

## TECHNICAL SPECIFICATIONS AND STANDARDS

Conforms to ISO 11600-G-20LM. Performance related to mildew and fungus resistance has been tested in accordance with the ISO-Norm 846.

## HOW TO USE

### Surface preparation

Ensure that surfaces to be sealed are clean, dry, sound and free from frost, release agents, old sealants and other contaminants which could impair adhesion. All surfaces should be cleaned and degreased by wiping with a suitable solvent such as DOW CORNING® R40 Universal Cleaner on a clean oil- and lint-free cloth before application of sealant.

Note: When using any solvent, always provide adequate ventilation. Avoid heat, sparks and open flames. Use solvent resistant gloves. Observe and follow all precautions listed on solvent container label.

### Masking

Areas adjacent to the joints should be masked with tape to prevent contamination of the substrates and to ensure a neat sealant line. Masking tape should be removed immediately after tooling.

### Priming

DOW CORNING 784 Silicone Sealant offers good adhesion to most non-porous substrates found in glazing applications. However, due to the wide variety of coatings available, we recommend that substrates be tested for adhesion prior to use. The use of a primer will maximize adhesion of the sealant particularly where cleaning is a problem, for example, mill finished aluminum. For specific advice, please refer to the DOW CORNING® Brand Primers' Guide or contact one of Dow Corning's Regional Service Centers for technical assistance.

### Back-up materials

When back-up material is required, a closed cell polyethylene backer rod is recommended. Low tack polyethylene tape should be used in joints too shallow to allow the use of a backer rod. Back-up materials provide back pressure and prevent three sided adhesion that limits sealant movement capability.

### Finishing

The joint should be tooled within 5 minutes of application to ensure good contact between the sealant and the substrate. Tooling of the sealant also gives a smooth, professional finish. Spatulas for tooling purposes are available from Dow Corning.

### Clean-up

Excess sealant may be cleaned off tools and non-porous surfaces whilst in an uncured state using DOW CORNING R40 Universal Cleaner. If sealant is misapplied to porous substrates, it should be left until it is just cured and then removed by peeling, cutting or other mechanical means. Care should be taken not to damage plastic or coated surfaces.

## JOINT DESIGN

The sealant joint width should be designed to accommodate the movement capability of the sealant. When designing joints using DOW CORNING 784 Silicone Sealant, the minimum width should be 6mm. For joints between 6-12mm wide, a seal depth of 6mm is required. For joints above 12mm wide, a width to depth ratio of 2:1 should be used. In situations where fillet joints are needed, a minimum of 6mm sealant bite to each substrate is recommended.

Figure 1: Deep joint.

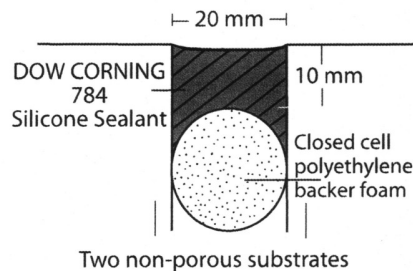
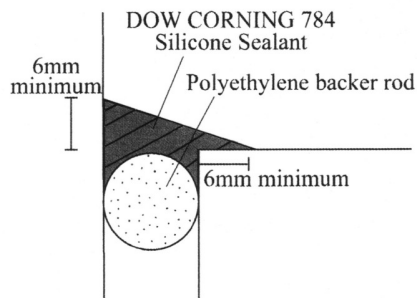


Figure 2: Fillet joint.



## HANDLING PRECAUTIONS

Product safety information required for safe use is not included. Before handling, read product and safety data sheets and container labels for safe use, physical and health hazard information. The material safety data sheet is available on the Dow Corning website at [www.dowcorning.com](http://www.dowcorning.com). You can also obtain a copy from your local Dow Corning sales representative or Distributor or by calling your local Dow Corning Global Connection.

## USABLE LIFE AND STORAGE

When stored in cool, dry conditions below 30°C (86°F) in the original unopened containers, DOW CORNING 784 Silicone Sealant has a usable life of 27 months from the date of production.

## PACKAGING

DOW CORNING 784 Silicone Sealant is supplied in 310ml cartridges packed in boxes of 12.