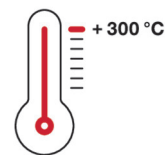


OTTOSEAL® S 25 SPECIAL

The high temperature silicone



1-component silicone sealant based on acetate

For indoor and outdoor application

S 25

Characteristics

- ▶ High temperature resistance up to + 300 °C

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

- ▶ Meets the requirements for fire behavior according to EN 13501: Class E
- ▶ 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)



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, type 3 [N/mm²] | ~ 0,9 |
| Tensile expansion according to ISO 37, type 3 [%] | ~ 300 |
| Tensile strength according to ISO 37, type 3 [N/mm²] | ~ 2,5 |
| Temperature resistance from/to [°C] | - 40 / + 300 |
| Shelf life at 23 °C/50 % RH for cartridge/foil bag [months] | 18 |
| Shelf life at 23 °C/50 % RH for pail/drum [months] | 12 |

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.

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.

Important information

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SEALING & BONDING

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 are not suitable for full-area bonding, unless there are specific structural conditions that require such full-area application. 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.

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

Glossy colors

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

Due to typographical reasons the colours shown below may differ from the original colours of the products.

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.