

**Sikasil® WS-605 S**

## High performance weatherproofing sealant

## Typical Product Data

Chemical base	1-C silicone
Color (CQP <sup>1</sup> 001-1)	Various colors available <sup>2</sup>
Cure mechanism	Moisture-curing
Cure type	Neutral
Density (uncured) (CQP 006-4)	transparent / aluminum color 1.03 kg/l all other colors 1.49 kg/l
Non-sag properties (CQP 061-4 / ISO 7390)	< 2 mm
Application temperature	5 - 40 °C (40 - 105 °F)
Skin time <sup>3</sup> (CQP 019-2)	25 min
Tack-free time <sup>3</sup> (CQP 019-1)	120 min
Curing speed (CQP 049-1)	See diagram 1
Shore A-hardness (CQP 023-1 / ISO 868)	20
Tensile strength (CQP 036-1 / ISO 37)	1.0 N/mm <sup>2</sup>
Elongation at break (CQP 036-1 / ISO 37)	800 %
Tear propagation resistance (CQP 045-1 / ISO 34)	4.0 N/mm
100 % modulus (CQP 036-1 / ISO 37)	0.3 N/mm <sup>2</sup>
Movement accommodation capability (ASTM C 719)	± 50 %
Thermal resistance (CQP 513-1)	180 °C (355 °F)
Short term	4 hours 200 °C (390 °F) 1 hour 220 °C (430 °F)
Service temperature	-40 - 150 °C (-40 - 300 °F)
Shelf life (storage below 25 °C) (CQP 016-1)	12 months

<sup>1</sup> CQP = Corporate Quality Procedure<sup>2</sup> See "Specification Guide" for more details<sup>3</sup> 23 °C (73 °F) / 50 % r.h.**Description**

Sikasil® WS-605 S is a durable, neutral-curing silicone sealant with a high movement capability and excellent adhesion to a wide range of substrates.

**Product Benefits**

- Meets requirements of ISO 11600 25 LM F & G, ASTM C 920 (class 50), ASTM C 1248, TT-S00230C, TT-S001543A, DIN 18540, DIN 18545 (group E)
- Outstanding UV and weathering resistance
- Does not stain areas adjacent to the joint
- Adheres well to glass, metals, coated / painted metals, plastics and wood
- Provided with CE-mark according to EN 15651-1:2012, F EXT-INT CC 25LM, (F EXT-INT 25LM for transparent), EN 15651-2:2012, G CC 25LM, certified by Control Body 1119

**Areas of Application**

Sikasil® WS-605 S can be used for weatherproofing and sealing applications where durability under severe conditions is required. It is particularly suited as a weather seal for structural glazing, curtain walling and windows. This product is suitable for professional experienced users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



## Cure Mechanism

Sikasil® WS-605 S cures by reaction with atmospheric moisture. The reaction thus starts at the surface and proceeds to the core of the joint. The curing speed depends on the relative humidity and the temperature (see diagram 1 below). Heating above 50 °C to speed-up the vulcanization is not advisable as it may lead to bubble formation. At low temperatures the water content of the air is lower and the curing reaction proceeds more slowly.

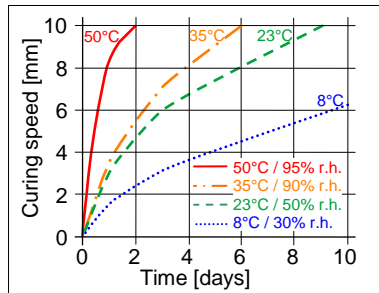


Diagram 1: Curing speed 1C-Sikasil®

## Application Limits

Most Sikasil® WS, FS, SG, IG, WT, AS and other engineering silicone sealants manufactured by Sika are compatible with each other and with SikaGlaze® IG sealants. For specific information regarding compatibility between various Sikasil® and SikaGlaze® products please contact the Technical Department of Sika Industry. All other sealants have to be approved by Sika before using them in combination with Sikasil® WS-605 S. Where two or more different reactive sealants are used, allow the first to cure completely before applying the next.

Do not use Sikasil® WS-605 S on pre-stressed polyacrylate and polycarbonate elements as it may cause environmental stress cracking (crazing).

The compatibility of gaskets, backer rods and other accessory materials with Sikasil® WS-605 S must be tested in advance. Joints deeper than 15 mm have to be avoided.

The above information is offered for general guidance only. Advice on specific applications will be given on request.

## 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

After suitable joint and substrate preparation, Sikasil® WS-605 S is gunned into place. Joints must be properly dimensioned as changes are no longer possible after construction. For optimum performance the joint width needs to be designed according to the movement capability of the sealant based on the actual expected movement. The minimum joint depth is 6 mm and a width / depth ratio of 2:1 must be respected. For backfilling it is recommended to use closed cell, sealant compatible foam backer rods e.g. high resilience polyethylene foam rod. If joints are too shallow for backing material to be employed, we recommend using a polyethylene tape. This acts as a release film (bond breaker), allowing the joint to move and the silicone to stretch freely.

For more information please contact the Technical Department of Sika Industry.

### Tooling and finishing

Tooling and finishing must be carried out within the skin time of the adhesive.

When tooling freshly applied Sikasil® WS-605 S press the adhesive to the joint flanks to get a good wet ability of the bonding surface.

### Removal

Uncured Sikasil® WS-605 S may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin should be washed immediately using Sika® Handclean towels or a suitable industrial hand cleaner and water. Do not use solvents!

### Overpainting

Sikasil® WS-605 S cannot be over-painted.

## Further Information

Copies of the following publications are available on request:

- Safety Data Sheet

## Packaging Information

Cartridge	300 ml
Unipack	600 ml
Pail trans / other	18 / 26 kg
Drum trans / other	195 / 280 kg

## Value Bases

All technical data stated in this Product Data Sheet 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.

## Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use 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.

Further information available at:

[www.sika.ch](http://www.sika.ch)  
[www.sika.com](http://www.sika.com)

Sika Schweiz AG  
Business Unit Industry  
Tüffenwies 16  
CH-8048 Zurich  
Switzerland  
Tel. +41 58 436 40 40  
Fax +41 58 436 45 30

