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Dow Quality Bond

Recommendations for gluing glazing units into window and door constructions made of PVC, aluminum and wood

Professional Dowsil sealants enable glazing units to be glued into constructions made of PVC, aluminum and wood. All elements in contact with adhesives should be pre-treated tested for adhesion and compatibility and approved for use.

Dowsil offers a full range of specialist silicone sealants for gluing glass panes into window and door frames. Below is a brief description of silicone sealants for these applications. These sealants are specially developed and intended for the structural bonding of windows and façades and cannot be used as sealants for structural glazing of façades or insulating glazing.

Silicone sealants for gluing windows into profiles

Dowsil 776 WB Instant Fix

Dowsil[®] 776 InstantFix WB is a one-component silicone adhesive specially developed for the bonding of windows and doors, in the process of continuous production cycle and for manual application. The material provides high initial bond strength immediately after application, which increases the productivity of the process.

Dowsil 776 InstantFix WB is a silicone that provides primerless adhesion to a wide range of common substrates used in the production of windows and doors. As a one-component silicone, it is perfect for manual applications as well as for fully automatic applications, ensuring excellent bonding durability and

Dowsil 994 Ultra Fast Cure Bonding

Dowsil[®] 994 Ultra Fast Bonding is a two-component, fast-setting structural silicone specially adapted for bonding in automatic window production. Odorless and non-corrosive, neutral, two-component silicone adhesive developed specifically for applications in gluing glazing units into window profiles (window bonding), where extremely fast curing and adhesion building is required.

The special formulation guarantees excellent and quick adhesion without the need to use primers for a number of surfaces such as glass, PVC, wood and aluminum.

The use of Dowsil 994 makes it possible to modify the setting time of the silicone by adjusting the mixing ratio in the range of 1:5 to 1:10 by weight and thus obtaining the appropriate time binding from 3 to 10 minutes.

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Cleaning and priming agents

Dowsil offers a range of cleaners and primers suitably formulated for use with Dowsil sealants. In some cases, it is required prior to application silicone sealant, the use of a suitable cleaner or primer in order to obtain optimal adhesion to the substrate.

Easy® to Clean / R-40

EASY® To Clean is a special solvent that improves the adhesion of the sealant or adhesive to the substrate for use in preparing the surface for sealing and bonding with the help of adhesive sealants. It is especially designed to clean non-porous surfaces from dust, grease, oil, fingerprints, etc.

Dowsil® Primer 1203 3 in 1

Dowsil® Primer 1203 3 in 1 is a cleaner and primer that also offers traceability under the influence of UV light. Improves and accelerates the adhesion of Dowsil silicone sealants to many substrates. The advantage of Dowsil Primer 1203 3 in 1 is the possibility of degreasing and priming the substrate with one product, which eliminates the risk of mistakes.

Surface preparation and sealant application

The main requirements for gluing glass with Dowsil sealants have been defined in surface preparation and sealant application procedures. Strict adherence to these procedures will ensure proper functioning of the sealant. Due to the fact that sealants are applied in different conditions, these procedures cannot constitute a complete and exhaustive programme quality assurance.

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For basic joint preparation and application procedures sealants include the following:

1. Cleaning

Joint surfaces must always be clean, dry, free of dust, rust and frost. Both the profile and the edge of the glass should be cleaned. Use the "two cloths" method which involves applying a small amount of Easy to Clean / R40/ Dowsil® Primer 1203 3 in 1 to the cloth. Wipe the surface with a damp cloth, and then with another clean and dry cloth, wipe the surface dry.



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2. Priming - only when required

If priming is required, the operation should be performed immediately after cleaning the profile. Glass should not be primed. Priming involves pouring a small amount of Dowsil[®] Primer 1203 3 in 1 onto a clean, lint-free cloth, then wipe the profile with a steady motion in one direction. Avoid applying too much Primer 1203 3 in 1. The quality of the primer application can be checked with a UV lamp.

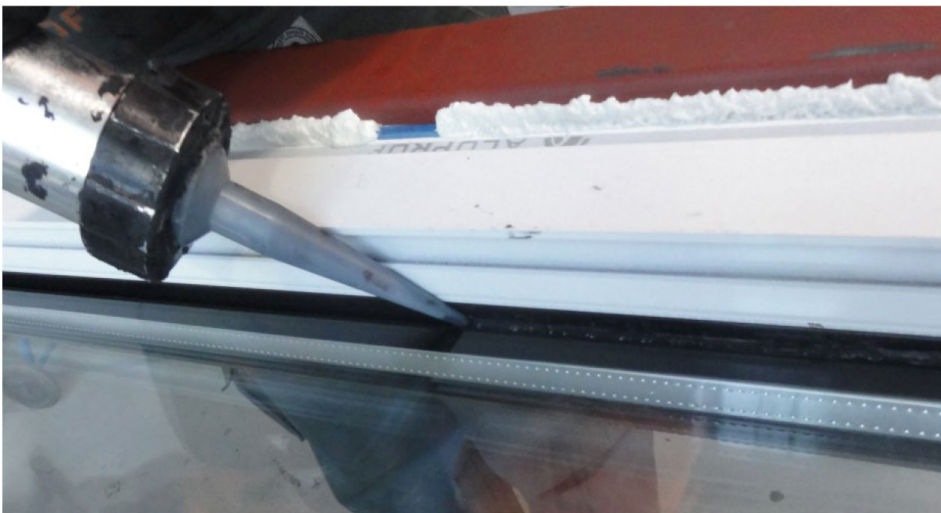


3. Filling

Glue the self-adhesive insulating inserts, filler cord or separating tape.

4. Application

Cut the tip of the applicator so that it can be placed in the recess of the connector. The adhesive should be applied within 2 hours from the moment of degreasing and priming the substrate.



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5. Machining

Press the sealant to completely fill the joint, ensuring adhesion and proper dimensioning of the connector.



6. Movement after gluing

Dowsil 776 InstantFix WB provides immediate initial adhesive strength. After application and bonding of the substrates, the material carries certain static and dynamic loads. yeah the immediate bonding strength is about 5 times greater than that of other structural silicones, which generally allows you to move and manipulate the freshly glued window sash. Full hardening takes several days, depending on the depth of the joint.

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7. Glass replacement / cutting out

If the glass needs to be replaced, the glass must be cut out using the appropriate tools. When cutting out the glass, leave a layer of approx. 2 mm of Dowsil 776 InstantFix WB silicone adhesive on the profile surface. Then degrease the remaining adhesive and the new glass as described in point 1 Cleaning. Then follow the steps described above.

