

DOW CORNING

PMS Process

Dow Corning

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**Global Construction
STRENGTH**

Drawing Review

- Required Information
 - Drawings (Elevation, Horizontal/Vertical Section Details)
 - Specified Loads
 - Specified Movements
 - Specified Tolerances



Project Details

Adhesion, Compatibility & Stain Testing



Request for
Testing

- Specimen size
 - Adhesion Testing: 100mm × 200mm (2 ea)
 - Compatibility Testing: 300mm long
 - Stain Testing: 25mm × 25mm × 75mm (2 ea)

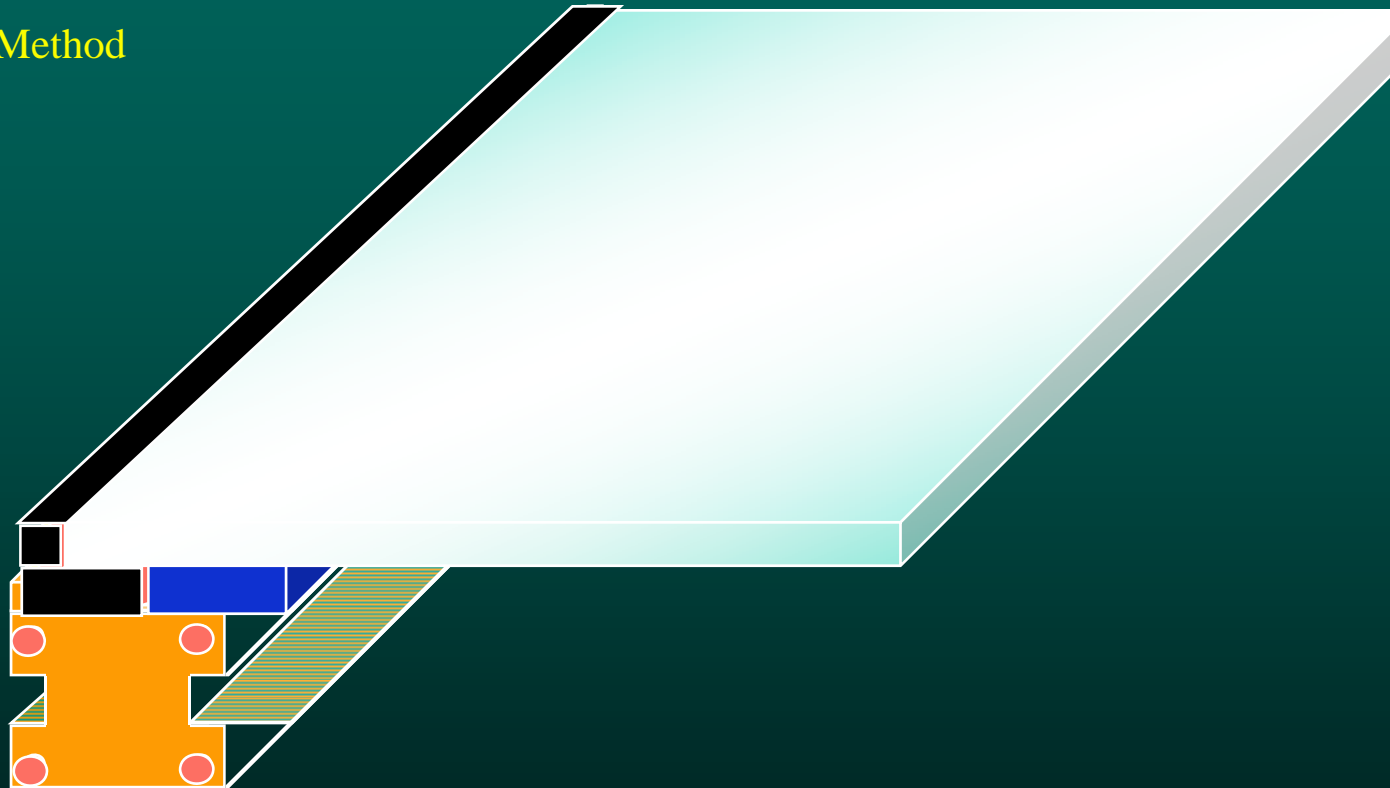
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Field Training

- Appropriate Sealant Application
- Field Quality Assurance

Cleaning, Priming, Glazing

1. Screw Heads Sealing
2. Clean surface of substrate with 2 Cloth Method
3. Apply Primer if required
4. Apply Spacer Tape
5. Install Setting Block at every 1/4 point
6. Install Panel
7. Apply Masking Tape
8. Apply Sealant
9. Tooling
10. Remove Masking Tape
11. Protect Sealant till full curing



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Field Quality Assurance (1-part)

- Skin-Over Time / Elastomeric Testing
 - Make Sealant Slab(1mm thickness)
 - Check Sealant surface every 5 minutes
 - Check elastomeric property after 24h cure
 - Record the result in the Product Quality Control Log (1-part)



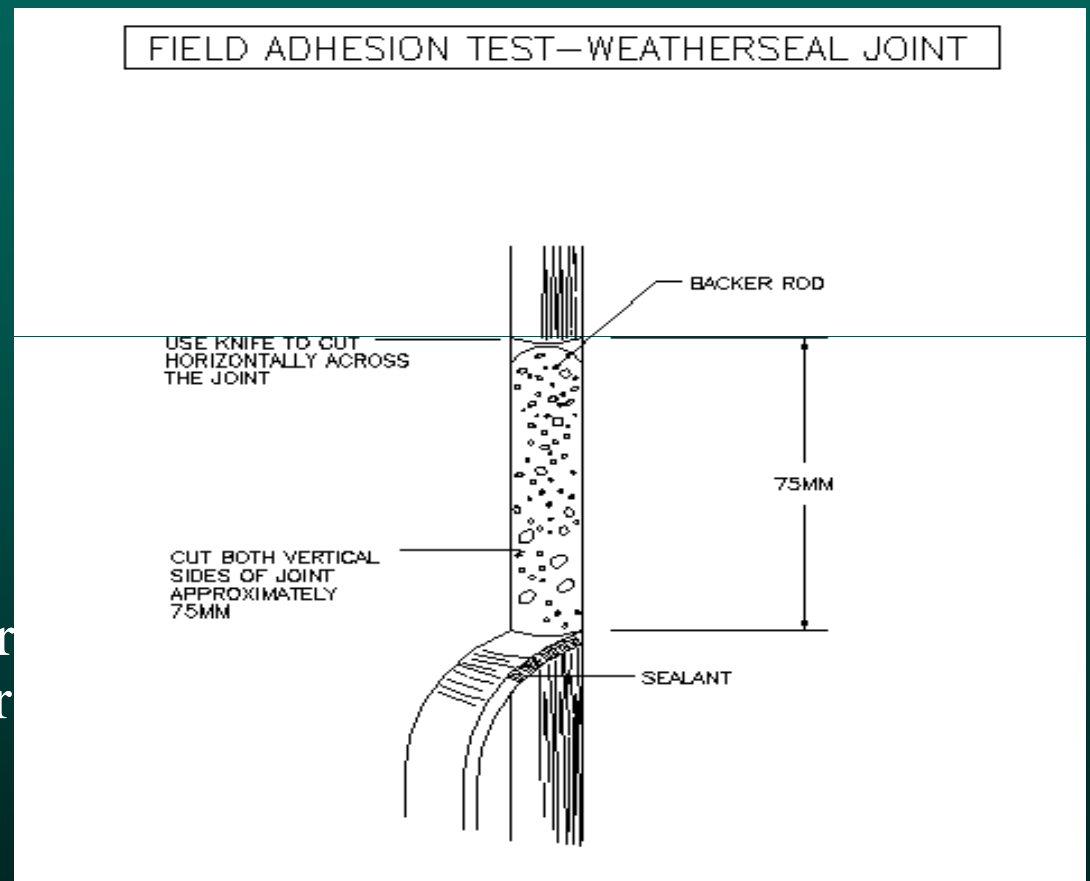




Field Quality Assurance (1-part)

- Field Adhesion Test

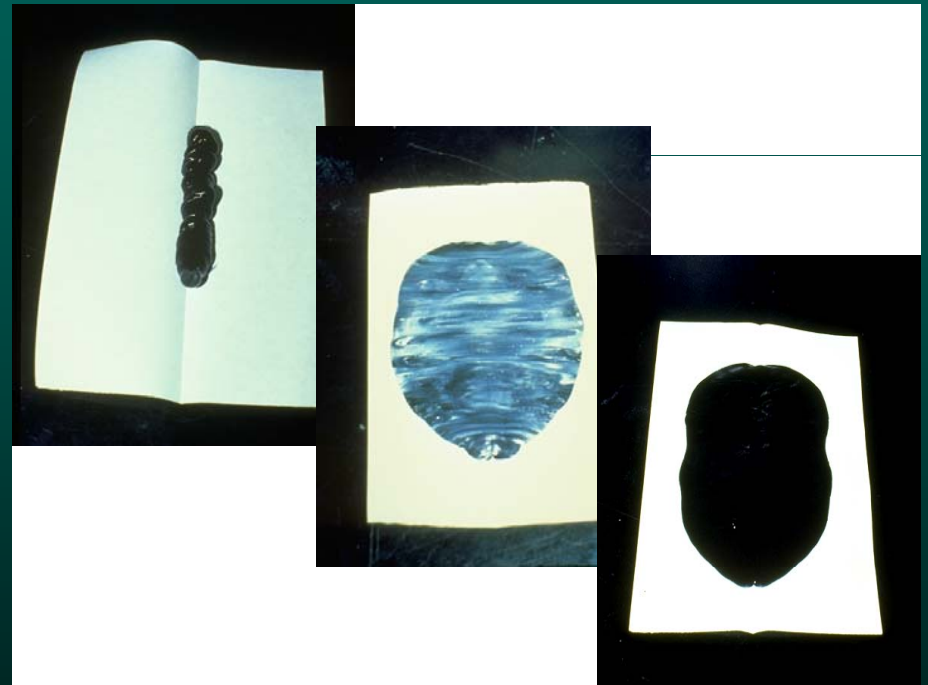
- Allow sealant cure in a joint for 7 ~ 21 day
- 10 Test for first 300m
- 1 Test for every 300m or for every floor thereafter
- Record the result in the Field Adhesion Testing Log (1-part)



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Field Quality Assurance (2-part)

- Butterfly Test
 - Apply mixed 2-part sealant on a paper
 - Inspect the sealant smear formed after folding and unfolding the paper
 - Record the result in the Product Quality Control Log (2-part)



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Field Quality Assurance (2-part)

- Snap Time

- Fill a small container with mixed 2-part sealant
- Place a stick in the sealant and note the time
- Every 5 to 10 minutes, pull on the stick
- Standard Snap Time is 40 minutes at which base to catalyst ratio is 12 to 1 by weight



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Field Quality Assurance (2-part)

- Deglazing
 - Cut sealant around fabricated unit and inspect required sealant Bite, Glue thickness, adhesion and joint fill
 - Frequency
 - 1 for first 10 units
 - 1 for next 40 units
 - 1 for next 50 units
 - 1 for every 100 units thereafter
 - Record the result in the Deglazing Report

Deglazing



Good adhesion and joint fill



Bad adhesion

