

# Product Information

## Silicone Bonding Sealant

DOW CORNING

## Dow Corning® 776 InstantFix WB

### FEATURES

- Easy-to-use 1-part Silicone
- Low squeeze-out
- Provides Instant Green Strength
- UV- and weather -resistant
- Primerless adhesion to a wide range of substrates such as PVC, coated wood, glass, etc.
- Neutral cure
- Low odor
- Suitable for automated assembly applications
- Elastic Bonding Silicone
- Structural capability for window bonding applications similar to Dow Corning Construction 2-part silicones
- Temperature stability over a wide range: -50°C to +150°C

### BENEFITS

- Fast strength build up supports productivity enhancements due to fast handling of bonded units (see Figure 1)
- Saves time as no buffer for strength build up required
- For factory glazing and on-site application

Instant Strength neutral cure silicone for window & door assembly

### APPLICATIONS

- *Dow Corning® 776 InstantFix WB* is a 1 part silicone sealant specifically designed for window & door bonding application that require immediate handling and processing of the units. It provides immediate strength directly after application, enhancing productivity. *Dow Corning 776 InstantFix WB* is a silicone which shows primerless adhesion to a variety of substrates typical for windows and doors. As a 1-part silicone it is suitable for manual and automated processes and provides excellent long-term durability.

### 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
<b>As supplied – uncured state</b>			
CTM 97B	Specific gravity	g/ml	1.58
ASTM D2202	Flow (sag or slump)	mm	0
ASTM C 679	Tack-free time (23°C, 50% R.H.)	minutes	30
CTM 663A	Curing time (23°C, 50% R.H.)		
	- after 24 hours	mm	2
	- after 72 hours	mm	4
CTM 1430	Immediate strength	Pa	1500
<b>As cured after 7 days at +23°C 2mm sheet (ISO 37)</b>			
CTM 99A	Durometer hardness, Shore A	Points	47
CTM 137A	Modulus at 100% elongation	MPa	1.0
CTM 137A	Tensile strength at break	MPa	1.8
CTM 137A	Elongation at break	%	500
<b>Properties after 28d cure at 50% RH and +23°C (73°F) 12mmx12mmx50mm H-Piece (ISO 8339)</b>			
ISO 8339	Elongation at break	%	>100
ISO8339	Tensile strength	MPa	1.2
	Service temperature range	C°	-50to+150

\*CTM: Corporate Test Method, copies of CTM's are available on request.

ASTM: American Society for Testing and Materials.

ISO: International Standardization Organization

### DESCRIPTION

*Dow Corning 776 InstantFix WB* is a one-part, neutral curing alkoxy silicone sealant designed specifically for window bonding application.

Neutral alkoxy silicones cure at room temperature on exposure to water vapor in the air, giving off a small amount of alcohol.

### GREEN STRENGTH

*Dow Corning 776 InstantFix WB* provides immediate Green Strength. Once applied and substrates assembled together, *Dow Corning 776 InstantFix WB* is able to withstand certain dynamic and constant loads.

This property is unique and can eliminate the usage of tapes for

pre-fixing. It is therefore able to enhance productivity, can save time and labor cost. The immediate green strength is about 5 times higher than any other standard sealant which typically allows to move freshly bonded window units and window components immediately.\*

\*Please refer to Figure 1 (see end of this document).

## HOW TO USE

*Dow Corning 776 InstantFix WB* is a ready to use silicone sealant. It provides excellent strength and adheres to a wide range of most common window materials such as PVC, coated wood, metal and glass. *Dow Corning 776 InstantFix WB* can be used for fully automated robotized applications and is also suitable for manual applications.

It has good workability and ease of use properties, low string and a good resistance compression. There is far less squeeze out as seen with standard sealants.

As it is a moisture curing sealant, the reaction starts at the surface exposed to moisture and cures in depth. The deeper the joint is, the longer it takes the sealant to cure completely. Moisture has to migrate further to the already cured skin and as this skin becomes thicker, the reaction slows further down.

For Bonding application, the joint depth in general should not be deeper than 10mm to achieve reasonable cure times. However, the ultimate joint depth must not exceed 14-15mm.

## BONDING APPLICATION

*Dow Corning 776 InstantFix WB* offers good adhesion to most common window substrates such as PVC, coated wood, glass and

metal. The sealant is compatible with most commonly used glazing components. It is compatible to *Dow Corning*® Neutral Curing Construction Sealants and *Dow Corning*® Neutral Curing Insulating Glass Sealants.

It is important when selecting components within Window Bonding Application to ensure adhesion and compatibility by carrying out tests

As a one-part neutral curing system, moisture vapor/humidity is required for cure. Substrates have to be put together within the above stated open time before skin formation. High humidity level and higher temperatures accelerate the cure process.

Green Strength is continuously building up during cure. Adhesion to the substrates is developed at the same time as product cure. Although the strength build up is quite fast, the sealant will develop its final properties once completely cured. Therefore windows should not be installed before complete cure.

A further requisite for a high quality bonding application consists in an appropriate joint dimension. Depending on parameters such as glass weight, window sizes, but also frame materials and temperatures, joint dimensions may vary. Typical joint dimensions are in a range of 4mm x 8mm / 4mm x 10mm, but strongly depend on the specific parameters of the window system and the conditions it is exposed to after installation. More specific information about bonding are available in the Technical Manual for Bonded Windows. For each bonding project separately and depending on customer requirements, Dow Corning Construction Industry Technical Service will provide a tailor-made solution.

For further information please contact your local technical service engineer, who can help determining the required joint dimensions

## TECHNICAL SERVICES

**Your Dow Corning contact details (e-mails):**

**Technical inquiries:**

eutech.info@dowcorning.com

**Marketing:**

construction.marketing@dowcorning.com

**Quality Bond:**

qualitybond@dowcorning.com

**EHS inquiries:**

europe.ehs@dowcorning.com

**Reach inquiries:**

reachsupport@dowcorning.com

**Your Technical Service contact details (phone):**

**Toll Free Numbers:**

**From Belgium** 0800 80 522

**From France** 0805 54 04 39

**From Germany** 0800 52 50 258

**From Italy** 800 92 83 30

**From Spain** 900 813161

**From United Kingdom**

0800 9172 071

**All other countries:**

**For English** +32 64 51 11 59

**For French** +32 64 51 11 59

**For German** +49 611 237503

**For Italian** +32 64 51 11 73

**For Spanish** +32 64 51 11 66

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**Fax number from all countries:**

+32 64 88 86 86

## CLEANING

Substrates must be clean prior to application to ensure adhesion durability. All surfaces must be clean from contaminants and residues such as grease, oil, dust, water, frost, surface dirt, old sealants or glazing compounds and protective coatings. Metal, glass and plastic surfaces should be

cleaned by solvent procedures. Solvent should be wiped on and off with clean, oil- and lint-free cloths. *Dow Corning*® R40 Cleaner is recommended for cleaning. The ventilation time at room temperature should be at least 1 minute. Please contact your Dow Corning Technical Service Engineer for more information.

## COLOR

*Dow Corning* 776 InstantFix WB is available in black color.

## PRIMING

For each project separately, it is essential that adhesion to all concerned surfaces should be tested before application. If adhesion requires priming, a primer such as *Dow Corning*® 1200 OS is in general recommended. When priming, the ventilation time at room temperature should be at least 1 minute.

Priming should be done within 4 hours after cleaning. If there is a greater time delay, cleaning process has to be repeated again. Project specific priming regulation needs to be discussed and approved by Dow Corning Technical Department. Please contact your local Dow Corning Technical Service Engineer for further assistance.

## MASKING AND TOOLING

Areas adjacent to joints may be masked to ensure a neat sealant line. Do not allow masking tape to touch clean surfaces to which the silicone sealant is to adhere. Tooling should be completed in one continuous stroke before skin building. Masking tape should be removed immediately after tooling.

## MAINTENANCE

No maintenance is needed once sealant has been properly applied and cured. If glass units need to be replaced or sealant becomes damaged, sealant joint has to be cut back as much as possible. *Dow Corning* 776 InstantFix WB will adhere to cured silicone sealant which exhibits a clean knife-cut or abraded surface.

## EQUIPMENT CLEANING

Once sealant is used in conjunction with a dispensing equipment, dispensing system needs to be air-tight and moisture tight as otherwise sealant will start to cure over time. Normally there is no specific cleaning required as it is a one-part silicone sealant. Material which stays uncured in the nozzle, will start to cure. To avoid that, nozzle should be covered with a moisture tight material such as metal

## 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 Web site at [dowcorning.com](http://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 at or below +30°C in the original unopened containers, *Dow Corning* 776 InstantFix WB has a usable shelf life of 12 months from the date of production.

Storage conditions must be respected as higher temperatures will significantly reduce shelf life.

## COLOR AND PACKAGING INFORMATION

*Dow Corning* 776 InstantFix WB is available in white and black. For manual application it is provided in 310ml cartridges and 600ml sausages as well as in 20 liter pails and 250kg drums

## LIMITATIONS

*Dow Corning* 776 InstantFix WB must not be used for structural glazing applications in façade or as a sealant for insulating glass units.

Because of the risk of incompatibility, *Dow Corning* 776 InstantFix WB must not come into contact with, or to be exposed to, sealants that liberate acetic acid.

Prior to use *Dow Corning* 776 InstantFix WB in fully automated bonding applications, it is recommended to contact Dow Corning Construction Industry Technical Service. Each project shall be specifically and separately approved by Dow Corning. Project approval involves the following prerequisites:

- Joint dimensioning and print reviews
- Successful laboratory adhesion and compatibility testing to all relevant building components in direct or indirect contact with the bonding sealant.
- Observance of professional sealant application and workmanship standards.

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 Web site, [dowcorning.com](http://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.

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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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**Figure 1:**

