

Dow Corning®

Silicone Sealants *for* Industrial Assembly *and* Maintenance

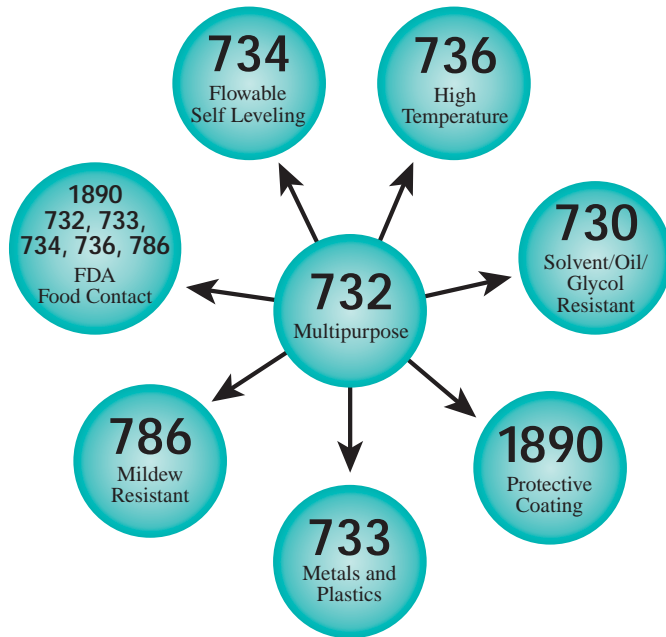
Americas Selection Guide



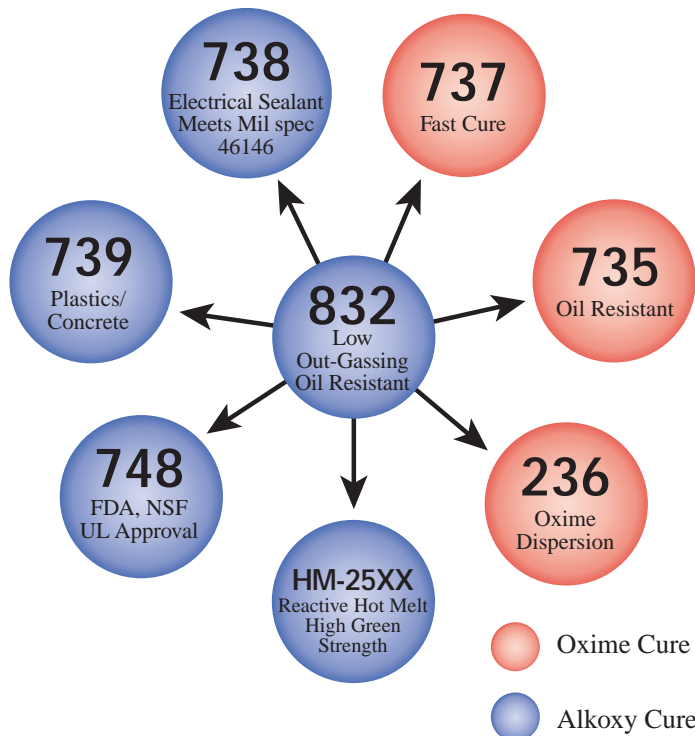
Regardless of how harsh the environment or how extreme the temperature, we are sure to have a Dow Corning® sealant to meet your needs.

This guide will assist you in selecting the best sealant for your specific application needs. A technical data sheet is available for all products.

Acetoxy Selection Guide



Neutral Cure RTV Selection Guide



All products listed are Dow Corning® brand

Acetoxy

Dow Corning® 730 Solvent Resistant Sealant

- **Primary Use** – Bonding, sealing and caulking where resistance to fuels, oils and solvents is required.
- **Applications** – Assembling and repairing fuel lines and tanks; bonding components exposed to fuels, oils, solvents; making formed-in-place gaskets for chemical compressors, fluid-filled distributors and transformers; repairing rubber linings exposed to corrosive conditions; sealing pipe joints on lines carrying corrosive chemicals.¹

Dow Corning® 732 Multi-Purpose Sealant

- **Primary Use** – General purpose bonding and sealing; making formed-in-place gaskets.
- **Applications** – Sealing flashing, vents, flues, gutters, marine cabins and windows, electrical boxes; caulking joints in sheet metal stacks, ductwork; bonding appliance parts, signs and sign letters; adhering auto trim, appliance trim, name plates; making formed-in-place gaskets for compressors, gearboxes, pumps.¹

Dow Corning® 733 Glass & Metal Sealant

- **Primary Use** – Bonding and sealing.
- **Applications** – Bonding and sealing appliances, heavy equipment, marine equipment, recreational vehicles.¹

Dow Corning® 734 Flowable Sealant

- **Primary Use** – To fill voids, cracks, crevices; conformal coating for connections and battery terminals.
- **Applications** – Coating mechanical devices; making formed-in-place gaskets for compressors, gearboxes, pumps; potting electrical terminals; sealing ammunition fuses, trailers, truck cabs.¹

Dow Corning® 736 Heat Resistant Sealant

- **Primary Use** – Sealing and bonding applications exposed to temperatures as high as 600°F (315°C).
- **Applications** – Sealing fired heaters, flanged pipe joints, access doors, moving oven belts, industrial ovens and boilers, plywood drying ovens, bag filters on smoke stacks, flues on gas appliances; bonding appliance parts, electrical and electronic equipment; caulking joints in sheet metal stacks, ductwork.¹

Dow Corning® 786 Mildew Resistant Sealant

- **Primary Use** – Interior sealing applications exposed to high moisture.
- **Applications** – Sealing tubs, sinks, plumbing fixtures, interior walls.¹

Dow Corning® 1890 Protective Coating

- **Primary Use** – General purpose coating for protecting motors and electrical equipment; maintenance coating.
- **Special Characteristics** – Excellent moisture protection and resistance to sand, dust, dirt particles; easy to apply, thin coatings will not run or drip when applied to vertical or overhead surfaces.
- **Applications** – Coating motor windings, bus bars, splines, connectors, transformers, insulators, trailers, truck cabs, wooden pole tops.¹

Dow Corning® Silicone Sealants Designed for Industrial Assembly and Maintenance

Silicon-based Dow Corning sealants last longer and are more versatile than most organic polymer sealants. They are durable, one part RTV sealant, cure at room temperature to a tough, rubbery solid with exceptional performance characteristics, and meet a wide variety of your industrial bonding and sealing needs.

Features of Dow Corning silicone sealants include:

- **Stability over a wide temperature range** – When fully cured, our products can be used at temperatures ranging from -85° to 599° F (-65° to 315° C).
- **Weather resistance** – High resistance to UV rays, radiation and weather prevents our products from hardening, cracking, crumbling, drying and becoming brittle.
- **Chemical stability** – Our sealants do not readily degrade even under long-term exposure to many chemicals and atmospheric pollutants.
- **Good bond strength** – Our products provide good adhesion to a wide variety of industrial materials, including glass, ceramics, and wood masonry, painted surfaces, and many metals and plastics.
- **Electrical properties** – Designed for a variety of applications, our products can be used in various electrical and electronic applications, including devices that are thermally cycled over a wide temperature range.
- **Low Flammability** – In fire conditions, silicone adhesives/sealants are reluctant to burn. Many products comply with UL flammability standards.

When you specify an assembly and maintenance product from Dow Corning, you receive a solution backed by the world leader in silicone technology with more than 60 years of expertise and innovations.

Innovative Technology

Reactive hot-melt silicone technology provides instant green strength which can increase productivity, improve quality and reduce costs in industrial assembly applications.

Dow Corning® HM-25XX Assembly Sealants are patented, neutral-cure reactive hot-melt silicones ideal for automated applications in the manufacturing of various components. When used with standard hot-melt dispensing equipment and an automated robot, HM-25XX Assembly Sealants become part of the productivity solution that enables parts to be produced faster, better, and more economically.

- **Immediate green strength** – parts move efficiently from one step to the next
- **No “hold time” required** – ship parts as fast as you make them
- **Long Pot Life and Long Open Time** – material stability, is not heat cured, does not cure in line
- **Aggressive Adhesion** – excellent primerless adhesion to metals, plastics, wood, and paints
- **Clear** - Ultra clear, clear, or select colors
- **Worker Friendly** – non-hazardous formulation, very low odor, very low voc

Neutral-Cure 100% Silicone Chemistry – cure to flexible, weather-resistant, silicone elastomer with outstanding durability and UV resistance



Oxime

Dow Corning® 236 Dispersion Coating

- **Primary Use** – Release coating for protective surfaces from weathering, corrosion and dirt.
- **Special Characteristics** - Excellent release; weather resistance; excellent electrical insulator
- **Applications** - Easing clean-up of latex manufacturing equipment and paint-spraying operations and removal of flash in urethane and polyester molding; preventing adhesion and build-up on conveyor belts, paper and fabric rolls; reducing build-up on waste-handling equipment.¹

Dow Corning® 735 Oil Resistant Sealant

- **Primary Use** - Sealing and adhering general industrial equipment, vehicles and other applications where resistance to oil, coolants and lubricants is required.
- **Applications** - Sealing oil circulation systems, machine housings, conveyors, piping, oil containment troughs, dikes and barriers; making formed-in-place gaskets for gearboxes, engines and pumps.¹

Dow Corning® 737 Neutral Cure Sealant

- **Primary Use** - General manufacturing assembly operations where quick cure and good adhesion are important.
- **Applications** - OEM and assembly applications; substitute for mechanical fasteners on appliances; adhering plastic moldings to plastic substrates; waterproofing components, sealing coaxial connectors, protecting instrumentation; may be used on concrete and masonry.¹

Alkoxy

Dow Corning® 738 Electrical Sealant

- **Primary Use** – Bonding and sealing.
- **Applications** – Bonding and sealing corrosion-sensitive electrical and electronic equipment.¹

Dow Corning® 739 Plastic Adhesive

- **Primary Use** – Adhering, bonding and sealing plastic and metal; making formed-in-place gaskets.
- **Applications** – Adhering auto trim, appliance trim and parts; assembling plastic toys; bonding gaskets in refrigeration units, signs and sign letters; caulking cement and masonry; making formed-in-place gaskets for compressors, gearboxes, pumps; sealing flashing, vents, gutters, marine cabins and windows; waterproofing leakproof tractor cabs.¹

Dow Corning® 748 Noncorrosive Sealant

- **Primary Use** – Electrical sealing applications; food processing and transportation applications.
- **Applications** – Bonding and sealing electrical equipment, power and control connections, motors, cover plates, instrument lenses, regulators, junction boxes, control panels; sealing refrigerator and freezer liners.¹

Dow Corning® 832 Multi-Surface Adhesive/Sealant

- **Primary Use** – Bonding, sealing and assembly where a noncorrosive sealant is required.
- **Applications** – Sealing and repairing roof penetrations, gutters, concrete floor seams, marine equipment and windows, pipes, threaded connections; assembling original equipment components.¹

| Cure Type | Dow Corning® Product* | Special Features | Temperature Range °F/°C (Intermittent)** | Color(s) | Skin-Over Time (min) | Tack Free Time (min) |
|--------------|-----------------------|----------------------------|--|---------------------|----------------------|----------------------|
| Acetoxyl | 730 | Solvent resistant | -85 to 500/-65 to 260 | wht | 5 | 25 |
| | 732 | Multi-purpose, FDA, NSF | -76 to 350 (400)/-60 to 177 (204) | alum, blk, clr, wht | 10 | 20 |
| | 733 | Good adhesion | -70 to 350 (400)/-57 to 177 (204) | alum, blk, clr, wht | 10 | 15 |
| | 734 | Flowable, self-leveling | -85 to 356/-65 to 180 | clr, wht | 7 | 13 |
| | 736 | High temperature resistant | -85 to 500 (599)/-65 to 260 (315) | red | 10 | 17 |
| | 786 | Mildew resistant | -76 to 350 (400)/-60 to 177 (204) | clr, wht | 5 | 20 |
| | 1890 | Coating, visc. 400 poise | -75 to 350 (400)/-59 to 177 (204) | gry | 15 | 25 |
| | 236 | Coating, visc. 675 cps | -40 to 300/-40 to 150 | wht | 85 | 120 |
| Alkoxy Oxime | 735 | Oil resistant | -80 to 400 (450)/-62 to 204 (230) | blk | 9 | 15 |
| | 737 | Fast cure | -85 to 350/-65 to 177 | blk, clr, wht | 5 | 14 |
| | 738 | Electrical sealant | -80 to 356/-62 to 180 | wht | 20 | 120 |
| | 739 | Plastic adhesive | -65 to 300 (350)/-54 to 149 (177) | blk, gry, wht | 25 | 45 |
| | 748 | FDA and NSF approved | -65 to 350 (400)/-55 to 177 (204) | off wht | 15 | 30 |
| | 832 | Excellent adhesion | -67 to 300 (350)/-55 to 149 (177) | blk, gry, off wht | 20 | 50 |
| | HM-2500 | Immediate adhesion | -50 to 300/-45 to 150 | ultra clr | — | — |
| | HM-2510 | Immediate adhesion | -50 to 300/-45 to 150 | ultra clr | — | — |
| | HM-2520 | Immediate adhesion | -50 to 300 / -45 to 150 | clr | — | — |

* Meets FDA CFR 21.177.2600

**Meets FDA CFR 21.177.2600 and FDA CFR 21.175.105

Dow Corning® HM-25XX Assembly Sealants

- **Primary Use** – Assembly, bonding, sealing, gasket and other applications that require instant adhesion and high green strength
- **Special Characteristics** – 100% silicone, instant adhesion, cures to long lasting silicone sealant.
- **Applications** – Hot melt reactive sealants work well in OEM and assembly applications, very good adhesion to most substrates without the need of a primer. With instant adhesion, parts can be shipped out quickly. Long open time, long pot life, and low voc.

Primers and Cleaners

Dow Corning® PR-1200 RTV Prime Coat

- **Primary Use** – Significantly improves the adhesion of silicone sealants, to a wide variety of challenging substrates.
- **Applications** – Improves the adhesion of silicone sealants, coatings and rubber to masonry, wood, granite, metals, glass, ceramics, plastics, rubbers and coatings.
- **Container Sizes** – Can, pail and drum.
- **Color** – Clear, red.

Dow Corning® P5200 Adhesion Promoter

- **Primary Use** – Significantly improves the adhesion of silicone sealants, with low VOC to a wide variety of challenging substrates.
- **Applications** – Improves the adhesion of silicone sealants, coatings and rubber to masonry, wood, granite, plastics, rubbers and coatings.
- **Container Sizes** – Can.
- **Colors** – Clear, red.

Dow Corning® OS-2 Silicone Cleaner and Surface Prep Solvent

- **Primary Use** – Removing oils, greases, waxes and sealant residue—especially silicone; cleaning surfaces to be painted, bonded or sealed; replacing VOC solvents.
- **Special Characteristics** – VOC exempt (VOC = 0 g/L). Certified as a Clean Air Solvent by the California South Coast Air Quality Management District. Easy to use, low in toxicity, essentially odorless. Safe on plastics and non-corrosive to metals. Ideal for diluting and tailoring the viscosity of silicones.
- **Applications** – Cleaning plastics, metals, other surfaces, or preparing these surfaces for painting, bonding or sealing.
- **Limitations** – This product may not remove highly polar contaminants.
- **Container Sizes** – Can, pail and drum.

*Most paints will not adhere to sealant; not for underwater structural or adhesive applications; requires atmospheric moisture to cure. May stress crack some plastics; test before use.

*Estimated service temperatures based on product formulation and laboratory testing. Actual service temperature range is dependent on other factors including the specific application environment.

| Extrusion Rate (g/min) | Durometer (shore A) | Tensile PSI | Elongation | Specific Gravity | Listing/ Specifications | Container Sizes Listed |
|------------------------|---------------------|-------------|------------|------------------|---------------------------------------|-----------------------------|
| 250 | 40 | 300 | 200 | 1.40 | | tube, cartridge, pail, drum |
| 350 | 25 | 325 | 600 | 1.04 | FDA 21*, NSF 51, NSF 61, UL, MIL spec | tube, cartridge, pail, drum |
| 350 | 25 | 335 | 500 | 1.03 | NSF 51, UL, FDA | cartridge, pail, drum |
| 650 | 27 | 222 | 315 | 1.03 | FDA 21*, NSF 51, UL, MIL spec | tube, cartridge, pail, drum |
| 390 | 26 | 350 | 600 | 1.04 | FDA 21*, NSF 51, UL, MIL spec | tube, cartridge, pail, drum |
| 350 | 25 | 325 | 600 | 1.04 | FDA 21**, NSF 51 | cartridge, pail, drum |
| — | 21 | — | — | 1.03 | FDA 21* | pail, drum |
| n/a | 20 | 325 | 500 | 1.64 | | can, pail |
| 400 | 42 | 280 | 300 | 1.06 | | cartridge |
| 395 | 33 | 175 | 300 | 1.04 | UL | tube, cartridge, pail, drum |
| 550 | 35 | 385 | 535 | 1.03 | UL, MIL-A-46146 Type 1 | tube, cartridge, pail, drum |
| 110 | 37 | 225 | 640 | 1.52 | UL | cartridge, pail, drum |
| 150 | 25 | 275 | 350 | 1.33 | FDA 21**, NSF 51, NSF 61, UL | tube, cartridge, pail, drum |
| 133 | 35 | 350 | 420 | 1.33 | UL | cartridge, pail, drum |
| — | 60 | 350 | 1000 | 1.06 | FDA 21*, NSF 51, NSF 61, UL | cartridge, pail, drum |
| — | 47 | 390 | 760 | 1.07 | FDA 21*, NSF 51, NSF 61 | cartridge, pail, drum |
| — | 33 | 700 | 1000 | 1.12 | FDA 21*, NSF 51, NSF 61 | cartridge, pail, drum |

Substrate Preparation

Although Dow Corning silicone sealants possess excellent bond strength, maximum adhesion is only attained on surfaces which are clean and dry. Contaminants, such as dirt, grease, water, tar or rust act as release agents and prevent the formation of durable bonds

It is strongly recommended, therefore, that wet or unclean surfaces be properly prepared before sealants are applied.

- Wipe contaminated surface with a clean, oil-free cloth.
- Rewipe surface with a suitable cleaner or industrial solvent, such as IPA, mineral spirits, naphtha or ketones. Note: do not clean surface with detergent or soap. (Soap residue may act as release agent.)
- Rough rubber surfaces with sandpaper. Make a spot check to determine the adhesion of sealants for each application. Bond strength will increase as the sealant cures.

How to Apply

Apply Dow Corning adhesives/sealants to one of the prepared surfaces, then quickly cover with the other substrate to be bonded. On exposure to moisture, the freshly applied material will “skin over” in about 5-10 minutes (depending on the product) at room temperature and 50% relative humidity. Any tooling should be completed before this skin forms. The surface is easily tooled with a spatula.

Use of Primer

For maximum adhesion, the use of Dow Corning primer is recommended. After solvent cleaning, a thin coat of Dow Corning primer is applied by wiping, brushing or spraying. At normal room temperatures and humidity conditions (room temperature, 50% relative humidity), the primer should be allowed to air dry from 5 to 30 minutes. The primer cures in contact with air moisture, low humidity will necessitate longer drying time.

The required drying time for a specific area should be determined prior to use. Primer which was allowed to cure extensively will not promote adhesion anymore. As a general rule, drying time of more than 6 hours at normal temperatures and humidity should be avoided.

Cure Time

After skin formation, cure continues inward from the surface. In 24 hours (at room temperature and 50% relative humidity) Dow Corning adhesive/sealant will cure to a depth of about 1/8". Very deep sections, especially when access to atmospheric moisture is restricted, will take longer to cure completely. Cure time is extended at lower humidity levels.

As the sealants cure by reaction with moisture in the air, keep the container tightly sealed when not in use. A plug of used material may form in the tip of a tube or cartridge during storage. This is easily removed and does not affect the remaining contents.

Compatibility

Some Dow Corning adhesives/sealants release a small amount of acetic acid during cure. This may cause corrosion on some metallic parts or substrates, especially in direct contact or when the cure is carried out in a totally enclosed environment which would not allow cure by-products to escape.

Health and Environmental Information

To support Customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For more information please see our website, www.dowcorning.com or consult your local Dow Corning representative.

How To Contact Us

For more than 60 years, OEM designers, maintenance and materials engineers around the world have trusted Dow Corning brand for performance and expertise to solve or prevent sealant problems. Dow Corning solutions are available through a distributor network of more than 3000 channel partners around the world. To learn more about our extensive product and service offerings, visit www.dowcorning.com or email industrial@dowcorning.com.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that Dow Corning's products are safe, effective, and fully satisfactory for the intended use. Suggestions of uses should not be taken as inducements to infringe any particular patent.

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Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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Form No: 80-3258C-01

Cover montage: AV05264, AV08189, AV08190, AV08191, AV08192, AV08193, AV08194.

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