 % approx.
Service temperature	-50 - 200°C
Shelf life	(storage below 25°C) 12 months

1) CQP = Corporate Quality Procedure 2) 23°C/50% R.H.

DESCRIPTION

Sikasil® AS-61 is a one-part, non-corrosive neutral-curing silicone adhesive especially designed for industrial assembly processes. It combines mechanical strength with high elongation. It adheres excellent to a wide range of substrates.

PRODUCT BENEFITS

- Good mechanical properties
- Excellent adhesion to a wide variety of substrates
- Very good adhesion and mechanical performance under harsh environment conditions
- Superior heat resistance
- Remains flexible over a wide temperature range
- Good long-term durability
- UL® certified: UL 94 , UL 746 A, UL 746B, (File No : E504802)

AREAS OF APPLICATION

Sikasil® AS-61 can be used for industrial bonding and sealing applications. It is especially designed for frame and junction box bonding in the photovoltaic industry, where specific tests have proven its excellent suitability.

The product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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CURE MECHANISM

Sikasil® AS-61 cures by reaction with atmospheric moisture. The reaction thus starts at the surface and proceeds to the core of the joint. The skin forming time and curing speed respectively depends on the relative humidity and the temperature (see diagram 1 below).

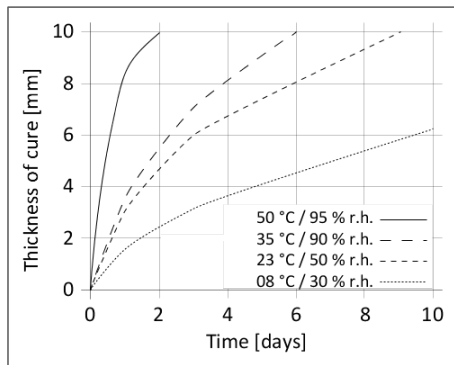


Diagram 1 : Curing Speed of Sikasil® AS-61

METHOD OF APPLICATION

Surface preparation

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 Department of Sika Industry.

Application

Sikasil® AS-61 can be processed between 5 °C and 40 °C (climate and product) but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and sealant is between 15 °C and 25 °C. Sikasil® AS-61 can be processed with manual, 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. Joints deeper than 15 mm 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® AS-61 press the adhesive to the joint flanks to get a good wetting of the bonding surface. No tooling agents have to be used.

Removal

Uncured Sikasil® AS-61 may be removed from tools and equipment with Sika® Remover-208 or an-other suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin should be washed immediately using Sika® Cleaner-350H or a suitable industrial hand cleaner and water. Do not use solvents on skin!

Application limits

For specific information regarding compatibility between various Sikasil® products contact the Technical Department of Sika Industry. Sikasil® AS adhesives and sealants are compatible with Sika® Spacer Tape HD. Prior use all materials in contact with Sikasil® AS-61 need to be approved by Sika. Where two or more different reactive process materials are used, allow the first to cure completely before applying the next. Sikasil® engineering sealants and adhesives may only be used in industrial assembly applications by experienced professionals and after a detailed examination. A written approval of the corresponding project details by the Technical Department of Sika Industry is recommended. The suitability of Sikasil® AS-61 for a specific application including compatibility and adhesion must be tested in advance on original substrates and under actual conditions.

FURTHER INFORMATION

Copies of the following publications are available on request:

- Material Safety Data Sheets
- General Guidelines Bonding and Sealing with Sikasil® AS adhesive

PACKAGING INFORMATION

Unipack	600 ml
Pail	25 Kg
Drum	250 Kg

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.

DISCLAIMER

The information, and in particular, the recommendations relating to the application and enduse 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 in accordance with Sika's recommendations. 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 written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. 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.

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