XV. Silicones

As of 01.06.2019

There are no objections to the use of silicones (organopolysiloxanes) in the manufacture of commodities in the sense of § 2, Para. 6, No. 1 of the Food and Feed Code (Lebensmittel- und Futtermittelgesetzbuch), provided they are suitable for their intended purpose and comply with the following conditions. The same applies for commodities in the sense of § 2, Para.6, No. 3 of the same act, which are dealt with in Section III (Silicone elastomers) No. 4 of this Recommendation:

I. Silicone oils

1. The following starting materials may be used:
   a) Linear or branched and/or cyclic organopolysiloxanes with methyl groups alone or with n-alkyl(C\textsubscript{2}-C\textsubscript{32}), phenyl\textsuperscript{2} and/or hydroxyl groups attached to the silicon atom, and their condensation products with polyethylene and/or polypropyleneglycol.
   b) Linear or branched organopolysiloxanes as mentioned under a) but in addition with up to max. 5 % hydrogen and/or alkoxy(C\textsubscript{2}-C\textsubscript{4}) and/or carboalkoxyalkyl (-(CH\textsubscript{2})\textsubscript{2-17})- and/or hydroxyalkyl(C\textsubscript{1}-C\textsubscript{3}) groups attached to the silicon atom.

2. Finished products may contain only the following production aids, used in manufacturing the raw polymer, in the maximum amounts given:
   a) Condensation agents:
      Residues of condensation accelerators and their conversion products:
      - Sodium hydroxide
      - Potassium hydroxide
      - Hydrochloric acid
      - Sulfuric acid
      - Phosphoric acid
      - Acetic acid
      - Conversion products of phosphonitrile chloride, max. 0,001 %
   b) Thickening agents:
      - Calcium salts of straight-chain aliphatic saturated monocarboxylic acids C\textsubscript{10}-C\textsubscript{20}
      - 12-Hydroxystearic acid, calcium salt
      - Carboxymethylcellulose
      - Pulped Starch\textsuperscript{3}
   c) Emulsifying agents, provided that the oils are used as aqueous emulsions\textsuperscript{4}, in total max. 10 %, based on the silicone content:

\textsuperscript{1} Silicone fats or pastes are silicone oils to which fillers or extenders (see Section I. No. 2 b) with a thickening effect have been added, and for which the same requirements apply.
\textsuperscript{2} There must be no cyclic polysiloxanes included, which besides a phenyl group also have a hydrogen atom or a methyl group attached to the same silicon atom.
\textsuperscript{3} Because the viscosity of natural starch is too high, it is partially broken down through dextrinisation (treatment with acids at moderate temperature, or without acid, at elevated temperature), through oxidation (with hypochlorite in alkaline medium) or with the help of enzymes.
\textsuperscript{4} Silicone emulsions are used to produce coatings and films. As a result of heat treatment (e.g. the hydrophobing of glass at 280 °C) or of strong dilution of the aqueous phase prior to use (e.g. as slip agent for corks, artificial guts (sausage casings), or as release agent for rubber stoppers and seals), as a rule, they only contain a fraction of the emulsifying agents present in the emulsion.
Alkyl(C₈-C₁₈) dimethylbenzyl ammonium chloride, max. 1.5 %, but only for coating paper
Sodium dodecyl sulfate, max. 0.5 %
Polyethyleneglycol ethers of monohydric aliphatic alcohols C₁₂-C₂₀ and of C₂-C₉ alkyl phenols
Polyethyleneglycol esters of natural fatty acids C₈-C₂₂ and vegetable oils
Semi-acetylated polyvinyl alcohol with less than 20 % acetyl groups and a K-value greater than 40

3. Preserving agents:
The following preserving agents may be added to silicone oil emulsions:
Sorbic acid, max. 0.1 %.

4. Kinematic viscosity of the silicone oils, measured according to DIN 51 562 at 20 °C, must be min. 100 mm² • s⁻¹.

II. Silicone resins

1. The following starting materials may be used:
Linear and branched organopolysiloxanes with methyl groups alone and/or n-alkyl(C₂-C₃₂)-, and/or phenyl-, and/or vinyl-, and/or hydroxyl-, and/or alkoxy(C₁-C₄)-, and/or hydrogen-, and/or carboalkoxyalkyl(−(CH₂)−C(O)−(CH₂)₀−₁₇CH₃)-, and/or hydroxyalkyl(C₁-C₃)- groups attached to the silicon atom also in combination with polycondensation products (esters) of:
  Isophthalic acid
  Terephthalic acid
  Ethandiol
  Trimethylol propane
  Glycerol
  Pentaerythrite

2. Finished products may contain only the following production aids, used in manufacturing and processing the raw polymer, in the maximum amounts given:
   a) Condensation agents:
      Residues of hydrochloric acid and its conversion products with fillers and hardeners, in total max. 0.1 %
   b) Hardeners:
      α) Zinc-di-2-ethylhexoate in total
         Di-n-octyl-tin-maleinate max. 1.5 %
      β) Conversion products⁵ of hardeners named under α), plus the following:
         Butyltitannate and/or butylpolytitanate, as necessary, with the monoethyl ether of ethanediol (ethyleneglycol) in the ratio 1:1⁶
         Aluminium acetylacetonate
         Zirconium acetylacetonate
   c) Emulsifying agents:
      In so far as the resins are used in the form of aqueous emulsions⁴, the substances listed above under 1, No. 2 c may be used, however, max. 7.0 %, based on silicone content.

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⁵ The conversion products are either incorporated into the resin or occur as oxides. Thus, a quantitative limit is not deemed necessary.
⁶ To be used at temperatures of at least 180 °C.
3. The following substances may be added to silicone resins used for coating paper:
   - Carboxymethyl cellulose
   - Pulped starch
   - Alginates
   - Casein
   - Dispersions of hard paraffin and wax
   - Dispersions based on copolymers of acrylic and methacrylic acid esters, butadiene and styrene, provided they comply with Recommendation XIV.
   - Polyvinyl alcohol (viscosity of 4 % aqueous solution at 20 °C min. 5 cP).
   - Hydroxyethyl cellulose, max. 2 % in the resin.

III. Silicone elastomers (Silicone rubber)

1. The following starting materials may be used:
   - Polymers complying with Section I, No.1 of this Recommendation
   - Organopolysiloxanes with vinyl groups attached to the silicon atom
   - Addition products of trivinyl cyclohexane and α,ω-Dihydrogenpolyhydrogen-methylidimethyl-siloxanes, max. 10 %
   - 1-Dodecene, max. 20 %
   - Polydimethyl-siloxanes and -silicones, 3-aminopropyl-group terminated, polymers with 1-isocyanato-3-isocyanatomethyl-3,5,5-trimethylcyclohexane
   - Polydimethyl-siloxanes and -silicones, 3-aminopropyl-group terminated, polymers with bis(4-isocyanatocyclohexyl)methane

2. Finished products may contain only the following production aids, used in manufacturing and processing the raw polymer, in the maximum amounts given:
   a) Residues of condensation accelerators and their neutralising agents:
      - Sodium hydroxide
      - Potassium hydroxide
      - Hydrochloric acid
      - Sulfuric acid
      - Phosphoric acid
      - Acetic acid
      - Conversion products of phosphorus nitrile chloride, max. 0.001 %
      - Sodium hydrogen carbonate, max. 0.5 %

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7 The waxes and paraffins must comply with Recommendation XXV. "Hard paraffins, microcrystalline waxes and mixtures of these with waxes, resins and plastics", Part I.
8 Recommendation XIV. "Plastics dispersions"
9 Specifical restrictions for 1-isocyanato-3-isocyanatomethyl-3,5,5-trimethylcyclohexane and 1-amino-3-aminomethyl-3,5,5-trimethylcyclohexane, laid down in the Commission Regulation (EU) No 10/2011, must be complied with.
10 Specifical restrictions for bis(4-isocyanatocyclohexyl)methane and bis(4-aminocyclohexyl)methane, laid down in the Commission Regulation (EU) No 10/2011, must be complied with.
b) Conversion products of following cross-linking agents:
- Benzoyl peroxide
- Bis-(2,4-Dichlorobenzoyl) peroxide ¹¹
- Dicumyl peroxide
- tert-Butyl-cumyl peroxide
- 2,5-Bis(tert-butylperoxy)-2,5-dimethylhexane
- Methyl-tris-cyclohexyl-aminosilane ¹²
- Methyl-tris-sec-butylaminosilane ¹²
- Methyl-tris-acetoxyisilane
- Ethyl-tris-acetoxyisilane
- Methyl-tris-butanoximosilane ²
- Di-(4-methyl-benzoyl)peroxide
- Esters of alkyl-C₁₈-silicic acid or orthosilicic acid with aliphatic monohydric alcohols C₂-C₄ and the monomethyl ether of ethanediol (methylglycol) and their condensation products ¹³, in total max. 3 %.

The following substances may be used as inhibitors for these coordination compounds:
- 1-ethinyl-cyclohexanol and 2-methylbutine-3-ol-2, in total max. 0.1 %.

c) Hardener or catalysts and their conversion products:
- Di-n-octyl-tin-dimaleinate
- Di-n-octyl-tin-dilaurate max. 1.5 %,
- Esters of titanic acid with isobutyl alcohol, n-butanol and the enolate of acetoacetic ester finished product
- Amides of aliphatic carboxylic acids, C₈-C₂₂
- Coordination compounds of platinum, max. 50 mg platinum per kg finished product ¹⁴.

The following substances may be used as inhibitors for these coordination compounds:
- 1-ethinyl-cyclohexanol and 2-methylbutine-3-ol-2, in total max. 0.1 %.

b) Conversion products of following cross-linking agents:
- Benzoyl peroxide
- Bis-(2,4-Dichlorobenzoyl) peroxide
- Dicumyl peroxide
- tert-Butyl-cumyl peroxide
- 2,5-Bis(tert-butylperoxy)-2,5-dimethylhexane
- Methyl-tris-cyclohexyl-aminosilane
- Methyl-tris-sec-butylaminosilane
- Methyl-tris-acetoxyisilane
- Ethyl-tris-acetoxyisilane
- Methyl-tris-butanoximosilane
- Di-(4-methyl-benzoyl)peroxide
- Esters of alkyl-C₁₈-silicic acid or orthosilicic acid with aliphatic monohydric alcohols C₂-C₄ and the monomethyl ether of ethanediol (methylglycol) and their condensation products ¹³, in total max. 3 %.

The following substances may be used as inhibitors for these coordination compounds:
- 1-ethinyl-cyclohexanol and 2-methylbutine-3-ol-2, in total max. 0.1 %.

c) Hardener or catalysts and their conversion products:
- Di-n-octyl-tin-dimaleinate
- Di-n-octyl-tin-dilaurate max. 1.5 %,
- Esters of titanic acid with isobutyl alcohol, n-butanol and the enolate of acetoacetic ester finished product
- Amides of aliphatic carboxylic acids, C₈-C₂₂
- Coordination compounds of platinum, max. 50 mg platinum per kg finished product ¹⁴.

The following substances may be used as inhibitors for these coordination compounds:
- 1-ethinyl-cyclohexanol and 2-methylbutine-3-ol-2, in total max. 0.1 %.

d) Emulsifying agents:
- Apart from the emulsifying agents ⁴ listed above under Section I, No. 2 c, the following may be used only in silicone elastomers for coating paper:
- Sodium alkyl(C₈-C₂₂)-sulfates in total max. 4 %
- Sodium alkyl(C₈-C₂₂)-sulfonates based on silicone content
- Sodium alkylaryl sulfonates

The total amount of emulsifying agents used must not exceed 10 %.

e) Reclaimed silicone rubber, provided it complies with this Recommendation.

3. To the extent that the silicone elastomers are intended for coating paper or plastic films, the following may be used:
- the substances listed above under Section II, No. 3
- as hardener or catalyst – departing from No. 2, c) of this Section -, coordination compounds of platinum, max. 120 mg platinum per kg finished coating
- 1,2-dibromo-2,4-dicyanobutane, max. 2.7 µg/dm² of finished coating, as preservative.
- 2-Bromo-2-nitropropane-1,3-diol, max. 1.25 µg/dm² of finished coating, as preservative.

4. To the extent that silicone elastomers in compliance with this recommendation are used in the manufacture of bottle teats, dummies (pacifiers), nipple caps, teething rings or dental guards, the finished products may only contain the following production aids, used during manufacture and processing of the raw polymer, in the maximum amounts given:

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¹¹ The migration of 2,4-dichloro benzoic acid formed as decomposition product must not exceed 5 mg/kg food resp. food simulant.
¹² The reaction products, cyclohexylamine, sec-butylamine or Butanonoxime and their conversion products must not be detectable in the finished products. For method of analysis, see 43rd Communication on the testing of plastics in Bundesgesundheitsblatt 22 (1979) 339
¹³ The conversion products are incorporated into the elastomers or hydrolysed to silicic acid.
¹⁴ Hexachloroplatinic acid and its conversion products with vinyl-containing siloxanes are the catalysts of choice.
a) Conversion products of the following cross-linking agents:
   Dicumyl peroxide
   Benzoyl peroxide
   tert-Butyl-cumyl peroxide
   in total max. 0.2 %

b) Hardener or catalysts and their conversion products:
   Coordination compounds of platinum, max. 50 mg platinum
   per kg of finished product

 c) The following may be used as inhibitors:
   1-Ethynyl-cyclohexanol and 2-methylbutine-3-ol-2, in total max. 0.1 %

d) Fillers:
   Silicic acid.

Dummies (pacifiers) and bottle teats made of silicone elastomers must comply with the
requirements laid down in the Commodities Regulation (Bedarfsgegenständeverordnung).

5. The silicone elastomers must release no more than 0.5 % volatile organic and no more than
0.5 % extractable components.

6. The finished products must not test positively for peroxides.

7. The silicone elastomers must contain not more than 3 % titanium dioxide or titanium dioxide
with 1-3 % iron(III) oxide as heat stabilizing agent. The material is characterized as follows:
The size of the primary particles is 5-100 nm, at least 90 % of primary particles have a size
below 50 nm.

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15 Recommendation LII. "Fillers"
16 61st Communication on testing of plastics in Bundesgesundheitsblatt, Gesundheitsforschung, Gesundheitsschutz
   46 (2003) 362
17 58th Communication on testing of plastics in Bundesgesundheitsblatt 40 (1997) 412