



Technical Data Sheet

DOWSIL™ 121 Structural Glazing Sealant

Fast-curing, two-part, neutral-cure, RTV silicone sealant for use in structural and weatherseal applications.

Features & Benefits

- Approved for structural and weatherseal applications¹
- High level of mechanical properties
- Structural capability
- Odorless and non-corrosive cure
- Excellent stability through wide temperature range: -50°C to 150°C
- Stable viscosity for base and catalyst, no heating required
- The cured product exhibits excellent weathering characteristics, and a high resistance to ultra-violet radiation, ozone, heat and humidity
- Primerless adhesion to alodine and anodized aluminum²
- Adhesion to DOWSIL™ structural sealants for reglazing applications
- Adhesion and structural strength achieved in 24–48 hours
- Meets ASTM C 719 Class 25 (G, A, O)
- Meets ASTM C1184 Structural Sealant Specification

¹All structural glazing applications MUST be reviewed by the Dow technical staff. If their recommendations are followed, Dow will issue a project-specific adhesive warranty.

²Certain sealing materials used in the anodizing process may increase the potential for use of primer to gain adhesion within a 24-hour period. DOWSIL™ Primer-C OS is recommended for fast and consistent adhesion, especially to Kynar, polyester powder coat and other high-performance substrates approved for architectural structural glazing applications.

Applications

- Repair and/or replacement of structurally glazed glass and other substrates where a fast cure is required
- On-site structural glazing, including storefront systems
- Attachment of panel stiffeners where quick cure is required
- In-shop structural glazing where the use of a two-part pump is not viable

Typical Properties

Specification Writers: These values are not intended for use in preparing specifications.

Test ¹	Property ²	Unit	Result
As Supplied – As Tested at 23°C (75°F) and 50% RH			
	Color		
	Base		Black/dark gray
	Catalyst		White
	Physical Form		Paste
ASTM D1475	Specific Density		
	Base	kg/l	1.35
	Catalyst	kg/l	1.24
As Catalyzed – Mixed at 1:1 Base to Catalyst by Volume			
	Working Time	minutes	15–45
	Unit Handling Time at 23°C (75°F), Minimum ³	hours	min 24 ⁴
	VOC Content, Mixed ⁴	g/L	< 25
ASTM D2202	Flow/Sag (Slump)	inches (mm)	< 0.2 (< 5)
Cured – After 1 Day at 75°F (23°C) and 50% RH			
ASTM C661	Durometer, Type A	points	30
ASTM D412	Tensile Strength	psi (MPa)	300 (2.1)
ASTM C1135	Tensile Strength at 25%	psi (MPa)	26 (0.18)
ASTM C1135	Tensile Strength, Ultimate	psi (MPa)	74 (0.62)
ASTM C1135	Elongation, Ultimate	%	300
Cured – After 7 Days at 75°F (23°C) and 50% RH			
ASTM C661	Durometer, Type A	points	30–40
ASTM D412	Tensile Strength	psi (MPa)	300 (2.1)
ASTM C1135	Tensile Strength at 25%	psi (MPa)	40 (0.28)
ASTM C1135	Tensile Strength, Ultimate	psi (MPa)	135 (0.93)
ASTM C1135	Elongation, Ultimate	%	325
ASTM C 719	Movement Capability	%	±25

1. ASTM: American Society for Testing and Materials.
2. All testing was conducted using an 18-element, ½ inch (1.3 cm) diameter static mixer and a pneumatic two-part gun operating at 87 psi (6 bar).
3. Adhesion must be confirmed prior to removing temporary attachments or shipping to the job site. In general terms, glazed units can be moved or temporary attachments removed within 24 hrs depending on the temperature and relative humidity (RH). DOWSIL™ 121 Structural Glazing Sealant can achieve the necessary strength and adhesion properties in 24 hours when applied and cured at 23°C and 50% RH. Check adhesion before moving units.
4. Based on South Coast Air Quality Management District of California. Maximum VOC is listed both inclusive and exclusive of water and exempt compounds.

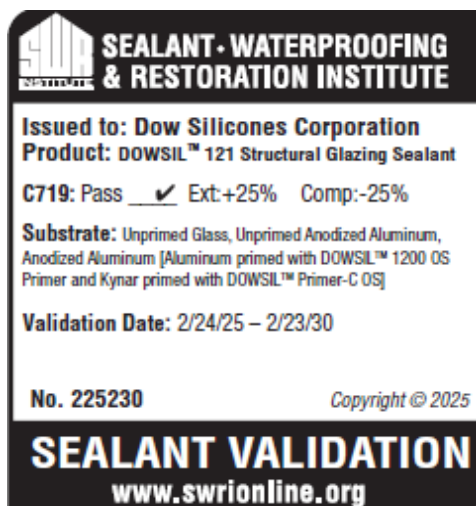
Description

DOWSIL™ 121 Structural Glazing Sealant is a two-part silicone formulation designed specifically for use in structural glazing applications in field and factory applications. The material is supplied in a two-part cartridge in which the catalyst is a smooth, white paste and the base is tinted either black or gray. Once catalyzed, the material cures into a medium-modulus, flexible silicone rubber that is flexible for use in structural and weatherseal applications. It can be used in deep, narrow joints to obtain a complete cure.

DOWSIL™ 121 Structural Glazing Sealant cures in deep section within 24 hours and generally achieves full adhesion within 48 hours. However, full cure time depends on joint design, substrate type, temperature and humidity.

How to Use

Complete design and installation guidelines are contained in the Americas Technical Manual, European Silicone Structural Glazing Manual, DOWSIL™ 121 Structural Glazing Sealant Installation Guide, and the DOWSIL™ 121 Structural Glazing European Application Guide. They must be followed for warrantable applications when using this product.



Preparation

Clean all joints and glazing pockets, removing all foreign matter and contaminants such as grease, oil, dust, water, frost, surface dirt, old sealants or glazing compounds and protective coatings.

In reglazing applications where the structural sealant is performing per specification, a thin (less than 1/16 inch) layer of the existing DOWSIL™ sealant should remain on the substrate. DOWSIL™ 121 Structural Glazing Sealant will achieve primerless adhesion to the cured sealant.

Application

Install backup material or joint filler, setting blocks, spacer shims, and tape. Mask areas adjacent to joints to ensure clean sealant lines.

DOWSIL™ 121 Structural Glazing Sealant curing agent and base must be thoroughly mixed using an airless mixing system. DOWSIL™ 121 Structural Glazing Sealant is compatible with most existing pneumatic dispensing tools that accommodate 2 x 200 ml cartridges.

The air pressure used to dispense the material should be limited to 90 psi (6 bar) to ensure a good mix and to prevent damage to the sealant cartridge.

How to Use (Cont.)**Application (Cont.)**

Remove the attached plug of the cartridge by following the instructions in the Installation Guide; do NOT cut it off. Insert the cartridge into the pneumatic and/or battery dispensing tool and run material out of the cartridge to ensure that both base and catalyst are being extruded. Then, attach a new static mixer to the cartridge, and the material is ready for use.

Eighteen-element static mixers are included in the packaging and are required to mix the material. A new static mixer must be used for each cartridge to ensure proper mixing of the material. Neither hand-mixing nor mechanical mixing is satisfactory due to the incorporation of air, resulting in altered physical properties.

**Handling
Precautions**

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. 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 ON THE DOW WEBSITE AT DOW.COM, OR FROM YOUR DOW SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CUSTOMER SERVICE.

**Usable Life and
Storage**

When stored in original, unopened containers in a dry location below 30°C (86°F), DOWSIL™ 121 Structural Glazing Sealant has a shelf life of 12 months from date of manufacture. Refer to product packaging for “Use By” date.

**Packaging
Information**

DOWSIL™ 121 Structural Glazing Sealant is available in kits of 400 ml net fill (2 x 200 ml)/13.5 fl. oz. net fill (2 x 6.8 fl. oz.) cartridges.

Limitations

DOWSIL™ 121 Structural Glazing Sealant should not be applied:

- To building materials that bleed oils, plasticizers or solvents – materials such as impregnated wood, oil-based caulks, green or partially vulcanized rubber gaskets, and tapes
- On surfaces that will require painting or staining
- Once the air temperature falls below 0°F (-18°C)
- On frost-laden or wet surfaces
- In areas where abrasion and physical abuse are encountered
- In below-grade or continuous water immersion applications
- To surfaces that will be in direct contact with food

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 has an extensive Product Stewardship organization and a team of product safety and regulatory compliance specialists available in each area.

For further information, please see our website, dow.com or consult your local Dow representative.

Disposal Considerations

Dispose in accordance with all local, state (provincial) and federal regulations. Empty containers may contain hazardous residues. This material and its container must be disposed in a safe and legal manner.

It is the user's responsibility to verify that treatment and disposal procedures comply with local, state (provincial) and federal regulations. Contact your Dow Technical Representative for more information.

Product Stewardship

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products - from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

Customer Notice

Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support. Dow product literature, including safety data sheets, should be consulted prior to use of Dow products. Current safety data sheets are available from Dow.

dow.com

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