



Technical Data Sheet

DOWSIL™ InstantGlaze II Assembly Sealant

Reactive hot-melt silicone for automated backbedding applications

Features & Benefits

- Instant green strength
- Meets ASTM C 793 weather resistance
- Low VOC (VOC exempt in CA)
- Neutral cure
- Adheres to most common window substrates
- Open time up to 15 minutes
- Pot life up to 18 hours at $\leq 250^{\circ}\text{F}$ ($\leq 121^{\circ}\text{C}$)
- Excellent clarity
- Service temperatures from -58 to 200°F (-50 to 93°C)
- Reduces silicone contamination and cleanup
- Easy to deglaze
- Can be used with standard XY glazing equipment and pumps
- Instant green strength delivers improved productivity in window assembly.
- Long open time, pot life and moderate application temperature (200 to 250°F [93 to 121°C]) offer a user-friendly application.
- Unique physical properties minimize contamination of window components during assembly.

Composition

- Neutral (moisture) cure, 100 percent silicone, reactive hot-melt sealant

Applications

- DOWSIL™ InstantGlaze II Assembly Sealant is designed for use as a backbedding sealant in the assembly of windows and doors. It is used with high-speed XY glazing equipment to improve manufacturing productivity and window performance. It can be used on most common window materials (wood, PVC, aluminum, fiberglass) for standard glazing. DOWSIL™ InstantGlaze II Assembly Sealant is also compatible with most common insulating glass sealants.

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Typical Properties

Specification Writers: These values are not intended for use in preparing specifications

Test	Property	Unit	Result
CTM ¹ 0719	Viscosity		
	at 200°F (93°C)	poise	1700
	at 250°F (121°C)	poise	1050
CTM 0243	Open time ²	minutes	15
CTM 0243	Green strength		
	at 15 minutes	psi	5
	at 60 minutes	psi	6
	Cure time ³	days	2
ASTM ⁴ C 661	Durometer, Shore A	points	47
ASTM D 412	Tensile strength	psi	390
ASTM D 412	Elongation	percent	760
ASTM D 412	Modulus at 50 percent elongation	psi	38
ASTM C 719	Movement capability	percent	±50
ASTM C 794	Peel strength		
	to Float glass	pli	56
	to Mill-finished aluminum	pli	44
	to PVC	pli	51
	to Pine	pli	27
	to Fiberglass	pli	46
	to Kynar-coated aluminium	pli	55
ASTM C 711	Low-temperature flexibility	°F (°C)	-58 (-50)
ASTM C 793	Weathering resistance		Excellent
CTM 0044	Specific gravity, uncured		1.070
ASTM C 711	Service temperature range	°F (°C)	-58 to 200 (-50 to 93)

1. CTMs (Corporate Test Methods) correspond to standard ASTM tests in most instances. Copies of CTMs are available upon request.
2. To ensure adhesion.
3. Full cure within a manufactured unit depends on joint design.
4. ASTM – American Society for Testing and Materials.

Description

DOWSIL™ InstantGlaze II Assembly Sealant is a 100 percent silicone, neutral-cure sealant formulated to meet the demanding requirements of a backbedding sealant for the highspeed manufacturing of windows and doors. DOWSIL™ InstantGlaze II Assembly Sealant delivers instant green strength to offer productivity improvements in backbedding applications. Windows made with DOWSIL™ InstantGlaze II Assembly Sealant can be immediately handled without the risk of compromising the integrity of the seal or distorting of the sash.

DOWSIL™ InstantGlaze II Assembly Sealant is available in clear.

Approvals/ Specifications

AAMA 805.2-94, Group A

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How To Use

Preparation

Surfaces should be clean and dry before sealant application.

Application

DOWSIL™ InstantGlaze II Assembly Sealant is applied from 5 gallon pails or 55 gallon drums with a platen-type hot-melt pump. Application temperature is typically between 200 and 250°F (93 and 121°C). When the melt temperature has been reached, application with automated or hand-assisted glazing equipment can begin.

After applying the sealant to the sash, the glass unit should be installed within 15 minutes to ensure adhesion. Once applied, this product reacts with atmospheric moisture to form a weather resistant, flexible silicone sealant. Exposure of opened containers with air should be minimized.

Handling Precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW WEBSITE AT CONSUMER.DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

Material is applied between 200 and 250°F (93 and 121°C). Use common personal protective equipment to prevent contacting the hot material with skin or eyes.

Usable Life And Storage

When stored at or below 90°F (32°C) in original unopened containers, DOWSIL™ InstantGlaze II Assembly Sealant has a usable life of 18 months from the date of manufacture. Refer to product packaging for "Use By Date."

Packaging

DOWSIL™ InstantGlaze II Assembly Sealant is available in 5 gal (20 L) pails containing 40 lb (18 kg), 7 gal (28 L) pails containing 55 lb (25 kg) and 55 gal (200 L) drums containing 452 lb (205 kg).

Limitations

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

DOWSIL™ InstantGlaze II Assembly Sealant is not intended for use:

- In spaces totally confined from atmospheric moisture during cure
- In continuous water immersion
- In below-grade applications
- In structural glazing applications
- As an insulating glass sealant
- On surfaces that require painting or staining
- On surfaces that might bleed oils, plasticizers or solvents
- On frost-laden or wet surfaces
- When movement capability greater than ± 50 percent is required

Avoid prolonged exposure to citrus containing cleaners, solvents and solvent-based cleaners.

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Health And Environmental Information

To support customers in their product safety needs, Dow has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, www.consumer.dow.com or consult your local Dow representative.

consumer.dow.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 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.

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