



The premium 2-component silicone for structural glazing

2-component silicone adhesive and sealant based on alkoxy neutral condensation, cross-linking

For indoor and outdoor application

S 660

Characteristics

- ▶ Neutral, condensation curing 2-component silicone adhesive and sealant based on alkoxy
- ▶ Extremely UV-resistant, crack and notch resistant
- ▶ Non-corrosive
- ▶ Excellent adhesion on glass and wood
- ▶ High expansion-tension value guarantees high stability bonding
- ▶ Cures at room temperature
- ▶ Minimal odour nuisance
- ▶ Reduced cycle times - due to the fast curing bonded parts can be further processed extremely soon
- ▶ High mechanical capability
- ▶ Low shrinkage during vulcanization (approx. 4 %)
- ▶ Very good temperature resistance
- ▶ Excellent resistance to water and moisture



Fields of application

- ▶ Bonding of timber-glass-composite elements
- ▶ Elastic bonding and sealing of various materials, e. g. glass, wood, metal and plastics

Technical properties

Single components:

	Component A	OTTOCOLL® S 660 Comp.B (OTTOCURE S-CA 2010)
Colour	white	black
Viscosity at 23 °C	pasty	pasty, stable
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,31	~ 1,17
Shelf life at 23 °C/50 % RH [months]	8	8
Mixing ratio according to weight (base A : - curing agent B)		11,0 : 1
Mixing ratio according to volume (base A : - curing agent B)		10 : 1

Unvulcanised compound:

with OTTOCOLL® S 660 Comp.B (OTTOCURE S-CA 2010)

Colour	black
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,3
Processing temperature from/to [°C]	+ 5 / + 30
Shore-A-hardness after 4 hours	~ 25 - 30
Shore-A-hardness after 24 hours	~ 38 - 42
Shore-A-hardness after 3 days	~ 45

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SEALING & BONDING

Pot life at 23 °C/50 % RH [minutes]	~ 15 - 35
Shrinkage of volume according to ISO 10563 [%]	~ 4

Vulcanisate:

Density at + 23 °C [g/cm³]	~ 1,3
Shore-A-hardness according to ISO 868	~ 45
Temperature resistance from/to [°C]	- 40 / + 150
Tensile strength according to ISO 37, type 3 [N/mm²]	~ 2,9
Tensile expansion according to ISO 37, type 3 [%]	~ 350
Stress expansion modulus at 100 % according to ISO 37, type 3 [N/mm²]	~ 1,0

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

Pretreatment

The adhesive surfaces must be cleaned and any contamination such as release agents, preservatives, grease, oil, dust, water, old adhesives/sealants and other substances impairing adhesion must be removed. Cleaning of non-porous substrates: Clean with OTTO Cleaner T (no flash-off time required) and a clean, lint-free cloth. Cleaning porous substrates: Clean surfaces mechanically, e.g. with a steel brush or a grinding disc, to remove loose particles. The adherent surfaces have to be clean, free from fat, dry and sustainable.

Primer table

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 according to the recommendations of our technical department (e. g. +/OTTO Primer 1216) in order to achieve a resilient bonding.

Glass	+
Wood, untreated	+ 1
Glass fibre reinforced plastics	1101

1) Upon high exposure to water please contact our Technical Department.

- + = good adherence without primer
- = not suitable
- T = Test/pilot test advised

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.

The constructional details of the bonding have to be checked with our technical service department, in particular the compatibility with contact materials, such as insulating glass edge bonds, sealants etc.

During curing small amounts of alcohol are released. Ensure good ventilation during application and curing. Processing with air compressed gun P TS 460 XH

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.

Processing of 2-component adhesives and sealants out of side-by-side cartridges:

First of all remove the lids of both component's chambers. Place cartridge into the pistol. Squeeze out material, until material comes out of both chambers. Wipe off material and attach the static mixing nozzle with help of the union nut. Check homogeneity of the mixture.

For seals in the mixing and dosing system that are in direct contact with the adhesive/sealant, we recommend using (plasticiser-free) EPDM seals or even more resistant FFKM seals. If other sealing materials are used, please consult our Application Technology department.

Avoid entrapment of air during mixing. Therefore we recommend to use a mixing equipment.

The maximum ambient temperature of 60 °C must not be exceeded while curing.

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.

In order to achieve optimal adhesion and good mechanical characteristics, the entrapment of air in the joint must be avoided.

Processing/smoothing: The adhesive/sealant has to be smoothed within pot life in order to ensure close contact with joint edges/substrates. OTTO Smoothing Agent shall not be used.

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. The according necessary tests have to be gathered from the document "Accompanying Quality Checks for the processing of 2-component Silicones", which is available from our technical department.

Packaging

Packagings and colours on request

Safety precautions

Please observe the material safety data sheet.

After curing, the product is odourless.

Disposal

Information about disposal: Please refer to the material safety data sheet.

Warranty information

The above information and our technical application advice, whether verbal, in writing or by means of tests, are provided to the best of our knowledge, but are non-binding, including with regard to any third-party property rights. The information in this publication does not exempt the processor from carrying out their own tests on our products with regard to their suitability for the intended processes and purposes. The application, use and processing of our products and the products manufactured on the basis of our technical application advice are beyond our control and are therefore the sole responsibility of the processor. If the application for which our products are used is subject to an official authorisation requirement, the user is responsible for obtaining these authorisations. We reserve the right to adapt the product to technical progress and new developments. For the rest, we refer to our General Terms and Conditions, in particular with regard to any liability for defects. You can find our GTC at www.otto-chemie.de.