

DOW CORNING

Paints & Inks
Solutions

Additive Selection Guide

a little makes a big *splash!*

WITH **ADDITIVES** FROM DOW CORNING



KRAYDEN, INC.

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1-800-448-0406

A Little Makes a Big Splash!

It takes only a little of a *Dow Corning*[®] brand additive to make the significant performance difference your customers demand from your paint, ink and coating formulations. *Dow Corning* additives provide problem-solving performance.

- Use in waterborne or solventborne formulations
- Compatible with virtually any binder system
- High efficiency at low concentration levels to help lower raw materials costs
- Suitable for use in low VOC, sustainably formulated products
- Formulated for versatility and ease of use

Problem-Solving Performance

For more than half a century, Dow Corning has led the way in silicon-based technology and is a global leader in the development of problem-solving, silicon-based technologies for paints, inks and coatings. Many

Dow Corning additives impart a combination of benefits, giving you a high benefit-to-cost ratio. Whether you need foam control; improved pigment dispersion, surface wetting leveling or adhesion; water resistance, mar resistance, slip, gloss, texturization or any combination, silicon-based technology from Dow Corning can help you achieve it.

Global Resources, Local Expertise and Support

With global manufacturing facilities, sales offices, research and development laboratories, and Technical Information Centers all linked to a worldwide

network of expert local distributors, Dow Corning is able to provide you with an exceptional level of service, support and value. Dow Corning is known for outstanding technical support. Our team of experts will work hand-in-hand with yours to ensure your success with these amazingly versatile materials.

How to Use This Guide

This guide will help you explore the properties and performance capabilities of Dow Corning's global line of additives for paints, inks and coatings. Table 1 offers additive suggestions for use in a variety of delivery systems and resins. First, from the left-hand column, select the delivery system and resin you plan to use. Then, simply follow that row across to the column for the benefit you wish to achieve. In the box where the two intersect, you will find suggested additives for your application. Table 2 groups the additives by their primary benefit and describes their physical makeup, features, secondary benefits and properties.

About Concentrations and Blending

The amount of *Dow Corning* additive required to achieve a particular benefit depends on the type of formulation, the solvent it contains, the resin system and total system solids. Generally, *Dow Corning* additives are effective at the concentrations noted in Table 2. Since advantages do not increase proportionally, avoid using excessive amounts. *Dow Corning* additives are usually added during grind, let-down or are post-added. However, some may be added during any processing stage. See Table 2 for additional information.

dowcorning.com/coatings gives you immediate access to:

- Product samples
- Product literature and technical data sheets
- Technical articles
- Customer service
- The name of a technically knowledgeable Dow Corning distributor near you



Table 1. Additives Application Guide¹ (For additional products, please see Table 2.)

Benefit ▶									
System/Resin	Slip	Mar Resistance	Foam Control	Adhesion Promotion	Pigment Treatment	Water Resistance	Leveling/Wetting	Gloss	Texturing
Waterborne	51	51	62	OFS-6020*	OFS-6020*	84	67	28	33
	52	14	65	OFS-6011*	OFS-6011*	85	57	51	
	57	52						52	
Acrylic		51	62	Z-6137	57	51	67	28	
		HV 495	65	OFS-6020*	OFS-6020*	85	57	51	
		52		OFS-6040*				52	
Alkyd	57	57	65	OFS-6020*	57	84	67		
	14	51		OFS-6040*	OFS-6040*	85	28		
		52					57		
Epoxy	51	18	65	Z-6137	Z-6032	84	67		
	52	51	7	OFS-6020*	OFS-6020*	85	14		
	57	52		OFS-6040*			57		
Polyester	51	18	65	OFS-6020*	OFS-6020*	84	67		
	52	54	163	OFS-6011*	OFS-6011*	85	14		
	54	52		OFS-6040*			57		
Polyurethane	14	51	65	Z-6137	OFS-6020*	84	67	57	
	51	52	163	OFS-6020*	OFS-6011*	85	57	51	
	52	14	73	OFS-6040*				52	
Vinyl	14	51	65	OFS-6020*		84	67		
	51	52	163			85	28		
	52	14					57		
Solventborne	14	57	7	Z-6121	3		3	29	23N
	11	11	163	OFS-6040*	57		57	54	
Acrylic	11	11	7	OFS-6040*	3		3	54	23N
	14	57	163	OFS-6020*	57		57	54	
Alkyd	14	11	7	Z-6121	3		3	23N	
	11	56	56	OFS-6040*	OFS-6040*		7		56
Amide	19	11	7	OFS-6011*	3		19		
	11		Antifoam A	OFS-6040*	57		57		
Epoxy	11	57	7	Z-6121	57		11	23N	
	14	11	163	OFS-6040*	3		57		
Nitrocellulose	14	11	7				56	29	
	11	57	65				11		
Phenolic	14	14	65	OFS-6020*	57		57		
				OFS-6040*	OFS-6020*				
Polyester	14	11	65	Z-6121	57		57	29	23N
	11	14	7	OFS-6040*	3		29	57	
Polyurethane	11	11	7	OFS-6040*	57		11	23N	
	57	54	163	OFS-6030*	OFS-6040*		57		
Vinyl	14	14	7	OFS-6040*	3		57	23N	
	11	11	163	OFS-6020*	OFS-6030*		54		
Radiation-Cured		14	163	OFS-6030*			57	23N	
		11	Antifoam A	OFS-6040*			29		

¹All products are *Dow Corning*[®] brand, except those noted with an asterisk (*), which are XIAMETER[®] brand.



Table 2. Features, Typical Use and Properties of Additives from Dow Corning¹¹ (Products are listed under their primary benefit.)

Product	Description	Features/Benefits	Compatible Binder Systems	Point of Addition	Typical Concentration ²¹	Suitable Diluents ²¹	Reactive Groups	Solvent	Flash Point, closed cup	Viscosity at 25°C (77°F), cSt	Shelf Life, months ²¹	Food Contact Compliance ²¹
Slip, Mar Resistance												
<i>Dow Corning</i> [®] 11 Additive	Silicone polyether copolymer; 10% active in toluene	Increases mar resistance; also improves leveling, gloss, wetting, and prevents pigment separation	Acrylic, alkyd, amide, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.1-0.5%	Aromatics such as xylene or toluene; mineral spirits or ketones	Carbinol	Toluene	7°C (45°F)	1.5	36	–
<i>Dow Corning</i> [®] 14 Additive	Silicone polyether copolymer; 10% active in isopropanol	Improves slip and mar resistance; provides leveling and gloss	Acrylic, alkyd, epoxy, polyester, polyurethane	Grind or let-down or post add	0.1-0.5%	Water, alcohols, hydrocarbons	Carbinol	Isopropanol	10°C (50°F)	4	30	–
<i>Dow Corning</i> [®] 18 Additive	Dispersion of high molecular weight polydimethylsiloxane and silicone surfactant; 100% active	Provides high degree of slip, mar resistance and anti-blocking	Acrylic, alkyd, epoxy, polyester, polyurethane, vinyl	Let-down or post add	0.1-1.0%	Polar solvents, including water, alcohols, ketones	None	None	168°C (334°F)	400,000	21	–
<i>Dow Corning</i> [®] 19 Additive	Silicone polyether copolymer; 100% active	Imparts mar resistance and anti-blocking; improves leveling and substrate wetting	Amide, epoxy, nitrocellulose, polyurethane	Grind or let-down	0.1-1.0%	Water or alcohols	None	None	63°C (145°F)	1,750	18	–
<i>Dow Corning</i> [®] 28 Additive	Silicone polyether copolymer; 100% active	Improves slip and mar resistance; provides leveling and gloss	Acrylic, alkyd, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.1-1.0%	Water, alcohols or aromatics	Carbinol	None	99°C (210°F)	425	30	–
<i>Dow Corning</i> [®] 29 Additive	Silicone polyether copolymer; 100% active	Imparts mar resistance and anti-blocking; also improves leveling and wetting	Acrylic, epoxy, polyester, polyurethane	Grind or let-down or post add	0.1-1.0%	Water, alcohols or aromatics	Carbinol	None	67°C (153°F)	310	30	–
<i>Dow Corning</i> [®] 51 Additive	Dispersion of high molecular weight polysiloxane and surfactants; 80% active in water	Improves mar resistance and slip to systems with water-based emulsions; also effective in solvent-borne coatings containing alcohol or polar solvents	Acrylic, alkyd, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.05-0.3%	Polar solvents, including water and alcohols	Silanol	Water	>101°C (>214°F)	500,000	18	FDA 175.105, 176.180, 176.210
<i>Dow Corning</i> [®] 52 Additive	Dispersion of high molecular weight polysiloxane and surfactants; 64% active in water	Imparts mar resistance and slip to systems with water-based emulsions; also effective in solvent-borne coatings containing alcohol or polar solvents	Acrylic, alkyd, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.01-3.5%	Polar solvents, including water and alcohols	Silanol	Water	>101°C (>214°F)	4,000	12	FDA 176.210
<i>Dow Corning</i> [®] 54 Additive	Silicone polyether copolymer; 100% active	Provides mar resistance, slip, leveling and gloss; aids defoaming in some systems	Acrylic, alkyd, epoxy, polyester, polyurethane, vinyl	Let-down or post add	0.05-1.0%	Aromatics such as xylene or toluene, mineral spirits and chlorinated hydrocarbons	Carbinol	None	>101°C (>214°F)	170	30	–
<i>Dow Corning</i> [®] HV 495 Emulsion	Silicone emulsion; 37% active	Provides slip and mar resistance	Acrylic, epoxy, polyester, polyurethane	Let-down or post add	0.05-0.5%	Water	Silanol	Water	>101°C (>214°F)	10	18	FDA 175.105, 176.180, 176.200, 176.210

(continued on pages 5, 6, 7)



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Table 2. Features, Typical Use and Properties of Additives from Dow Corning[®]

Product	Description	Features/Benefits	Compatible Binder Systems	Point of Addition	Typical Concentration ⁽²⁾	Suitable Diluents ⁽³⁾	Reactive Groups	Solvent	Flash Point, closed cup	Viscosity at 25°C (77°F), cSt	Shelf Life, months ⁽⁴⁾	Food Contact Compliance ⁽⁵⁾
Foam Control												
<i>Dow Corning[®]</i> 7 Additive	Fluorosilicone; 5% active in methylisobutyl ketone	Provides foam prevention and defoaming	Acrylic, alkyd, amide, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.01-0.05%	Ketones	None	Methyl-isobutyl-ketone	12°C (54°F)	0.8	18	FDA 177.2600
<i>Dow Corning[®]</i> 62 Additive	Silicone emulsion; 57% active in water	Provides effective foam control in inks and coatings; good compatibility and low tendency to cause defects; APEO-free	Acrylic, polyurethane	Grind or let-down or post add	0.05-0.5%	Water	None	Water	>101°C (>214°F)	2,000	18	FDA 175.105, 176.210, BFR XXXVI
<i>Dow Corning[®]</i> 65 Additive	Silicone emulsion; 59% active in water	Prevents and eliminates foam in high-shear mixing processes; long-term defoaming action	Acrylic, alkyd, amide, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.05-0.5%	Water	None	Water	>101°C (>214°F)	2,000	24	-
<i>Dow Corning[®]</i> 71 Additive	Organo-modified silicone copolymer; 100% active	Effective foam control in water-borne coatings, especially ink; balancing effective foam control and good surface appearance	Acrylics	Grind or let-down or post add	0.1-1.0%	Water	None	None	>100°C (>212°F)	500	24	FDA 175.105, 175.300 ⁽⁶⁾ , 175.320 ⁽⁶⁾ , 176.200 ⁽⁶⁾ , 176.210 ⁽⁶⁾ , BFR XV, EU 2002/72/EC
<i>Dow Corning[®]</i> 73 Additive	Silicone emulsion; 10% active in water	Excellent persistency; stable over a wide pH range; good performance in dispersion paints	Acrylic emulsion, polyacrylate PU-modified systems	Grind or let-down or post add	0.1-1.0%	Water	None	None	>100°C (>212°F)	1,500	12	-
<i>Dow Corning[®]</i> 74 Additive	Organo-modified silicone copolymer; 100% active	Effective foam control in water-borne coatings, especially wood coatings; balancing effective foam control and good surface appearance	Acrylics	Grind or let-down or post add	0.1-1.0%	Water	None	None	>100°C (>212°F)	750	24	FDA 176.210
<i>Dow Corning[®]</i> 76 Additive	Organo-modified silicone; silica-free; 20% active in dipropylene glycol monomethylether	Effective, low-cost foam control for waterborne printing applications; wood, protective and plastic coatings; does not influence gloss or cause surface defects	Acrylics	Grind or let-down or post add	0.1-1.5%	Water	None	Dipropylene-glycol mono-methyl ether	75°C (167°F)	45	24	FDA 175.105, 176.170, 176.180, 176.210
<i>Dow Corning[®]</i> 163 Additive	Silicone antifoam compound; 100% active	Provides foam control in coatings and inks	Acrylic, epoxy, polyester, polyurethane, vinyl	Let-down or post add	0.1-0.5%	Aromatics, aliphatics, glycols, water	Silanol	None	>101°C (>214°F)	1,000	18	FDA 175.105, 175.300, 176.170, 176.180, 176.200, 176.210, BFR XV
<i>Dow Corning[®]</i> Antifoam A	Silicone antifoam compound; 100% active	Silicone defoamer effective in solvent-based amide systems	Solvent-borne amide and UV	Grind or let-down or post add	0.1-1.0%	Aliphatic, aromatic and chlorinated solvents and glycols	None	None	>101°C (>214°F)	1,500	36	FDA 175.105, 175.300, 176.170, 176.180, 176.200, 176.210, 177.2600
<i>Dow Corning[®]</i> Antifoam 2210	Silicone emulsion; 10% active in water	Provides foam control in waterborne coatings, especially dispersion paints	Acrylic	Grind or let-down or post add	0.1-1.0%	Water	None	Water	>100°C (>212°F)	2,700	24	-

(continued on pages 6, 7)



Table 2. Features, Typical Use and Properties of Additives from Dow Corning^[1]

Product	Description	Features/Benefits	Compatible Binder Systems	Point of Addition	Typical Concentration ^[2]	Suitable Diluents ^[3]	Reactive Groups	Solvent	Flash Point, closed cup	Viscosity at 25°C (77°F), cSt	Shelf Life, months ^[4]	Food Contact Compliance ^[5]
Adhesion Promotion												
XIAMETER [®] OFS-6011 Silane	Aminopropyl-triethoxysilane; 99% active	Adhesion promoter and pigment treatment	Acrylic, alkyd, polyester, polyurethane	Let-down	0.05-1.0%	Alcohols and water	Amino-ethoxy	None	96°C (205°F)	1.65	24	FDA 175.105
XIAMETER [®] OFS-6020 Silane	Amino-methoxy-functional silane; 99% active	Effective in promoting adhesion of a wide variety of coating systems to glass, aluminum and steel	Acrylic, alkyd, epoxy, polyester, polyurethane, vinyl	Let-down	Primer: dilute to 10% active in isopropanol Additive: 0.5-3.0% Primer: dilute to 0.1-0.5% active in acidified (pH ~4.0) water Additive: 0.5-3.0%	Alcohols and water	Amino-methoxy	None	62°C (144°F)	6.5	36	FDA 175.105, 176.300, 177.1390
XIAMETER [®] OFS-6030 Silane	Methacrylate-methoxy-functional silane; 98% active; when used as a primer, apply by dipping or brushing	Improves adhesion of free radical cured resins, such as polyester, to inorganic substrates	Acrylic, alkyd, epoxy, polyester, polyurethane, vinyl	Let-down	Primer: dilute to 0.1-0.5% active in acidified (pH ~4.0) water Additive: 0.5-3.0%	Alcohols and water	Methacrylate-methoxy	None	>100°C (>212°F)	2.5	18	–
Dow Corning [®] Z-6032 Silane	Vinylbenzyl-amine-methoxy-functional silane; 40% active	Adhesion promoter and pigment treatment	Alkyd, epoxy, vinyl	Let-down	0.05-2.0 wt%	Alcohols and water	Vinylbenzyl-amine-methoxy	Methanol	13°C (55°F)	2	18	FDA 175.300
XIAMETER [®] OFS-6040 Silane	Epoxy-methoxy-functional silane; 99% active; when used as a primer, apply by dipping or brushing	Effective in promoting adhesion of a wide variety of coating systems to glass, aluminum and steel	Acrylic, alkyd, amine, epoxy, nitrocellulose, phenolic, polyester, polyurethane, vinyl	Let-down	Primer: dilute to 10% active in isopropanol Additive: 0.5-3.0%	Alcohols and water	Epoxy-methoxy	Methanol	>101°C (>214°F)	3	36	FDA 177.1390
Dow Corning [®] Z-6121 Silane	Amino-methoxy-functional silane; 50% active	Improves adhesion and water resistance of coatings and adhesives when bonded to glass or metal substrates; can be used as an additive or primer	Acrylic, alkyd, epoxy, polyester	Grind or let-down or post add	Primer: dilute to 10% active Additive: 1.0-5.0%	Alcohols and water	Amino-methoxy	n-Butanol	27°C (81°F)	5	36	FDA 175.105
Dow Corning [®] Z-6137 Silane	Aqueous solution of amino-functional silicone polymers; low alcohol content (<1%); 24% active; when used as a primer, apply by dipping or brushing	Promotes adhesion of a wide variety of coating systems to glass, ceramics and metals	Acrylic, epoxy, phenol, polyurethane	Let-down	Primer: dilute to 10% active Additive: 1.0-5.0%	Water, isopropyl alcohol	Aminosilanol	Water	100°C (212°F)	7	24	–
Pigment Treatment												
Dow Corning [®] 3 Additive	Silanol-functional (Si-OH) additive; 10% active in toluene	Improves pigment dispersion and reduces separation and floitation; also provides leveling, flow-out and gloss	Epoxy, polyurethane	Grind or let-down or post add	0.1-0.5%	Aromatics such as xylene or toluene; mineral spirits or ketones	Silanol	Toluene	7°C (45°F)	1	36	–
Dow Corning [®] Z-6300 Silane	Vinyltrimethoxysilane; 99% active	Pigment treatment	Acrylic, alkyd, epoxy, polyester, polyurethane, vinyl	Let-down	0.05-0.1%	Alcohols and water	Vinyl-methoxy	Methanol	22°C (72°F)	3	36	FDA 177.2600
Water Resistance												
Dow Corning [®] 84 Additive	Low-viscosity emulsion of elastomeric silicone; 60% active	Provides water resistance for waterborne systems, particularly inks	Mainly acrylics	Let-down or post add	2.0-5.0%	Water	Silanol	Water	>100°C (>212°F)	500	24	–
Dow Corning [®] 85 Additive	Medium-viscosity emulsion of elastomeric silicone; 60% active	Provides water resistance for waterborne systems, particularly inks	Mainly acrylics	Let-down or post add	2.0-5.0%	Water	Silanol	Water	>100°C (>212°F)	40,000	24	–

(continued on page 7)

Table 2. Features, Typical Use and Properties of Additives from Dow Corning^[1]

Product	Description	Features/Benefits	Compatible Binder Systems	Point of Addition	Typical Concentration ^[2]	Suitable Diluents ^[3]	Reactive Groups	Solvent	Flash Point, closed cup	Viscosity at 25°C (77°F), cSt	Shelf Life, months ^[4]	Food Contact Compliance ^[5]
Leveling/Wetting, Gloss												
<i>Dow Corning®</i> 56 Additive	Alkylalkyl-modified silicone; 100% active	Aids deaeration and stabilizes the curtain in curtain coatings; improves leveling and gloss; aids pigment orientation; good thermostability	Acrylic, alkyd, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.01-0.5%	Aromatics such as xylene, toluene, mineral spirits and chlorinated hydrocarbons	None	None	>101°C (>214°F)	1,500	36	-
<i>Dow Corning®</i> 57 Additive	Silicone polyether copolymer; 100% active	Improves leveling, slip, mar resistance and gloss; excellent substrate wetting	Acrylic, alkyd, amide, epoxy, nitrocellulose, polyester, polyurethane, vinyl	Grind or let-down or post add	0.1-1.0%	Acetone, toluene, naphtha, mineral spirits and isopropyl alcohol; dispersible in water	None	None	>80°C (>176°F)	270	30	FDA 176.210 ^[6]
<i>Dow Corning®</i> 67 Additive	Silicone polyether copolymer; 100% active	Imparts good spreading and wetting on difficult substrates, e.g., low-energy substrates such as polyethylene, polypropylene, polyester; suitable in inks, decorative and industrial coatings for plastic, metal and wood	Acrylate, polyester, polyurethane	Let-down	0.1-1.0%	Isopropyl alcohol, acetone and toluene; dispersible in water	Carbinol	None	>100°C (>212°F)	40	24	-
Texturing												
<i>Dow Corning®</i> 23N Additive	Powder consisting of transparent spherical silicone elastomer particles with epoxy functionality; average particle diameter of 2-3 microns	Imparts mar and abrasion resistance with a silky, smooth, matte finish	Acrylic, polyester, polyurethane, vinyl	Prepare premix; see product data sheet	0.5-5.0%	Solvents such as glycols, glycol ethers, esters, alcohols, water or monomers used for UV coatings such as TPGDA	Epoxy	None	NA	NA	27	-
<i>Dow Corning®</i> 33 Additive	Waterborne suspension of spherical silicone elastomer particles with epoxy functionality; average particle diameter of 2-3 microns; 46% active	Imparts mar and abrasion resistance with a silky, smooth, matte finish	Acrylic, polyurethane	Grind or let-down or post add	5-10%	Water	Epoxy	Water	>101°C (>214°F)	50	12	-

^[1] These values are not intended for use in preparing specifications.

^[2] The typical concentrations are usage levels where the materials have performed successfully. Usage levels can vary depending on application and performance requirements. Please evaluate for optimum performance in each specific application.

^[3] Review the Safety Data Sheet for each solvent prior to use. Safety Data Sheets can be obtained from your solvent supplier.

^[4] From date of manufacture, months.

^[5] **FDA Title 21 CFR** – 175 (175.105, 175.300, 175.320) Indirect food additives; adhesives and components of coatings; 176 (176.130, 176.170, 176.180, 176.200, 176.210) Indirect food additives; paper and paper board components; 177 (177.1390, 177.2600, 177.1520(b)) Indirect food additives; polymers.

EU Legislation – B1R recommendation XV about silicones; B1R recommendation XXXVI about paper and paperboard for food contact. EU Directive 2002/72/EC and its amendments up to and including Directive 2004/19/EC.

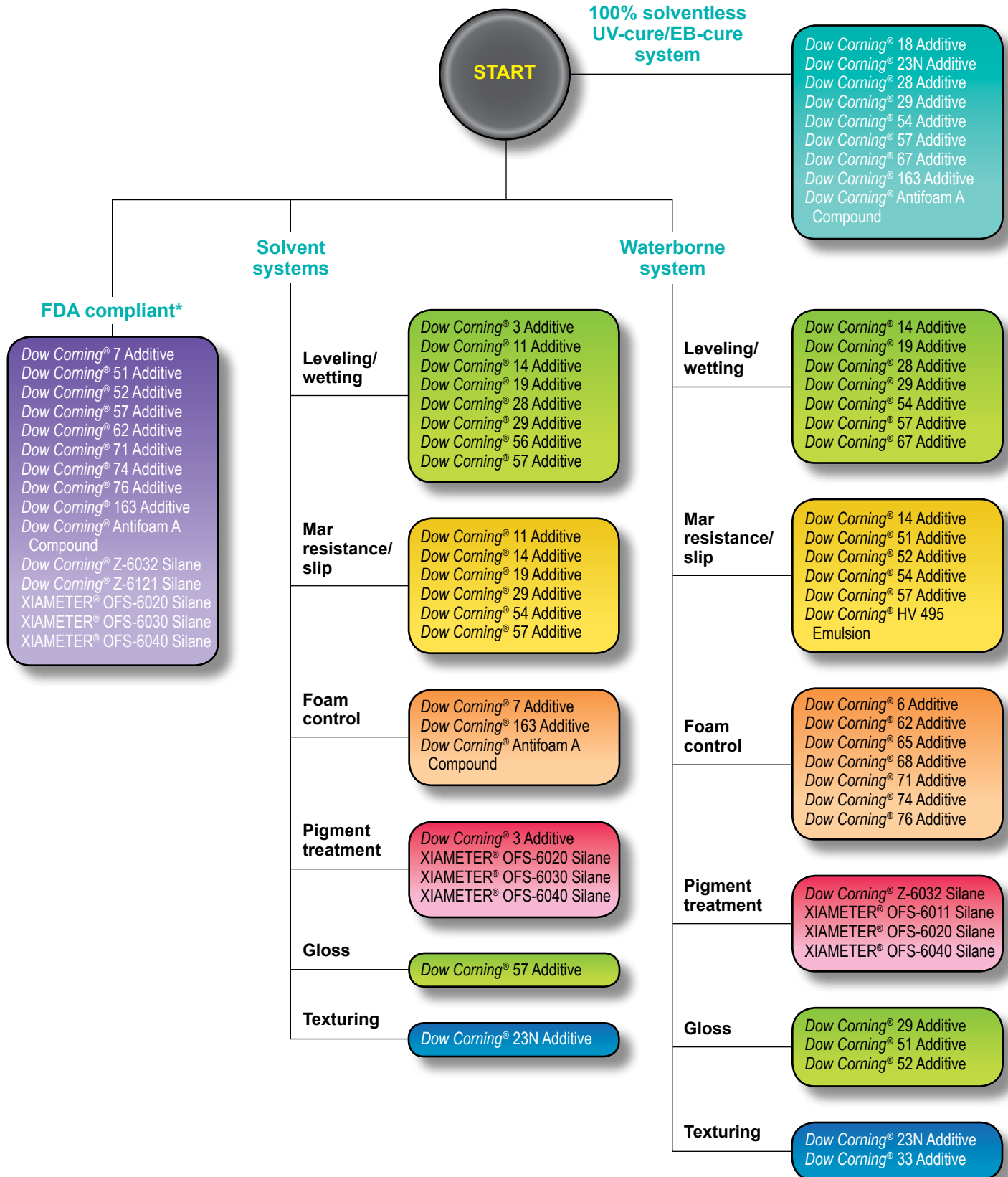
^[6] Per Food Contact Notification 516.

^[7] Per Food Contact Notification 142.

NA = Not Applicable.



Additive Selector Tree for Coatings Applications



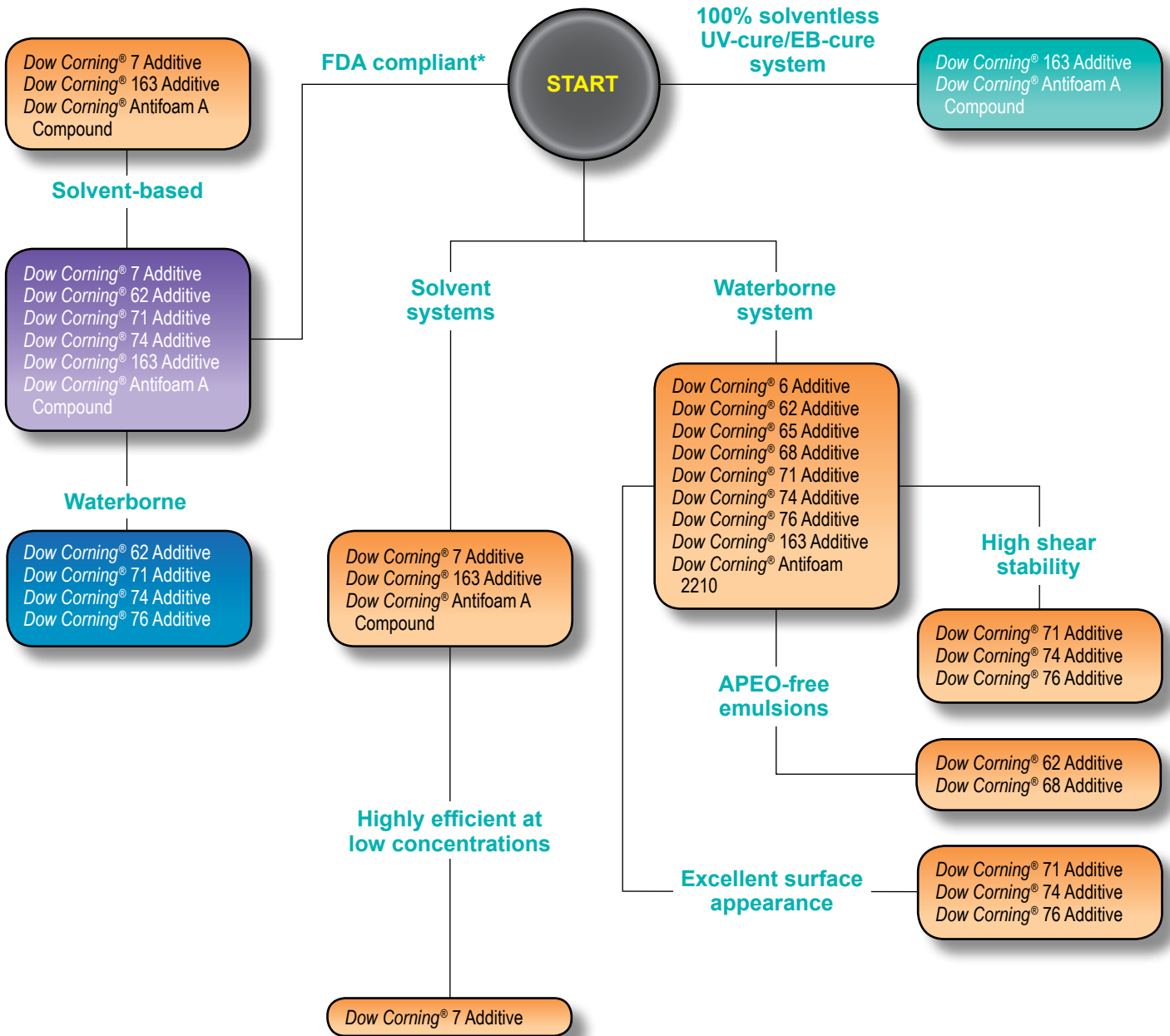
*See product data sheets for details.



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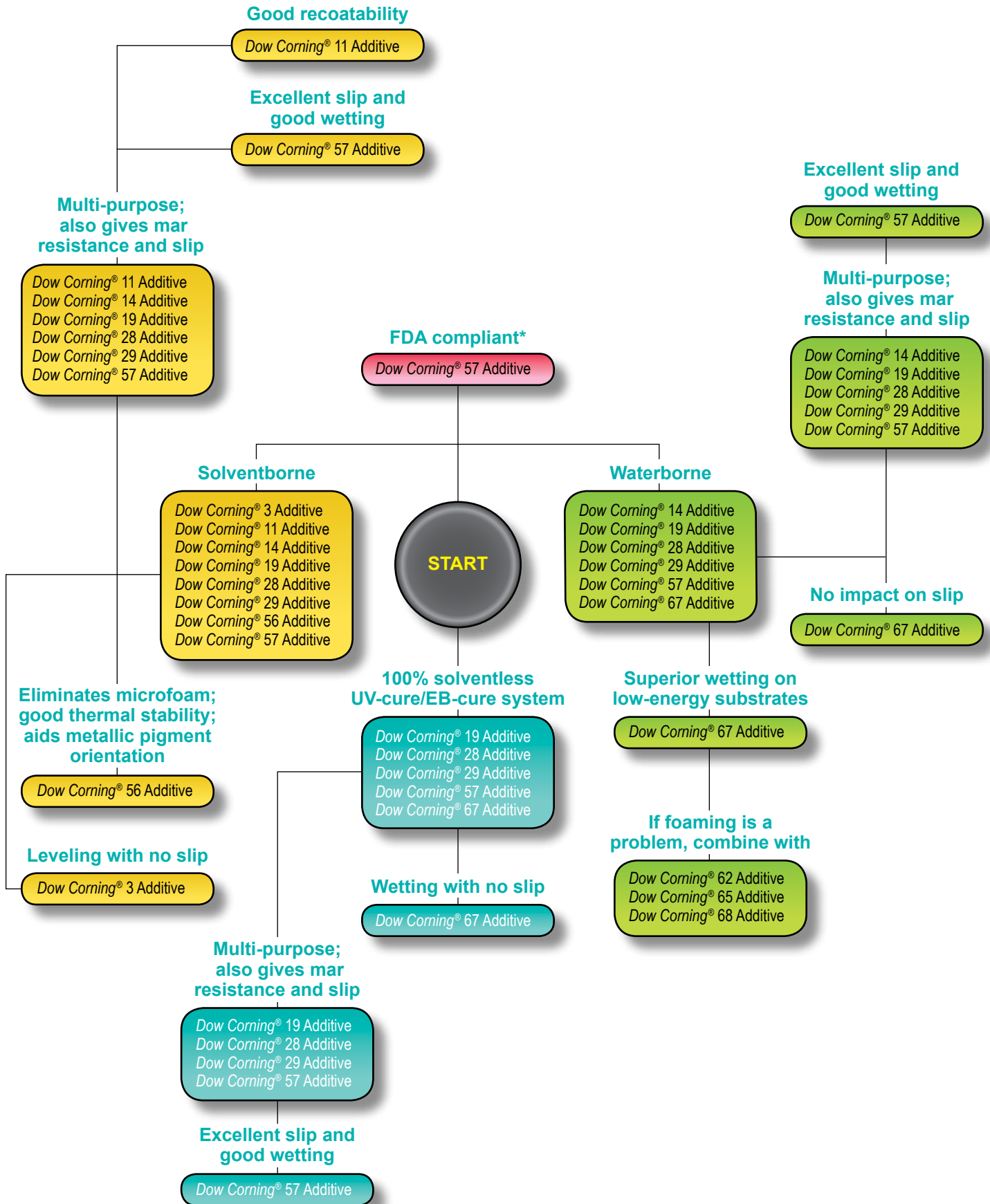
Foam Control Additive Selector Tree for Coatings Applications



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*See product data sheets for details.

Leveling and Wetting Additive Selector Tree for Coatings and Ink Applications



*See product data sheets for details.

Two Brands to Serve You

In addition to the variety of Dow Corning materials and services showcased in this selection guide, Dow Corning Corporation also offers over 2100 standard silicone products under its XIAMETER® brand. Visit xiameter.com to learn more about the many additional silicone options available to you from XIAMETER brand, backed by the same quality and supply you've come to expect from Dow Corning.

Your Global Connection

At home or abroad – wherever your business takes you – you will find the product supply, customer service and technical support you need to succeed available locally from Dow Corning.

Whether you are facing a challenge that could benefit from Dow Corning's international business and market experience, or you need a reliable, local source of supply for innovative paints, inks and coatings solutions, contact your Dow Corning representative. Product samples, technical information and assistance are also available online at dowcorning.com/coatings.

Contact Information

dowcorning.com/ContactUs

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LIMITED 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 our products are safe, effective and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the 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.

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