

WACKER® PRIMER G 791 A/B

PRIMER FOR SILICONE ELASTOMERS

Product description

WACKER® PRIMER G 791 A/B is a two-component, addition-curing priming system diluted in an organic solvent. The primer is applied to the substrate and after curing forms a primer film which firmly adheres to the substrate. Application of a silicone rubber onto the primed substrate and subsequent vulcanization will then result in a tight bond between the silicone rubber and the substrate.

Application

Bonding agent preferably used for bonding addition-curing silicone rubbers onto vulcanized, addition-curing rubbers (e.g. WACKER® ELASTOSIL® RTV-2, LSR and R plus or WACKER® POWERSIL® RTV-2 and LSR). WACKER® PRIMER G 791 A/B is especially suited for bonding addition-curing POWERSIL® XLR® 630/640 onto vulcanized silicone rubber of the same grade.

Processing

Surfaces to be primed have to be dry and free from grease, oil, wax, dust, rust or other contaminants. Also mold-release agent from the previous vulcanization cycle on the silicone rubber substrate has to be removed. The surface should be cleaned, e.g. with a non-polar solvent such as mineral spirits (boiling range between 80 °C and 140 °C), followed by a polar solvent, such as acetone. Very smooth surfaces may be roughened by grinding until the shine of the surface disappears. Loose particles must be removed.

Components A and B must be homogenized before use. A and B are mixed in a ratio of 1:1 by weight. The pot life of the catalyzed primer mixture is 2 – 3 days at room temperature and can be prolonged by cooling to approx. 1 week at 6 °C. Storage must be in properly sealed containers.

WACKER® PRIMER G 791 A/B is applied in a thin film layer with a brush, by dipping or spraying. The primer film has to be vulcanized for 20 – 60 minutes at 100 – 120 °C.

The silicone rubber should be applied to the primed surface soon after the heating process, if possible. It is recommended that this is done not later than approximately 2 days after priming the substrate. Otherwise a drop in adhesive strength may occur. Prior to the application of the silicone rubber, the primed surface has to be kept free of contaminations.

Important

Initial adhesion directly after vulcanization of the rubber will in many cases be high already. In some cases, however, initial adhesion will be sufficient for handling the composite while maximum adhesive strength will only be achieved after about 4 days. Additional post curing of the cured rubber at 70 °C – 150 °C will further improve adhesion. Once opened, containers of WACKER® PRIMER G 791 A/B should be kept well sealed and stored in a cool and dry place.

For detailed information, refer to brochures on www.wacker.com.

Storage

The 'Best use before end' date of each batch is shown on the product label.

Storage beyond the date specified on the label does not necessarily mean that the product is no longer usable. In this case however, the properties required for the intended use must be checked for quality assurance reasons.

Safety notes

Due to its high content of organic solvent, WACKER® PRIMER G 791 A/B is subject to the same safety regulations as these i.e., it is a flammable liquid. Appropriate precautions are an absolute must.

Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from WACKER subsidiaries or may be printed via WACKER web site <http://www.wacker.com>.

Product data

Typical general characteristics	Inspection Method	Value
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Product data (uncured)**Component A**

Color		opaque to whitish
Viscosity at 25 °C	Brookfield	4000 mPa s
Density at 25°C at 1013 hPa	DIN 51757	0,77 g/cm ³
Flash point	ISO 13736	-4 °C
Ignitation temperature (liquids)	EN 14522	391 °C

Component B

Color		clear, yellowish
Viscosity at 25 °C	Brookfield	85 mPa s
Density at 25°C at 1013 hPa	DIN 51757	0,73 g/cm ³
Flash point	ISO 13736	3 °C
Ignitation temperature (liquids)	EN 14522	378 °C

Product data (catalyzed A + B)

Active substance content		approx. 20 wt-%
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These figures are only intended as a guide and should not be used in preparing specifications.

The data presented in this medium are in accordance with the present state of our knowledge but do not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this medium should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. The information provided by us does not absolve the user from the obligation of investigating the possibility of infringement of third parties' rights and, if necessary, clarifying the position. Recommendations for use do not constitute a warranty, either express or implied, of the fitness or suitability of the product for a particular purpose.

The management system has been certified according to DIN EN ISO 9001 and DIN EN ISO 14001

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For technical, quality, or product safety questions, please contact:

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