

OTTOSEAL®**S 25****Technical Datasheet****1-component silicone sealant based on acetate**

For indoor and outdoor application

Characteristic:

- **High adhesive power**
Suitable also as special adhesive
- **High temperature resistance up to + 300 °C**
Suitable for special thermal requirements

Fields of application:

- High temperature resistant and still elastic bonding and sealing, e. g. for cast member heating boilers, exhaust boxes, tile stoves etc.
- Also suitable for applications in automotive areas for engines and gearboxes

Standards and tests:

- UL 94 Flame Classification HB, RTI 105 °C, File No. E 176319
- Suitable for applications according to IVD instruction sheet no. 31+35 (IVD = German industry association sealants)
- French VOC-emission class A+

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.

While curing small amounts of acetic acid are released.

Ensure good ventilation during application and curing.

The required vulcanization time prolongs with increasing thickness of the silicone layer. One-component silicones must not be used for full-surface bonding applications unless special constructional prerequisites are met. If one-component silicones are to be used for thickness layers of more than 15 mm please contact our technical department beforehand.

Avoid contact with materials which contain bitumen and which release solvents, e. g. butyl, EPDM, neoprene, insulating- and bituminous paint.

Technical properties:

Skin-forming time at 23 °C/50 % RH [minutes]	~ 8
Curing in 24 hours at 23 °C/50 % RH [mm]	~ 2
Processing temperature from/to [°C]	+ 5 / + 40
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,2
Shore-A-hardness according to ISO 868	~ 30
Stress expansion modulus at 100 % according to ISO 37, S3A [N/mm²]	~ 0,9
Tensile expansion according to ISO 37, S3A [%]	~ 300
Tensile strength according to ISO 37, S3A [N/mm²]	~ 2,5
Temperature resistance from/to [°C]	- 40 / + 300
Shelf life at 23 °C/50 % RH for cartridge/foil bag [months]	18

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

Pretreatment:

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

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, should be removed. Cleaning of non-porous substrates: Apply OTTO Cleaner T (airing time approx. 1 minute) using a clean, lint-free cotton cloth. Cleaning porous substrates: Clean surfaces with steel-wire brush e. g. or a grinding disk to remove loose particles.

Application information:

Vulcanisation of the sealant must be completely finished, before exposing it to temperatures above +50 °C.

This sealant is not a fire-proof silicone. For this purpose we recommend OTTOSEAL® S 94.

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.

Packaging:

	310 ml cartridge
red-brown	S25-04-C65
Packaging unit	20
Pieces per pallet	1200

Safety precautions:

Please observe the material safety data sheet.

After curing the product is completely odourless.

Disposal:

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

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>