

Proven

Tested

Protection

Durability

Versatility

Reliable

Efficient

Strength

Confident

Airtight

Control

High Performance

Expert Advice

Experience

History

Integrity

Flexibility

Superior

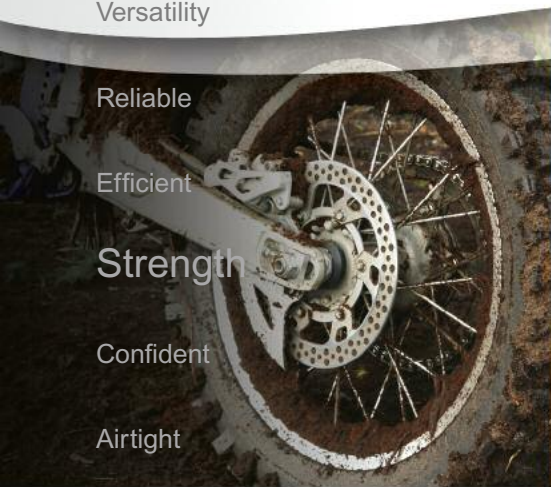
Quality

Global Support

Enduring

Adhesion

Growth



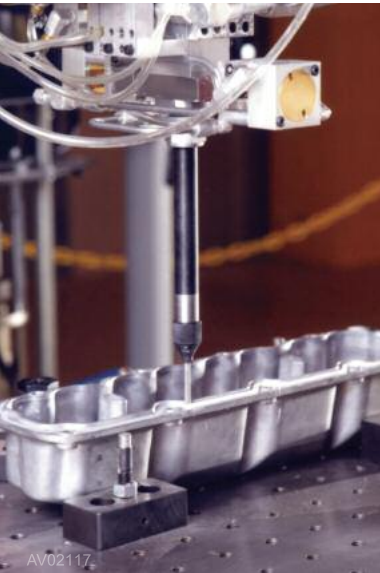
# A Guide to Dispensable Sealing and Adhering Products

For All Transportation Applications



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Dow Corning dispensable sealing and adhesive products are essential to the global transportation industry. No matter what your company produces —motorcycles, farm equipment, automobiles, or anything on wheels—Dow Corning offers products, services and support to help you.

The following section offers answers to your most frequently asked questions on selecting the right *Dow Corning*<sup>®</sup> dispensable sealing and adhering products for your application. Continue reading for the steps you can take to integrate Dow Corning products and services into your production process.

**Q When should I use a silicone dispensable sealing and adhering product?**

**A** Silicone seals and adhesives are often required for the design and assembly of transportation equipment and components. They ensure that your components remain intact and resistant to environmental stressors that could weaken performance. In some cases, preformed gaskets or adhesive tapes may be suitable; however, dispensable silicone materials can offer distinct advantages over other methods. You will gain the most value by using silicone dispensable sealing and adhering products when:

- surfaces to be sealed or adhered are complex, or have large dimensional variations
- challenging manufacturing requirements demand that you produce multiple components on the same automated equipment
- you need to automate the sealing or adhering portion of an assembly operation
- you are looking for a more cost-effective sealing or adhering method
- you wish to utilize your supplier base to apply gasketing or seals, and then supply you with a completed modular assembly
- you require fast cure rates to facilitate high-volume throughput
- you require high-volume production but need a compression seal

**Q What types of dispensable products does Dow Corning offer?**

**A** We offer a broad line of dispensable adhesive/sealant and gasket materials—all based on the versatile silicone polymer chain. Our silicone materials are remarkably tough yet flexible under the most punishing environments, including weathering, aging, temperature extremes and UV exposure. We also have products that are resistant to automotive, general transportation fluids and other harsh environments.

Dow Corning offers you more value through our products' ability to significantly outlast and outperform most conventional materials. As well, the high quality of our materials will provide you with the ability to offer longer warranty cycles to your customers.

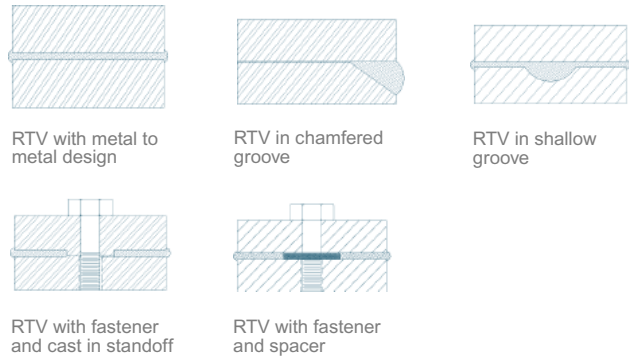
**Q I need more than products; I also need a system to apply them. Do you offer customized solutions beyond your product line?**

**A** Dow Corning will go beyond materials to provide engineered solutions to your specific sealing requirements. We have worked with several equipment/dispense system manufacturers to design and produce a variety of sealing systems for multiple seal-joint situations. As a result, Dow Corning has developed a global network of equipment alliances. Dow Corning will work with you and your equipment suppliers to optimize your design, sealing, process and material integration needs as you prepare to enter the vehicle commercialization process.

**Q How will Dow Corning support me at my location?**

**A** Dow Corning will provide you with local technical support as well as access to global technology. Our representatives will help you select the right sealing or adhering product for your unique automotive or industrial application. We can help you reach your optimal design goals by harmonizing the design with the sealing materials through specific engineering sealing protocols. We can then help you determine the most complementary process for your assembly process.

We will show you how our process works in five easy steps—you may take advantage of them all or as needed. Continue reading for more information on how Dow Corning offers you a complete range of solutions focused on your unique situation.



**1 Meet your material specifications.**

From meeting standard OEM and supplier specification approvals to fulfilling unique specification approvals, Dow Corning will help you satisfy your material specifications no matter where they originate. We will work with you to provide the type of validating data you need to prove the success of your sealing system. Customized benchtop functional test development is also available for an additional fee.

**2 Create a prototype.**

You can rely on the people at Dow Corning to help you bring your ideas to life. Our materials-development team can adjust a product to meet your exact requirements. Our multiple-axis dispensing robots can also provide custom prototypes for your application, which can then be incorporated into your test fixtures and fleet vehicle testing. After we have worked together with you to find the right product and sealing technique that is optimized for your design needs, we can also provide you with further gasketed parts for final validation.

If you have already created your prototype and are ready for the next step, please continue reading.

### 3 Test for functionality.

Today's stringent quality standards demand thorough functional testing. Dow Corning has the specialized equipment you require to ensure our products fit your application. We can develop a customized testing regimen for product validation. We can also test your application using environmental chambers, fluid circulation systems, a salt spray chamber, and other specialized equipment. Our combined testing expertise and experienced technical specialists will help you validate a product to a specific application.

### 4 Test for end-use performance.

Functionality of your material and process to the end user is just as important as the functionality of your application. In order to evaluate your potential success, Dow Corning provides and designs functionality tests to predict material and process end-use performance. We can work with you to create a specific laboratory benchtop predictive functional test to mimic end-use environments. This test can act as a screen prior to your required field-testing.

Dow Corning also offers full functionality testing, using your concepts or released production parts to provide tangible, end-use performance predictions.

### 5 Establish a production process.

Your product now meets specifications and the prototype has excelled during functional testing. At this moment, many other suppliers would leave you, their job completed. However, we know that it is extremely important that your new process match perfectly with your manufacturing scheme. Dow Corning will continue to help you by matching our products with the best equipment for your application. We can recommend well-known global equipment alliance partners who understand our materials and have the ability to fully integrate our systems approaches to your requirements. We will also work with both you and the equipment supplier you choose to help you create the right process—whether you employ a caulking gun, a fully automated dispensing system, or something

in-between. We can and have created a number of process failure mode effects analysis (PFMEA) methods to gauge our differing products' impact on various delivery processes.

*By dealing directly with Dow Corning as your basic material manufacturer, you will optimize your costs and still be able to access all the services of a technical distributor.*

#### Evaluate one of our products today

Use this guide to learn more about the types of products Dow Corning offers and discover which one might be best suited to your application. Then, contact your Dow Corning representative at [www.dowcorning.com](http://www.dowcorning.com) to begin your personal consultation.

Our representatives would be happy to visit your facility and discuss your exact needs. We will also obtain product samples for you and introduce you to our application development and technical service team. From there we can establish what you will require, from standard application assistance to customized testing and engineering. Whether you need to seal fluids in, seal the elements out, or adhere engineering materials together, you can always depend on Dow Corning.



# How to Use This Selector Guide

This selector guide is designed to help you find the Dow Corning dispensable sealing or adhering product that best meets your needs. To use the guide, first choose which application you require and locate it on the graph below. Then check the Function column. Sometimes one application will have multiple functions, so it is important that you identify exactly what you need the product to do for you. If you cannot find the application you need within the guide, begin your search in the Function column and select the function that best matches that of your application. This guide also includes specific design parameters and processing

characteristics to help you more accurately identify the product we recommend.

You have now officially started your search for a Dow Corning product. Further thorough evaluation in your application will be required even after you have chosen a product, and you may find that another Dow Corning product is a better match. Our representatives are always available to help you through this decision process.

FUNCTION	DESIGN CHARACTERISTICS	PROCESS CHARACTERISTICS	DOW CORNING® PRODUCT(S)
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## FUEL SYSTEM

Seal in fuel over a wide temperature range and under system pressure.	Adhesive seal/bond with minimally acceptable flange widths.	Robotically dispensable with simple one-part process and room-temperature cure.	730 Solvent-Resistant Sealant
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## AIR INTAKE / INDUCTION SYSTEMS

Seal out moisture, dust and the environment in aspirated engine-intake system.	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8109, 3-8186 & 3-8159RF Dispensable Foam Gasketing
Seal in pressure from turbo-charged air induction systems.	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-20P A&B Kit
Seal in pressure from turbo-charged air induction systems.	Gap-filling adhesive bond.	Robotically dispensable with simple one-part process and room-temperature cure.	736 Heat Resistant/Sealant
Sealing pinholes in soldering tubes to header operations for charged aircoolers.	Potting affected area with product.	Equipment dispensable with simple one-part process and heat cure.	3-3166 Primerless Silicone Adhesive

## STATIC ENGINE SEALING

Seal in oil or coolant from -40°C to 150°C and under 10 psi.	Compression gasket. Usually dispensed into an engineered groove utilizing an on-line pressurized seal check.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-30P & D94-45M Liquid Silicone Rubbers
	Adhesive seal with metal-to-metal or metal-to-metal with groove design, where an on-line pressure seal check is utilized.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0105, 3-0110J & 3-0115 Automotive Sealants
	Adhesive seal with metal-to-metal or metal-to-metal with groove design, with no on-line pressure seal check.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100 & 3-7057LV Automotive Sealants; 1080 Oxime Sealant; 7091 Adhesive/Sealant; 737 Neutral Cure Sealant; Q3-1566 Heat Resistant Adhesive/Sealant

## TRANSMISSION / GEARBOX

For pan-seal in transmission fluid at -40°C to 150°C.	Compression gasket: designed for engineered groove.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-30P & D94-45M A&B Kits
	Adhesive seal with metal-to-metal or metal-to-metal with groove design.	Robotically dispensable with simple one-part process and room-temperature cure.	7091 Adhesive/Sealant; 3-7057LV Automotive Sealants; 3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; Q3-1566 Heat Resistant Adhesive/Sealant
For inspection covers exposed to fluid splash only; from -40°C to 150°C.	Compression gasket: designed for engineered groove. No RTV due to serviceability.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8186 Thixotropic Foam; D94-20P & D94-30P A&B Kits (depending on cover construction and force to seal)

## DIFFERENTIAL / AXLE COVER

Seal in gear oil from -40°C to 125°C.	Adhesive seal with metal-to-metal or metal-to-metal with groove design.	Robotically dispensable with simple one-part process and room-temperature cure.	7091 Adhesive/Sealant; 732 Multi-Purpose Sealant; 1080 Oxime Sealant; 3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; 737 Neutral Cure Sealant
	Compression gasket: designed for engineered groove.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-45M A&B Kit

## COOLING SYSTEM

Radiator end tank-seal in coolant at -40°C to 125°C and up to 20 psi.	Compression gasket: designed for engineered groove.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-30P & D94-45M A&B Kits
Fan clutch-seal in torque transfer fluid.	Adhesive/gap seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants
Thermostat housing to seal in coolant under pressure from -40°C to 125°C.	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-30P & D94-45M A&B Kits
	Adhesive seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants

## UNDERHOOD

Electric module sealing. Keeps out moisture, occasional fluid contact. Serviceable.	Compression gasket.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	D94-20P, D94-30P & D94-45M A&B Kits; 3-8109 & 3-8159RF Silicone Foam Kits; 3-8186 Thixotropic Foam
Electric module sealing. Keeps out moisture, occasional fluid contact. Non-serviceable.	Adhesive seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; 7091 Adhesive/Sealant; 832 Multi-Surface Adhesive Sealant; 1080 Oxime Sealant; 737 Neutral Cure Sealant

## ELECTRICAL APPLICATIONS

Used in sensitive electrical and electronic applications.	Insulate and protect against corrosion.	Dip, spray or brush process with room-temperature cure.	236 Dispersion; 1890 Protective Coating
		Robotically dispensable with simple one-part process and room-temperature cure.	738 Electrical Sealant, White

## WHEELS

Adhere decorative covers to wheels.	Adhesion/bonding.	Robotically dispensable with simple one- or two-part process and room-temperature cure.	3-3636 Base; 7091 Adhesive/Sealant
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## INTERIOR SEALING AND ADHERING

Cabin sealing. Seals out water, dirt and fumes from cabin area.	Adhesive seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; 732 Multi-Purpose Sealant; 832 Multi-Surface Adhesive Sealant; 7091 Adhesive/Sealant
	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8186 Thixotropic Foam; 3-8109 & 3-8159RF Silicone Foam Kits
Firewall sealing. Seals off cabin penetrations from environment.	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8186 Thixotropic Foam; 3-8109 & 3-8159RF Silicone Foam Kits; D94-20P, D94-30P & D94-45M A&B Kits
	Adhesive seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; 732 Multi-Purpose Sealant; 832 Multi-Surface Adhesive Sealant; 7091 Adhesive/Sealant
Interior bonding and/or bonding two surfaces together.	Hot-melt adhesive bond.	One-part equipment dispensable with heated delivery.	HM-2500, HM-2510 & HM-2520 Assembly Sealants - Clear
Prevent squeak and rattle NVH concerns on interior parts.	Vibration absorption/sound deadener.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8109 & 3-8159RF Silicone Foam Kits; 3-8186 Thixotropic Foam
	Vibration absorption-RTV.	Robotically dispensable with simple one-part process and room-temperature cure.	732 Multi-Purpose Sealant; 832 Multi-Surface Adhesive Sealant; 737 Neutral Cure Sealant

## EXTERIOR SEALING AND BONDING

Adhere glass to mirror backing.	Adhesion seal.	Robotically dispensable with simple one-part process and room-temperature cure.	Q3-7062 Silicone Rubber
Vibration dampening for mirrors.	Compression seal with vibration dampening.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8109 & 3-8159RF Silicone Foam Kits; 3-8186 Thixotropic Foam
Adhere emblem to painted surface.	Adhesion seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-7062 RTV Silicone Rubber
	Hot-melt adhesive bond.	One-part equipment dispensable with heated delivery.	HM-2520 Assembly Sealant



## OPTICALLY CLEAR ADHERING

Adhesive bonding of plastic or metal to glass or other substrates requiring optically clear material characteristics.	Optically clear bond by a film adhesive.	Requires heat cure and pressure. Can be achieved through autoclave or fixtured process ensuring good wet-out and pressure.	Sotefa 70M
	Optically clear adhesive bond by a hot melt.	One-part equipment dispensable with heated delivery.	HM-2500, HM-2510 & HM-2520 Assembly Sealants - Clear

## LAMP SEALING

Seal and/or bond dissimilar substrates, withstand UV and moisture exposure.	Compression seal.	Robotically dispensable with very fast heat cure. Equipment must be capable of handling 1:1 ratio for two-part material.	3-8109 & 3-8159RF Silicone Foam Kits; 3-8186 Thixotropic Foam
	Adhesive seal.	Robotically dispensable with simple one- or two-part process and room-temperature cure.	7091 Adhesive/Sealant; 9-1363 Industrial Assembly Adhesive Sealant; 3-3636 Base; 3-3526 Base and Catalyst Adhesive Sealant
	Hot-melt adhesive bond.	One-part equipment dispensable with heated delivery.	HM-2520 Assembly Sealants - Clear

## GREEN APPLICATIONS

Flexible Fuel—exposure in fuel over a wide temperature range and under system pressure.	Adhesive seal with minimally acceptable flange widths.	Robotically dispensable with simple one-part process and room-temperature cure.	730 Solvent-Resistant Sealant
Low VOC surface cleaner.	Surface cleaning, adhesion-enhancing low VOC products.	Spray, brush, or wipe with room-temperature drying.	OS-10, OS-20 & OS-30
Low VOC surface primer.	Adhesion-enhancing primer.	Spray, brush, or wipe with room-temperature drying.	P5204 Adhesion Promoter; P5200 Formulation Aid; 1593 Cleaner/Primer
"MEKO"-free sealants.	Adhesion seal.	Robotically dispensable with simple one-part process and room-temperature cure.	3-0100, 3-0105, 3-0110J & 3-0115 Automotive Sealants; 7091 Adhesive/Sealant; Q3-7062 Silicone Rubber; 738 Electrical Sealant, White; 9-1363 Industrial Assembly Adhesive Sealant

# Product Detail

DOW CORNING® PRODUCT(S)	DESCRIPTION	EXTRUSION RATE (GM/MIN)	SKIN OVER TIME (MIN)	GEOGRAPHIC AVAILABILITY
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## ONE-PART SEALANT TECHNOLOGIES

3-7057LV Automotive Sealant	Low volatility, oil resistant, acetoxy cure.	220	4	Global
3-0100 Automotive Sealant	Alkoxy, neutral cure, low volatility, oil resistant.	145	24	Global
3-0105 Automotive Sealant	Alkoxy, neutral cure, low volatility, oil resistant.	50	7	Global
3-0110J Automotive Sealant	Alkoxy, neutral cure, low volatility, oil resistant.	50	10	Global for Asian transplants
3-0115 Automotive Sealant	Alkoxy, neutral cure, low volatility, oil resistant.	50	10	Global
735 Oil Resistant Sealant	Oil-resistant oxime.	400	9	Global
732 Multi-Purpose Sealant	Multi-purpose. Acetoxy cure.	350	10	Global
736 Heat-Resistant Sealant	High-temperature resistant. Acetoxy cure.	390	10	Global
737 Neutral-Cure/Sealant	Fast-curing oxime.	395	5	Europe, North & South America
7091 Adhesive Sealant	Alkoxy cure with excellent adhesion.	185	15	Global
Q3-7062 RTV Adhesive/Sealant	Alkoxy cure, adheres to plastic.	110	25	Global
738 Electrical Sealant	Alkoxy cure.	550	20	Global
734 Flowable Sealant	Acetoxy cure, flowable and self-leveling.	650	7	Global
832 Plant Maintenance Sealant	Alkoxy cure with excellent adhesion.	133	20	Global
733 Glass & Metal Sealant	Acetoxy cure, glass and metal sealant.	350	10	Global
1080 Oxime Sealant	Oxime cure with high tear.	350	25 min tack free	Europe and Asia
9-1363 Industrial Assembly Adhesive Sealant	Alkoxy cure with fast tack-free time.	200	1.5 skin-over/7 tack free	North & South America
Q3-1566 Heat Resistant Adhesive/Sealant	Acetoxy cure, high-temperature resistant.	270	5	Europe, South America, Asia
HM-2500 Assembly Sealant	Reactive hot melt, ultra clear with immediate "green" strength.	2100 poise	1/8" bead 48 hrs @ room temperature	Global
HM-2510 Assembly Sealant	Reactive hot melt, flowable with immediate "green" strength.	1050 poise	1/8" bead 48 hrs @ room temperature	Global
HM-2520 Assembly Sealant	Reactive hot melt, high strength with immediate "green" strength.	1100 poise	1/8" bead 48 hrs @ room temperature	United States, Europe, Asia

## TWO-PART SEALANT TECHNOLOGIES

3-3166 Primerless Silicone Adhesive	Heat curing, self-leveling, high-strength adhesive.	Viscosity - 47,000	60 min @ 150°C	Global
3-3526 Base and Catalyst Adhesive Sealant	Rapid adhesion, 10:1 mix, fast-curing non-slump.	Base viscosity - 250,000, catalyst viscosity - 10,000	15 min @ 70°C	Global
3-3636 Base	Rapid adhesion, 7.5:1, best anti-fogging characteristics.	Base viscosity - 200,000, catalyst viscosity - 45,000-200,000 color dependent	10 min @ 65°C	Global
D94-20P A&B Kit	1:1 mix, heat cure compression gasket, self adhering.	Extrusion rate Pt A-140 Extrusion rate Pt B 240	7-10 min @ 150°C	Global
D94-30P A&B Kit	1:1 mix, heat cure compression gasket, self adhering.	Extrusion rate Pt A - 80 Extrusion rate Pt B -140	7-10 min @ 150°C	Global
D94-45M A&B Kit	1:1 mix, heat cure compression gasket, self adhering.	Extrusion rate Pt A - 74 Extrusion rate Pt B - 74	7-10 min @ 150°C	Global
3-8109 Silicone Foam Kit	1:1 mix, room-temperature or heat cure, compression self-leveling gasket.	Pt A viscosity - 11,000-17,000. Pt B viscosity - 12,000-17,000	Room temperature or 7 min @ 75°C	Europe
3-8159RF Silicone Foam Kits	1:1 mix, room-temperature or heat cure, reduced flowable, compression gasket.	Pt A viscosity - 35,000-75,000. Pt B viscosity - 20,000-70,000	Room temperature or 7 min @ 75°C	Europe
3-8186 Thixotropic Foam	1:1 mix, heat cure thixotropic compression gasket.	Pt A viscosity - 135,000 Pt B viscosity - 125,000	10 min @ 75°C	North & South America

## SYNERGISTIC TECHNOLOGIES

236 Dispersion	Dispersion release coating, 70 percent solids.	Viscosity - 675	85 min skin over @ 24-hour room-temperature cure	Global
1890 Protective Coating	One-part silicone rubber, electrical-protection coating.	Viscosity - 400 poise	15 min skin over	Global
OS-10, OS-20 & OS-30	Ozone-safe for cleaning, rinsing, aerosols, replacement of organic fluids.	Viscosity 0.5 to 1.3	N.A.	Global
P5200 Formulation Aid	Low VOC cleaner and primer.	Viscosity - water-like	Room-temperature dry	Global
P5204 Adhesion Promoter	Low VOC alternative to 1204.	Viscosity - water-like	Room-temperature dry	North & South America, Asia
1593 Cleaner/Primer	Cleaner and primer.	Viscosity - 10	Room-temperature dry	North & South America, Asia

## How To Contact Us

Dow Corning has sales offices, manufacturing sites, as well as science and technology laboratories around the globe. For more information, visit [www.dowcorning.com/automotive](http://www.dowcorning.com/automotive) or call one of our primary locations listed here.

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## Global Presence. Local Support.

Dow Corning's global presence in the automotive market enables you to develop specifications centrally while providing consistent high-quality products and services locally. Through our global sales, application engineering, product development, and manufacturing and delivery capabilities, our quality is consistent around the globe. This also enables a more effective and efficient product customization process—no matter where you are located!

Front cover: AV12128, AV12127, AV12126

#### 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 Dow Corning's 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 the product will meet the Dow Corning 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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