**DESCRIPTION**
OLIVÉ SG-71 is a neutral-curing Structural Silicone Adhesive, one-part with high modulus and high mechanical properties.
It has a high speed curing time in contact with atmospheric humidity. Its unique properties give it an extraordinary adhesion power, extremely high mechanical strength, being stable to aging and with a high resistance to U.V. radiation and the atmospheric agents.

**MAIN FEATURES**
- Neutral cure sealant. Odourless and non corrosive.
- Ultra fast cure
- Solvent free
- Extraordinary adhesion power to glass, aluminium, steel
- High ultimate tensile strength makes it ideally suited for structural bonding applications
- Extremely high mechanical strength
- Resistant to UV radiation and to ozone
- Great thermal stability: -55°C a +150°C
- Suitable for all types of climates and resistant to strong winds
- Resistant to chemical agents
- Unalterable against aging

**CERTIFICATIONS**
OLIVÉ SG-71 meets the European standards for Structural Glazing systems applications, according EOTA (European Organisation for Technical Assessment).

EN 13022-2
EOTA - ETAG 002

**PACKAGING**
OLIVÉ SG-71 supplied in following packages:
- Drums 220 Kg.
  Ø inside: 570 mm.
- Pails 25 Kg.
  Ø inside: 280 mm.
- Sausages 600 ml.
  Box of 20 u. (pallets of 36 boxes)
- Cartridges 310 ml.
  Box of 4 u. (pallets 56 boxes)
* European pallets 120x80 cm.

**COLOURS**
Black
Gray and White on request
ENGLISH TEXT:

ENVIRONMENTAL REGULATIONS

- VOC-emission (French Regulation francesa): Class A+.
- Conforms to LEED® IEQ-4.1
  (Indoor Environmental Quality) Adhesives and sealants.

APPLICATIONS

OLIVÉ SG-71 is developed specifically for its application in facades of Structural Glazing (V.E.C.).

The particular mechanical properties of OLIVÉ SG-71 are suitable for responding to the technical and safety requests imposed in the architecture and engineering of facades for bonding glass and metal structures (4-sided and 2-sided systems, vertical or horizontal).

OLIVÉ SG-71 can also be used to adhere stiffening elements to building panels and for other high demanding industrial adhesive applications.

OLIVÉ SG-SYSTEM

S. G. 4-sided

S. G. 2-sided (v)

GLASS

ALUMINIUM PROFILE

SPACER ADHESIVE TAPE

OLIVÉ E-BAND SG | THERMALBOND

STRUCTURAL SILICONE

OLIVÉ IG-40

INSULATING GLASS SILICONE

OLIVÉ 400 or OLIVÉ C-40

BACKER ROD

OLIVÉ E-BAND CORDÓN-PE

SILICONE WEATHERSEAL

OLIVÉ 400 or OLIVÉ C-40

ALUMINIUM PROFILE

SPACER ADHESIVE TAPE

OLIVÉ E-BAND SG | THERMALBOND

STRUCTURAL SILICONE

OLIVÉ SG-71

GLASS

OLIVÉ 400 or OLIVÉ C-40

BACKER ROD

OLIVÉ E-BAND CORDÓN-PE

SILICONE WEATHERSEAL

GLASS

SPACER ADHESIVE TAPE

OLIVÉ E-BAND SG | THERMALBOND

STRUCTURAL SILICONE

OLIVÉ SG-71

ALUMINIUM PROFILE
TYPICAL PROPERTIES

General technical properties of OLIVÉ SG-71 before cure are the following:

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Basis</td>
<td>Neutral Structural Silicone</td>
</tr>
<tr>
<td>Aspect</td>
<td>Thixotropic paste</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.26 g./cm³</td>
</tr>
<tr>
<td>Non volatile material</td>
<td>100 %</td>
</tr>
<tr>
<td>Application temperature</td>
<td>+5 ºC to +40 ºC</td>
</tr>
<tr>
<td>Skin time</td>
<td>7 - 12 min. (at 23ºC; 50% R.H.)</td>
</tr>
<tr>
<td>Curing rate</td>
<td>24 h. 3.0 mm. 48 h. 5.6 mm. 7 days 8.8 mm.</td>
</tr>
<tr>
<td>Resistance to flow/sag</td>
<td>ISO 7390 0 mm.</td>
</tr>
</tbody>
</table>

The properties of OLIVÉ SG-71 after cure are:

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shore A hardness</td>
<td>ISO 868 35</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>H-Piece testing</td>
</tr>
<tr>
<td>Elongation 12,5%</td>
<td>ISO 8339 0.24 MPa</td>
</tr>
<tr>
<td>Elongation 50%</td>
<td>ISO 8339 0.50 MPa</td>
</tr>
<tr>
<td>Elongation 100%</td>
<td>ISO 8339 0.75 MPa</td>
</tr>
<tr>
<td>Ultimate tensile strength</td>
<td>ISO 8339 1.05 MPa</td>
</tr>
<tr>
<td>Ultimate elongation</td>
<td>ISO 8339 &gt; 200%</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>2 mm. thickness</td>
</tr>
<tr>
<td>E-Modulus 100%</td>
<td>ISO 37 0.75 MPa</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>ISO 37 3.30 MPa</td>
</tr>
<tr>
<td>Elongation at break</td>
<td>ISO 37 &gt; 450%</td>
</tr>
</tbody>
</table>

Environmental influences (EN 13022-2 and ETAG 002):

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesion/Cohesion</td>
<td>ISO 11431 1.09 MPa</td>
</tr>
<tr>
<td>Failure</td>
<td>ISO 11431 Cohesive (pass)</td>
</tr>
<tr>
<td>Corrosion test</td>
<td>ISO 9227 Pass</td>
</tr>
<tr>
<td>Sulfur Dioxide</td>
<td>ISO 3231 Pass</td>
</tr>
<tr>
<td>Service temperature</td>
<td>-55 ºC to +150 ºC</td>
</tr>
<tr>
<td>Aging resistance</td>
<td>Excellent (U.V., ozone, etc.)</td>
</tr>
<tr>
<td>Chemical resistance</td>
<td>Excellent</td>
</tr>
</tbody>
</table>

These values may vary depending on environmental factors such as temperature, moisture, and type of substrates.
STORAGE
OLIVÉ SG-71 should be stored in a dry and cool conditions (between 5ºC and 25ºC), in its unopened container.
Shelf life: minimum 12 months.
Caution: avoid damaging the containers. The blows would hinder the correct functioning of the application equipment.

S.G. PROJECT PROCESS
OLIVÉ SG-71 Structural Silicone should be considered that any project with Structural Glazing systems requires previous phases that guarantee the suitability of the system and its components:

1º PROJECT IDENTIFICATION AND TECHNICAL STUDY
- DETAILED INFORMATION
- JOINTS DESIGN
- DIMENSIONS CALCULATIONS
- COMPONENTS SELECTION
- SUPPORTS SAMPLES

2º LABORATORY TESTS
- ADHESION TESTS
- POTENTIAL PRIMER DETERMINATION
- COMPATIBILITY CHECKING
- SUITABILITY OF THE SUPPORTS CHECKING
- VALIDATION TECHNICAL REPORT

SUPPORTS

<table>
<thead>
<tr>
<th>METAL PROFILES</th>
<th>GLASS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Acceptable</strong>: Aluminium, Steel, Stainless steel</td>
<td>Float</td>
</tr>
<tr>
<td><strong>Unacceptable</strong>: Ferrous (included galvanized and/or painted)</td>
<td>Coated glass</td>
</tr>
<tr>
<td>Anodised aluminum is the ideal support for Structural Glazing modules</td>
<td>Tempered</td>
</tr>
<tr>
<td></td>
<td>Laminated</td>
</tr>
<tr>
<td></td>
<td>Curved</td>
</tr>
<tr>
<td></td>
<td>Insulating (IGU)</td>
</tr>
</tbody>
</table>
**JOINT DESIGN**

The design of the joint where OLIVÉ SG-71 Structural Silicone will be applied must be determined project by project.

The joint dimensions between the glass and the metal support that comprises the contact area with the Structural Silicone must be calculated taking into account the factors such as:

- Dimensions of the glass unit
- Wind loads
- Form and deformation coefficients

As a rule the minimum thickness should not be less than 6 mm. and ideally in a 3:1 ratio (width:depth).

**DIRECTIONS FOR USE**

OLIVÉ SG-71 Structural Silicone should preferably be applied at the factory to ensure the ideal conditions and optimum assembly performance of the components.

Building on-site application should only be considered for 2-sided systems (vertical or horizontal) or for repairs.

Surfaces to be sealed should be clean and dry, free of dust or grease, which could cause a deficient adherence.

The application is simple, quick and safe because the product is ready to use, it does not need previous mix.

It is applied with a hand gun or pneumatic gun, in case of cartridges or sausages, and an automatic or semiautomatic sealing machines in case of drums or pails.

The application phases are:

- Cleaning and drying surfaces
- Priming (if Laboratory tests determine it)
- Spacer adhesive tape application
- Glass assembly
- Structural Silicone application
- Quality control
- Units storage

We recommend the cleaning up extrusion machines with OLIVÉ PU-CLEANER (cleaner product hydrocarbons free, re-use and not dangerous) before product polymerization. Hardened/cured material can only be mechanically removed.

It is recommended to store the modules assembled in horizontal shelves during the curing completion process of the Structural Silicone.
SAFETY
Provide good ventilation.
Avoid contact with eyes and skin. In case of eyes contact, rinse immediately with plenty of water and seek medical advice if necessary. In case of skin contact, remove mechanically and rinse immediately with plenty of water and seek medical advice if cause irritation.
Keep out of the reach of children.
They are not special necessary cautions during their transport.
For further information you must to consult Material Safety Data Sheet before handling.

COVERAGE
Calculation of LINEAR METERS made per LITER of Structural Silicone OLIVÉ SG-71:

<table>
<thead>
<tr>
<th>S.G. Joint</th>
<th>Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>Width</td>
<td>6 mm.</td>
</tr>
<tr>
<td>15 mm.</td>
<td>12 m.l.</td>
</tr>
<tr>
<td>18 mm.</td>
<td>10 m.l.</td>
</tr>
<tr>
<td>20 mm.</td>
<td>9 m.l.</td>
</tr>
<tr>
<td>25 mm.</td>
<td>7 m.l.</td>
</tr>
<tr>
<td>30 mm.</td>
<td>6 m.l.</td>
</tr>
</tbody>
</table>

QUALITY CONTROL
During the OLIVÉ SG-71 Structural Silicone application process, the adhesion controls must be carried out.

FAÇADE INSTALLATION
After the complete curing of the Structural Silicone OLIVÉ SG-71, the glazed modules can be transported on-site and can be installed.
REFERENCES

ESTAÇÃO DE BRAGA
Braga - Portugal

CONVENTION CENTRE
Cape Town - South Africa

XUNTA de GALICIA
Santiago de Compostela - Spain

WARRANTY

OLIVÉ QUÍMICA warrants that its product complies, within its shelf life, to its specification.

OLIVÉ SG-71 is guaranteed for a period of 10 years from the date of application.

This guarantee applies whenever OLIVÉ QUÍMICA has approved the application of OLIVÉ SG-71 for each project and all phases of the Structural Glazing system are rigorously complied:

- Project identification and technical study
- Laboratory tests in OLIVÉ QUÍMICA
- Quality controls during the Structural Silicone application

OLIVÉ QUÍMICA reserves the right to supply OLIVÉ SG-71 Structural Silicone if the guidelines of each project are not respected.

The information in this document, in particular recommendations regarding the application and final use of our products, are given in good faith, based on our knowledge and experience and are intended as guidelines. It is the responsibility of the user to determine if the product is suitable for the application. Due to the great variety of materials and conditions, which are beyond our knowledge and control, we recommend to ensure that the product is suitable for its application, carrying out sufficient previous trials.

If any responsibility were to be considered ours, this would be only for any damages and for the value of the merchandise supplied by us and used by the customer. It is over understood that we warrant the irreproachable quality of our products in accordance with our General Conditions of Sales and Supply.

This document replaces and supersedes all previous data sheets on the same product.