

DOW CORNING® 92-023

Primer

APPLICATIONS

- Primer for silicone adhesive/sealants, encapsulants and conformal coatings.
- Use with SYLGARD® 170, 182, 184, 186, SILASTIC® E, J.

TYPICAL PROPERTIES

Specification writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales representative prior to writing specifications on this product.

CTM*	ASTM*	Property	Unit	Value
		Color		Clear
		Viscosity at 25°C	mPa.s	0.7
0022	D792	Relative density at 25°C		0.72
		Flash point - closed cup	°C	-4
		Solvent		Heptane
0010		Non-volatile content - after 6 hours at 46°C	%	7

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

ASTM: American Society for Testing and Materials.

HOW TO USE

With most surfaces, substantially stronger and more uniform bonds are obtained by preparing them with a primer. For best results, these steps should be followed on all surfaces except silicone rubber.

1. Thoroughly clean and degrease the surface using a solvent (see Handling precautions) such as methyl ethyl ketone and a slightly abrasive pad or a coarse lint-free cloth.
2. Rinse all cleaning agents off the surface with acetone or methyl ethyl ketone. Allow the surface to dry.
3. Alternatively, aqueous degreasing with steam or hot water and appropriate additives can be used to effectively prepare surfaces. Rinse with demineralised water and allow to dry thoroughly. Ensure that no residues are left on the surface.
4. Apply a thin coat of DOW CORNING 92-023 Primer (see

Handling Precautions) by dipping, brushing or spraying.

A thin film primer will give best adhesion. Film thickness can be roughly estimated by colour, the thicker the film, the darker the red tint or the whiter the appearance (clear primer). If cracks appear in the film, too heavy a coat was applied. White dust or flakes on the surface also indicate too heavy a coating.

DOW CORNING 92-023 Primer can be diluted with solvent (see Handling Precautions) to achieve lighter coats by dipping or spraying (see typical properties for appropriate solvents). All solvents must be water free.

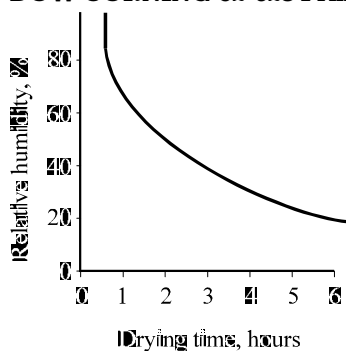
Allow the primer to dry 40 to 90 minutes at normal temperature and humidity conditions. Because the primer cures when in contact with air moisture, low humidity will

necessitate a longer drying time. The graph below will serve as a guide, although optimum conditions are best determined by experimentation.

Primer which was allowed to cure extensively will not promote adhesion. As a general rule, drying times of more than 6 hours at normal temperature and humidity conditions should be avoided.

Apply Dow Corning silicone adhesive/sealant encapsulant or conformal coating.

Effect of humidity on drying time of DOW CORNING 92-023 Primer.



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 SAFETY DATA SHEET IS AVAILABLE FROM YOUR LOCAL DOW CORNING SALES REPRESENTATIVE.

USABLE LIFE AND STORAGE

After the priming operation is completed, any remaining DOW CORNING 92-023 Primer should be returned to a sealable container as soon as possible for storage.

DOW CORNING 92-023 Primer hydrolyses upon contact with atmospheric moisture, and prolonged exposure will reduce or destroy its effectiveness. Keep containers tightly sealed and avoid keeping partially

filled containers of primer for long periods of time. If necessary transfer the primer to a smaller container.

A slight cloudiness often develops in the primer during storage, but this does not necessarily indicate impaired efficiency. If hydrolysis is extensive, precipitation will result.

DOW CORNING 92-023 Primer then assumes a milky appearance. Such materials should be checked on a test panel to determine whether they will still promote adhesion. If adhesion is poor, the primer should be discarded. Once hydrolysed, the material cannot be reclaimed, and will contaminate any unreacted primer with which it is mixed.

When stored at or below 30°C in the original unopened containers, this product has a usable life of 18 months from the date of production.

PACKAGING

This product is available in 500cc containers.

LIMITATIONS

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 Health, Environment and Regulatory Affairs specialists available in each area.

For further information, please consult your local Dow Corning representative.

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. 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. Unless Dow Corning provides you with a specific, duly signed endorsement of fitness for use, Dow Corning disclaims liability for any incidental or consequential damages. Suggestions of use shall not be taken as inducements to infringe any patent.