

Product Information
High
Performance
Building

DOW CORNING

Dow Corning® 781 Acetoxy
Silicone

FEATURES & BENEFITS

- High strength
- Good elasticity
- Conforms to ISO 11600-F&G-20LM
- Resistant to ozone, ultra-violet radiation and temperature extremes

Medium/high modulus acetoxy silicone sealant

APPLICATIONS

- *Dow Corning® 781 Acetoxy Silicone* is a one-part, silicone sealant which has good adhesion to a range of non-porous surfaces including glass, aluminum, painted surfaces and composite boards. It offers excellent resistance to aging, shrinkage, cracking and discoloring. It is also approved in certain countries for use in contact with potable water once cured.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test	Property	Unit	Result
	Cure system		Acetoxy
	Application temperature	°C	+5 to +40
		°F	+41 to +104
CTM* 97B	Specific gravity		1.02
CTM 364C	Extrusion rate	g/minute	220
CTM 98B	Skin-over time (23°C (73°F), 50% R.H.)	minutes	14
CTM 663A	Cure rate (23°C (73°F), 50% R.H.)		
	1 day	mm	3
	3 days	mm	5
2mm thickness S2 dumb-bells (ISO** 37)			
CTM 137A	E-Modulus 100%	MPa	0.40
CTM 137A	Tensile strength	MPa	1.8
CTM 137A	Elongation at break	%	520
12x12x50mm size T.A. joint (ISO 8339/DIN*** 2-8339)			
CTM 677	E-Modulus 100%	MPa	0.4
CTM 677	E-Modulus 60%	MPa	0.35
CTM 677	Tensile strength	MPa	0.59
CTM 677	Elongation at break	%	190
CTM 99E	Hardness (Shore A)		22
ISO 9047	Joint movement capability	%	20

*CTM: Corporate Test Method, copies of CTMs are available on request.

**ISO: International Standardisation Organisation.

***DIN: Deutsche Industrie Norm.

TECHNICAL SPECIFICATIONS AND STANDARDS

Conforms to ISO 11600-F&G-20LM.
UK Water Regulations Advisory Scheme (WRAS)-approved Material.

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

All joint surfaces other than glass and glazed ceramics should be primed. For specific advice, please refer to the *Dow Corning 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.

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* 781 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. For joint dimensions greater than 25mm, please contact one of Dow Corning's Regional Service Centers for technical assistance.

Figure 1: Deep joint

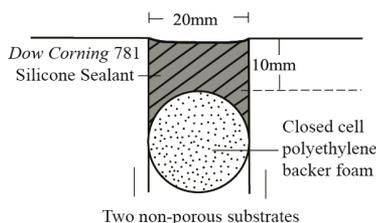


Figure 2: Shallow joint

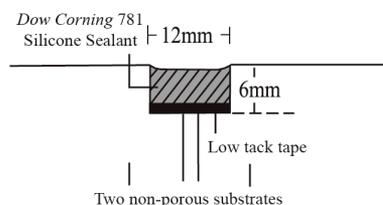
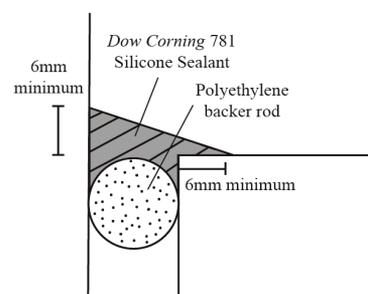


Figure 3: Fillet joint



HANDLING PRECAUTIONS
PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL 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 WEB SITE AT DOW CORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

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64 88 86 86

USABLE LIFE AND STORAGE

When stored in cool, dry conditions below 30°C (86°F) in the original unopened containers, *Dow Corning* 781 Silicone Sealant has a usable life of 27 months from the date of production.

PACKAGING INFORMATION

Dow Corning 781 Silicone Sealant is supplied in 310ml cartridges packed in boxes of 12.

LIMITATIONS

Dow Corning 781 Silicone Sealant is not recommended for use on porous substrates such as concrete, stone, marble or granite. *Dow Corning* 781 Silicone Sealant should not be used in contact with the edge seal of an insulated glazing unit.

Do not use *Dow Corning* 781 Silicone Sealant on bituminous substrates, substrates based on natural rubber, chloroprene or EPDM, or on building materials and flexible plastics which might bleed oils, plasticizers, or solvents. Do not use *Dow Corning* 781 Silicone Sealant in a totally confined space because the sealant requires atmospheric moisture to cure. Because acetic acid is released during curing, it can corrode mirror silver and sensitive metals such as copper, brass and lead. *Dow Corning*® 817 Mirror Adhesive should be used for this application. *Dow Corning* 781 Silicone Sealant is not recommended for use on submerged joints, or in joints where physical abuse or abrasion is likely to occur.

Dow Corning 781 Silicone Sealant is not suitable for food contact applications. However, it has been listed by the UK Water Fittings Byelaws Scheme for use in contact with potable water, once cured.

Dow Corning 781 Silicone Sealant has not been designed for use as an aquarium sealant.

Dow Corning 781 Silicone Sealant is not recommended for structural glazing or insulated glazing applications.

Dow Corning 781 Silicone Sealant is not recommended for structural glazing or insulated glazing applications.

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

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

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 our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

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.

TO THE FULLEST EXTENT PERMITTED BY APPLICABLE LAW, DOW CORNING SPECIFICALLY DISCLAIMS ANY OTHER EXPRESS OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY.

DOW CORNING DISCLAIMS LIABILITY FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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