

# Dow Corning® 791 Silicone Weatherproofing Sealant

### FEATURES

- Ideal for expansion, contraction, perimeter and other movement joints
- Neutral cure – suitable for use on coated glass, galvanized steel, masonry and other porous and non-porous substrates
- Extension/compression movement capability of up to ±50 percent of the original joint width

### BENEFITS

- Excellent weatherability, virtually unaffected by sunlight, rain, snow, ozone.
- Excellent unprimed adhesion to a wide variety of construction materials and building components.
- Ease of application – ready to use as supplied
- Excellent rheology, low string upon gunning

### COMPOSITION

- One-part, neutral-cure, RTV silicone sealant

### Neutral, one-part silicone sealant

### APPLICATIONS

- Dow Corning® 791 Silicone Weatherproofing Sealant is a specified, premium performance weather sealing product specifically designed for general glazing and weather sealing in curtain wall and building facades.

### 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.

| Method  | Test                                 | Unit          | Result     |
|---|--------------------------------------|---------------|------------|
| <b>Uncured – As Tested at 50% RH and 23°C (73°F)</b>      |                                      |               |            |
| ASTM C 639  | Flow (sag or slump)                  | inches (mm)   | 0          |
| ASTM C 603  | Extrusion Rate                       | g/minute      | 140        |
|   | Working Time                         | minutes       | 20         |
| ASTM C 679  | Tack-free Time, 77°F, 50% RH         | minutes       | 40         |
|   | Curing Time at 77° (25°C) and 50% RH | days          | 7-14       |
|   | VOC Content <sup>3</sup>             | g/L           | 31         |
| <b>As Cured – After 21 days at 50% RH and 77°F (25°C)</b> |                                      |               |            |
| ASTM D 2240   | Durometer Hardness, Shore A          | points        | 34         |
| ASTM C 794  | Peel Strength                        | lb/in (kg/cm) | 30 (5.4)   |
| ASTM C 719  | Joint Movement Capability            | percent       | ±50        |
| ASTM C 1135   | Tensile Adhesion Strength            |               |            |
|   | At 25% extension                     | Psi (MPa)     | 40 (0.276) |
|   | At 50% extension                     | Psi (MPa)     | 60 (0.414) |

<sup>1</sup> ASTM – American Society for Testing and Materials.

<sup>2</sup> CTM – Corporate Test Method; copies of CTMs are available on request.

<sup>3</sup> Based on South Coast Air Quality Management District of California. Maximum VOC is listed both inclusive and exclusive of water and except compounds. For a VOC data sheet for a specific sealant color, please send your request to [product.inquiry@dowcorning.com](mailto:product.inquiry@dowcorning.com).

### DESCRIPTION

Dow Corning 791 Silicone Weatherproofing Sealant is a one-part, neutral-cure, architectural grade sealant. It easily extrudes in any weather and cures at ambient temperature by reaction with moisture in the air to form a durable, flexible silicone rubber seal.

### APPROVALS/ SPECIFICATIONS

Meets the requirements of:

- ASTM C920 Type S, Grade NS, Class 50, Use NT, M, G, A



## SEALANT, WATERPROOFING & RESTORATION INSTITUTE

Issued to: **Dow Corning Corp.**

Product: 791 Silicone Weatherproofing Sealant

C719: Pass ✓ Ext: +50% Comp: -50%

Substrate: Mortar, Aluminum, Glass  
(Dow Primer P used on mortar substrates)

C661: Rating 40

Validation Date: 9/03/04 - 9/03/09

No. 904-791909

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## SEALANT VALIDATION

[www.swrionline.org](http://www.swrionline.org)

### Colors

This product is available in 6 colors: black, gray, bronze, limestone, precast white and white. Custom colors may be ordered to match virtually any substrate.

### HOW TO USE

Please consult the Dow Corning Americas Technical Manual, Form No. 62-1112, for detailed information on state-of-the-art application methods and joint design. Please contact your local Dow Corning Sales Application Engineer for specific advice.

### Preparation

Clean all joints removing all foreign matter and contaminants such as grease, oil, dust, water, frost, surface dirt, old sealants or glazing compounds and protective coatings.

### Application Method

Install backing material or joint filler, setting blocks, spacer shims and tapes. Mask areas adjacent to joints to ensure neat sealant lines. Primer is generally not required on non-porous surfaces, but maybe necessary for optimal sealant of certain porous surfaces. A test placement is always recommended. Apply Dow Corning 791 Silicone Weatherproofing Sealant in a continuous operation using a positive pressure. (The sealant can be applied using many types of air-operated guns and most types of bulk dispensing equipment. Before a skin forms (typically within 15 minutes), tool the

sealant with light pressure to spread the sealant against backing material and the joint surfaces. Remove masking tape as soon as the bead is tooled.

### 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 WEBSITE AT [WWW.DOWCORNING.COM](http://WWW.DOWCORNING.COM), OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

### USABLE LIFE AND STORAGE

When stored at or below 30°C (86°F) in the original unopened containers, Dow Corning 791 Silicone Weatherproofing Sealant has a usable life of 12 months from the date of manufacture. Refer to product packaging for "Use By" date.

### PACKAGING

Dow Corning 791 Silicone Weatherproofing Sealant is available in 10.3 fl oz (305-mL) disposable plastic cartridges that fit ordinary caulking guns, 20-fl oz (590-mL) sausages.

### LIMITATIONS

Dow Corning 791 Silicone Weatherproofing Sealant is not approved for use as a structural sealant.

Dow Corning 791 Silicone Weatherproofing Sealant should not be used:

- In below-grade applications
- When surface temperatures exceed 50°C (122°F)
- On surfaces that are continuously immersed in water.

- On building materials that bleed oils, plasticizers or solvents, green or partially vulcanized rubber gaskets or tapes
- On frost-laden or wet surfaces
- In totally confined joints (the sealant requires atmospheric moisture for cure)
- If the sealant is intended to be painted (paints do not typically adhere to most silicone sealants)
- To surfaces in direct contact with food or other food-grade applications

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

### HEALTH AND ENVIRONMENTAL INFORMATION

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For further information, please see our website, [www.dowcorning.com](http://www.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 Dow Corning's 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 the product will meet the Dow Corning 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.

**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.**

A 20-year Weatherseal Limited Warranty is available. Some testing may be required. Consult your Dow Corning Sales Application Engineer for details.



DOW CORNING

## DOW CORNING® 791

Silicone Weatherproofing Sealant

When You Need a Weatherseal Glazing Sealant

- ✓ Excellent weather-proofing performance
- ✓ Meets ASTM Specification C 920
- ✓ High movement capability ± 50%

### STANDARD COLORS



Black



Grey



Metal Grey



Bronze



Limestone



Precast White



White



Dark grey

Please refer to product literature for application and technical information.

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## Dow Corning® 795 Structural Glazing Sealant

### FEATURES

- Meets ASTM C1184 for Structural Silicone Sealant
- Meets ASTM C719 Class 50 High movement capability +/-50% in well designed weatherseal joint
- Excellent adhesion to a wide range of substrates including glass, anodized and coated aluminum profiles
- Non corrosive cure system

### BENEFITS

- Ease of use – all-temperature gunnability and easy tooling
- The cured product exhibits excellent weathering characteristics, and a high resistance to ultra-violet radiation, heat and humidity.
- High ultimate tensile strength which makes it suitable for structural bonding applications
- Excellent mechanical properties

### COMPOSITION

- One-part, neutral-cure, RTV silicone sealant

One-part, neutral-cure silicone sealant

### APPLICATIONS

- *Dow Corning® 795 Structural Glazing Sealant* is a one-component Silicone sealant designed for site or factory glazing and curtainwall production. It requires contact with air as it reacts with atmospheric moisture to cure to a tough but flexible silicone rubber. *Dow Corning® 795 Structural Glazing Sealant* can be used where dual structural and weatherseal applications are desired. It has up to +/- 50% movement capability in a well-designed weatherseal joint.

### 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 <sup>1</sup>  | Property                             | Unit    | Result     |
|--|--------------------------------------|---------|------------|
| <b>As Supplied</b>   |                                      |         |            |
| ASTM C 679   | Tack-Free Time, 50% RH               | hours   | 1.5 ( max) |
|  | Curing Time at 25°C, 50% RH          | days    | 7-14       |
|  | Full Adhesion                        | days    | 14-21      |
| ASTM C 639   | Flow, Sag or Slump                   | mm      | 0          |
|  | Working Time                         | minutes | 20-30      |
|  | Specific Gravity                     |         | 1.44       |
|  | VOC Content <sup>2</sup>             | g/l     | 32         |
| <b>As Cured - 7 Days at 25°C (77°F), 50% RH</b>  |                                      |         |            |
| ASTM D 412   | Tensile Strength (Ultimate)          | MPa     | 2.3        |
|  | Elongation                           | %       | 670        |
| ASTM C661  | Durometer Hardness, Shore A          | points  | 35         |
| ASTM D624  | Tear Strength, Die B                 | kN/m    | 13         |
| <b>As Cured – After 21 days at 25°C (77°F), 50% RH</b>   |                                      |         |            |
| ASTM C 794   | Peel Strength                        | kg/cm   | 8.5        |
| ASTM C 1135  | Tensile strength, at 100% elongation | MPa     | 0.6        |
|  | Ultimate Tensile strength, at break  | MPa     | 1.2        |
|  | Ultimate elongation at break         | %       | 400        |
| ASTM C 719   | Joint Movement Capability            | %       | ±50        |
| <b>As Cured – After 21 days at 25°C, 50% Relative Humidity followed by 5,000 hours in a QUV weatherometer, ASTM G 154-06</b> |                                      |         |            |
| ASTM C 1135  | Tensile strength, at 100% elongation | MPa     | 0.6        |
|  | Ultimate Tensile strength, at break  | MPa     | 1.1        |

<sup>1</sup>ASTM – American Society for Testing and Materials.

<sup>2</sup>Based on South Coast Air Quality Management District of California. Maximum VOC is listed both inclusive and exclusive of water and exempt compounds. For a VOC data sheet for a specific sealant color, please send your request to [product.inquiry@dowcorning.com](mailto:product.inquiry@dowcorning.com).

## DESCRIPTION

*Dow Corning® 795 Structural Glazing Sealant* is a one-part, neutral-cure, architectural-grade sealant that easily extrudes over a wide temperature range. This cold-applied, non-sagging silicone material cures to a medium-modulus rubber upon exposure to atmospheric moisture. The cured sealant is durable and flexible enough to accommodate  $\pm 50$  percent movement of original joint dimension when installed in a properly designed weatherseal joint. In a properly designed structurally glazed joint, the sealant is strong enough to support glass and other panel materials under high wind-load and seismic effects.

## APPROVALS/ SPECIFICATIONS

*Dow Corning® 795 Structural Glazing Sealant* meets the requirements of: ASTM Specification C 1184 for structural silicone sealants ASTM Specification C 920, Class 50

## COLORS

*Dow Corning® 795 Structural Glazing Sealant* is available in 4 colors: black, white, gray and bronze.

## HOW TO USE

When *Dow Corning® 795 Structural Glazing Sealant* is used in structural applications the structural joint design **MUST** be reviewed by a Dow Corning technical service specialist.

Complete design and installation guidelines are contained in the Dow Corning Asia Technical Manual, and must be followed for warranty applications when using this product.

## JOINT DESIGN

Structural joints sealed with *Dow Corning® 795 Structural Glazing Sealant* should have a minimum depth (or bite) of 6mm. For large site-glazed joints the sealant or bite should be not more than 12mm when the sealant can cure from one side only. When an open-cell moisture-permeable spacer tape is used, a

structural bite up to 24mm can cure to optimum strength. The exact structural bite should always be calculated. The thickness of the structural sealant joint or glueline should be 6mm minimum. As it must accommodate thermal and dynamic movements the actual joint movements should be calculated. Ideally the bite to glueline ratio should be not more than about 3:1.

## ACCESSORY SELECTION

The appropriate selection of all accessories such as setting blocks and backing materials is important to avoid discoloration or adhesion-related problems due to incompatibility. Dow Corning will also assess the suitability of proposed accessory materials as part of the standard testing services. Silicone-based setting blocks are generally recommended for best compatibility.

## PREPARATORY WORK

Thoroughly clean all substrates to be sealed, removing all contaminants such as grease, oil, dust, frost or water. All metal, glass, or other surfaces should be cleaned with the recommended solvent, using a lint free cloth.

## METHOD OF APPLICATION

Install backing material or joint filler, setting blocks, spacer shims and tapes. Mask areas adjacent to joints to ensure neat sealant lines. Apply *Dow Corning® 795 Structural Glazing Sealant* in a continuous operation using positive pressure. (The sealant can be applied using many types of air-operated guns and most types of bulk dispensing equipment.) Before a skin forms (typically within 15 minutes), tool the sealant with light pressure to spread the sealant against the backing material and joint surfaces. Remove masking tape as soon as the bead is tooled.

## HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMA-

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## USABLE LIFE AND STORAGE

When stored at or below 27°C (80°F), *Dow Corning® 795 Structural Glazing Sealant* has a shelf life of 12 months from the date of manufacture. Refer to product packaging for "Use By Date."

Questions about the use of *Dow Corning® 795 Structural Glazing Sealant* can be answered by calling your local Dow Corning Application Sales Engineer. Our laboratory personnel and technical service staff are also available for assistance.

## PACKAGING INFORMATION

*Dow Corning® 795 Structural Glazing Sealant* is supplied in 300 ml disposable plastic cartridges and 600 ml foil sausages.

## LIMITATIONS

*Dow Corning® 795 Structural Glazing Sealant* should not be used for structural applications without the prior written approval of Dow Corning Construction Industry Technical Services Department. Each project should be specifically and separately approved by Dow Corning.

Project specific approval involves the following prerequisites:

- Joint dimensioning and print reviews.

- Successful laboratory adhesion and compatibility testing to all building components.
- Observance of professional sealant application and workmanship standards.
- Users should always consult Dow Corning Technical Services Department for adhesion recommendation.

Dow Corning shall not be held liable for any possible claims arising from structural glazing use of Dow Corning® 795 Structural Glazing Sealant for projects which have not been specifically approved by Dow Corning.

For projects which have been approved, Dow Corning will issue a structural adhesion warranty on a case by case basis at the user's request. It is the user's exclusive responsibility to ensure project compliance with local building regulations.

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

## HEALTH AND ENVIRONMENTAL INFORMATION

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## 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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## 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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[dowcorning.com](http://dowcorning.com)

## How to Contact Us

Dow Corning has sales offices, manufacturing sites, as well as science and technology laboratories around the globe. Telephone numbers of the locations near you are available on the [www.dowcorning.com](http://www.dowcorning.com).



**Silicone  
Sealants**

***Dow Corning*<sup>®</sup> 991 Silicone  
High Performance Sealant**

**FEATURES**

- Improved aesthetic performance – reduces long-term residue rundown on metal panels and reflective glass or staining on porous substrates
- Good working time and tooling time
- All-temperature gunnability – from -29 to 50°C (-20 to 122°F), permitting application in all seasons
- Medium modulus, high movement capability – can accommodate ±50 percent movement in a properly designed joint
- Unprimed adhesion to most glass, granite, GFRC, and fluoropolymer painted substrates
- Excellent weatherability – non-reverting silicone durability
- Compatible with open-cell polyurethane, closed-cell polyethylene and nongassing polyolefin backer rods
- Available 20-year Limited Weatherseal and Non-Staining warranties

**COMPOSITION**

- One-part, pre-pigmented material

**Medium-modulus elastomeric sealant designed for weather-proofing sensitive porous stone and metal panel substrates**

**APPLICATIONS**

*Dow Corning*<sup>®</sup> 991 Silicone High Performance Sealant is particularly effective for sealing expansion and control joints, metal panel joints, curtainwall joints, joints between natural stone and perimeter seals around window frames. It forms a durable, flexible, watertight bond with most building materials. *Dow Corning* 991 Silicone High Performance Sealant is intended to be applied in new and remedial construction.

**TYPICAL PROPERTIES**

Specification Writers: Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

| Method   | Test   | Unit  | Result     |
|--|--|---|------------|
| <b>As Supplied</b>                             |  |   |            |
|  | Color  | Adobe tan, white, limestone, gray, bronze, black, custom colors |            |
| ASTM C 679                                     | Tack-Free Time, 50% RH   | minutes   | 60         |
|  | Curing Time, 50% RH at 25°C (77°F)                                     | days  | 7-14       |
| ASTM C 639                                     | Flow, Sag or Slump   | inches (mm)   | 0.1 (2.54) |
|  | Working Time   | minutes   | 30-45      |
| <b>As Cured</b>                                |  |   |            |
| ASTM D 2240                                    | Durometer Hardness, Shore A  | points  | 25         |
| <b>As Cured – After 14 days at 25°C (77°F)</b> |  |   |            |
| ASTM D 412                                     | Ultimate Tensile Strength  | psi (MPa)   | 200 (1.38) |
| ASTM D 412                                     | Ultimate Elongation  | percent   | 750        |
| ASTM C 794                                     | Peel Strength, unprimed to glass, and fluoropolymer painted substrates | ppi (kN/m)  | >20 (3.50) |
| ASTM C 1248                                    | Staining/Migration, white marble                                       |   | None       |
| <b>As Cured – After 21 days at 25°C (77°F)</b> |  |   |            |
| ASTM C 719                                     | Joint Movement Capability, glass, aluminum                             | percent   | ±50        |

**DESCRIPTION**

*Dow Corning* 991 Silicone High Performance Sealant is a medium-modulus elastomeric sealant specifically designed for weatherproofing sensitive porous stone and metal panel substrates. It is a one-part silicone formulation that requires no mixing prior to use to obtain all its aesthetic properties. *Dow Corning* 991 Silicone

High Performance Sealant cures to a flexible elastomer on exposure to atmospheric moisture, producing a durable, weather-resistant seal with the ability to form strong bonds with most building materials. Because of its medium modulus and good adhesion, it provides excellent weatherproofing performance in dynamically moving building joints.

*Dow Corning 991 Silicone High Performance Sealant* meets the following standards:

- ASTM Specification C 920, Type S, Grade NS, Class 50, Use NT, G, A, M and O
- ASTM Specification C 719  $\pm 50\%$  movement

## HOW TO USE

### Preparatory Work

The application surface must be clean, dry, sound and frost-free. Mask adjacent surfaces and apply primer as required, before installing an approved back-up material.

### Application

Apply *Dow Corning 991 Silicone High Performance Sealant* and tool so all joint sides are wetted out. (Wet tooling of the sealant with liquid tooling aids is not recommended.) In cases where excess uncured sealant is inadvertently applied to adjacent surfaces, the sealant should be cleaned from surfaces before curing, using mineral spirits (follow solvent manufacturer's safe handling recommendations and local, state and federal regulations regarding solvent usage).

Remove masking immediately after sealant application. Under low temperature and low humidity conditions, cure may be considerably longer.

### Joint Design

A thin sealant bead will accommodate more movement than a thick bead. Recommended width-to-depth ratio is

2:1 where possible. Joint depth over backer rod should be 1/8 to 1/2" (3 to 13 mm) and joint width from 1/4 to 1" (6 to 25 mm). *Dow Corning Technical Service* should be consulted for joint applications outside published guidelines. In all cases, movement of the joint should not exceed  $\pm 50$  percent of the original joint dimension.

### Maintenance

If sealant becomes damaged, cut out and replace the damaged portion with *Dow Corning 991 Silicone High Performance Sealant*

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## USABLE LIFE AND STORAGE

When stored below 27°C (80°F), *Dow Corning 991 Silicone High Performance Sealant* has a shelf life of 12 months from date of manufacture. Refer to product packaging for "Use By" date.

## PACKAGING

Prepigmented *Dow Corning 991 Silicone High Performance Sealant* is available in 20-oz (591-ml) sausages and 2-gallon (7.6-liter) pails.

## LIMITATIONS

This product is not intended for use:

- In structural glazing applications or where the sealant is intended as an adhesive
- In interior or shaded areas, *Dow Corning 991 Silicone High Performance Sealant* may yellow if not exposed to UV or sunlight; discoloration is most noticeable in light colors
- In areas where abrasion and physical abuse are encountered
- In spaces totally confined from atmospheric moisture during cure
- On frost-laden or damp surfaces
- For prolonged submersion in water
- On surfaces that might bleed oils, plasticizers or solvents – materials such as impregnated wood, oil-based caulks, green or partially vulcanized rubber gaskets, tapes, bitumen-impregnated boards, felts or sheets
- In below-grade applications
- On substrates made of polypropylene, polyethylene, polycarbonate and polytetrafluoroethylene (*Teflon*<sup>®1</sup>)
- Where movement capability greater than  $\pm 50$  percent is required

*Dow Corning 991 Silicone High Performance Sealant* will not improve pre-existing staining or residue

<sup>1</sup>*Teflon* is a registered trademark of E.I. du Pont de Nemours & Co.

rundown conditions. Surface appearance of any sealant will depend upon environmental conditions.

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

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## **DOW CORNING DISCLAIMS LIABILITY FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGES.**

20-year limited Weatherseal and Non-Staining warranties are available. Some testing may be required. Consult your Dow Corning Technical Service representative for details.