

Structural glazing repair kit

Cartridge system preparation guide

EMEA

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Introduction

DOWSIL™ 993 Structural Glazing Repair Kit is a two-part, neutral cure RTV silicone sealant for fast and efficient repair or new installation of structurally glazed units in shop or on site.

This guide provides step-by-step instructions on the correct system preparation of the DOWSIL™ 993 Structural Glazing Repair Kit when used in conjunction with the Powerpush 7000 Mixpack Dispenser battery application gun from Meritool.

Kit solution components

Cartridges

- Side-by-side cartridges containing standard DOWSIL™ 993 Structural Glazing Sealant two component base and catalyst
- Volume 675ml, base to catalyst volume ratio 8 to 1
- Weight of the filled cartridge: 1.05kg

Static mixer

- Sulzer MGQ high flow mixer with extended tube including 9 mixing elements



Approved gun solutions

1. Battery gun

- Powerpush 7000 Mixpack Dispenser, 675ml 8:1
- With 20V Li-Ion battery
- Weight of the gun: 3.20kg

NB: Before using the Powerpush 7000 Mixpack Dispenser battery application gun, please read, understand and save all safety information and instructions in the manual provided with the gun.



2. Pneumatic gun

- DISPENSER COX PPA 675ml 8:1
- Power: 5.25 kN,
- Air supply: 6.80 bar
- Weight of the gun: 3.30kg

DISPENSER COX PPA 675ml 8:1

System preparation in 8 easy steps

1. Visual inspection

Visually check that the DOWSIL™ 993 Structural Glazing Repair Kit cartridges are not damaged or cracked and that the product is within its stated shelf life.



2. Cartridge preparation

Remove the cap from the top of cartridge then remove the plugs from the dispensing end of the cartridge.



3. Gun preparation

To insert the cartridge, pull back the clutch lever on the battery application gun and pull the dual gun racks completely back.



Insert the DOWSIL™ 993 Structural Glazing Repair Kit cartridges into the cartridge retainer. The cartridges should snap into the gun so that the ends of the cartridges are aligned with the dual gun racks and pistons.



Once the cartridge is inserted, gently push the dual gun racks until the pistons touch the cartridge plungers, then close the clutch lever.



4. *Speed and dosing*

Adjust “SPEED” and “DOSE” to level 3.



5. *Pre-extrude without nozzle*

The two-component sealants must be extruded prior to attaching the static mixer for **15 seconds**. This action will verify that materials are equally dispensed and also help eliminate any catalyst separation that can occur during long term storage of cartridges. This step is very important to ensure a proper application.



6. Attach nozzle

Attach a new static mixer to the cartridge



Important: Do not remove extension tube of the mixer or mixing elements. Do not reuse static mixers after application with a second cartridge.



7. Speed and dosing for application

Select gun "SPEED" level 3 (maximum volume output) for the application.
 Select "DOSE" level 1 for continuous application.



Important: Do not exceed level 3 for speed.

"Off" position	LOW output force	Recommended output force	NOT ALLOWED	NOT ALLOWED
1	2	3	4	5
SPEED				

Continuous flow	7 Seconds flow	15 Seconds flow	21 Seconds flow	30 Seconds flow
1	2	3	4	5
DOSE				

8. Extrude material

Check mixing quality with butterfly test



Proper mixing



Insufficient mixing

The DOWSIL™ 993 Structural Glazing Repair Kit is now ready to use.



Quality control

For detailed quality control procedures, please refer to the Dow Silicone structural glazing manual EMEA1.

Frequency of quality control tests

Frequency of test				
Sealant production quality control test	After each change of cartridge	After each change of cartridge box	After each cartridge batch number	After each substrate batch number
Snap time test	Not required	Not required	1 test per batch and per day	Not required
Butterfly test	Not required	1 test per box	1 test per batch and per	Not required
Peel test	Not required	Not required	1 test per sealant batch	1 test per substrate batch
Deglaze test	Deglazing should be project related, depending on element numbers, size, and complexity, to be defined before production start. During site application and reparation, deglazing is not possible, so it's very important to ensure that the peel testing is carried out correctly.			

For more information

Learn more about Dow's full range of High Performance Building solutions by visiting us online at dow.com/highperformancebuilding.

Dow has sales offices, manufacturing sites and science and technology laboratories around the globe. Find local contact information at dow.com/contactus.



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