

# Novasil® S 804

The high temperature-resistant flowable 1-component alkoxy silicone

S 804

## Characteristics

- › Neutral curing 1-component silicone filling compound based on alkoxy
- › Self-levelling
- › Especially matched viscosity
- › Excellent temperature resistance
- › High adhesion strength
- › Very good steam and humidity resistance



## Fields of application

### Domestic appliances industry:

- › Bonding and sealing of household appliances
- › Bonding and sealing of irons

### Heating, ventilation and plant construction:

- › Potting/bonding and sealing of structural components like heating rods
- › Bonding and sealing of structural components exposed to high temperatures like heat exchangers

### General Industry:

- › Sealing of engine components (gear box etc.)

## Standards and tests

- › According to UL FLAME CLASSIFICATION 94 HB

## Technical properties

Skin-forming time at 23 °C/50 % RH [minutes]	~ 10
Curing in 24 hours at 23 °C/50 % RH [mm]	~ 2
Processing temperature from/to [°C]	+ 5 / + 40
Viscosity Brookfield [mPas]	~ 40000
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,1
Shore-A-hardness according to ISO 868	~ 20
Stress expansion modulus at 100 % according to ISO 37, type 3 [N/mm²]	~ 0,4
Tensile expansion according to ISO 37, type 3 [%]	~ 310
Tensile strength according to ISO 37, type 3 [N/mm²]	~ 1,3
Temperature resistance from/to [°C]	- 40 / + 250
Specific inductive capacity according to DIN VDE 0303 T 4 test frequency 40 kHz	~ 3,5
Volume resistance $\rho$ according to DIN IEC 93 [ $\Omega \cdot \text{cm}$ ]	~ $5,3 \cdot 10^{13}$
Dielectric strength ED according to DIN EN 60243 [kV/mm]	~ 19
Shelf life at 23 °C/50 % RH for cartridge/foil bag [months]	12 <sup>1</sup>
Shelf life at 23 °C/50 % RH for pail/drum [months]	6 <sup>1</sup>

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SEALING & BONDING

1) from production

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.

The adherent surfaces have to be clean, free from dust and grease as well as 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.

## 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.

Paints, lacquers, plastics and any other coatings must be compatible to the adhesive/sealant.

During curing small amounts of alcohol 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.


Silicones are usually serviceable over a wide temperature range for long periods of time. The interaction of factors such as the frequency of temperature changes, the heating rate, the air intake, etc. causes a complex time- and temperature-dependent thermal behaviour. Therefore, the behaviour at both the lower and upper end of the temperature spectrum (specified in the technical data) should be tested close to the application in order to check the individual suitability in the application.

## Application information

Due to the many possible influences during and after application, the customer always has to carry out trials first.

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

	<b>310 ml cartridge</b>
 <b>red brown</b>	S804-04-C65
<b>Pieces per packaging unit</b>	<b>20</b>
<b>Pieces per pallet</b>	<b>1200</b>

Other units on request

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](http://www.otto-chemie.de).