



## **Priming Guide for RTV Silicones**

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# There Is No Universal Primer. It Always Is Trial and Error.

## Product Selection

### Primer Selection

	<b>Kinematic Viscosity in mm<sup>2</sup>/s</b>	<b>Color</b>	<b>Solvent</b>	<b>Suitable for</b>
WACKER® Primer G 790	1	Yellowish	Isoalkanes/Toluene	General purpose
WACKER® Primer G 790 TOLUENE FREE	1	Yellowish	Isoalkanes	General purpose
WACKER® Primer G 791	5,200 / 120	Opaque	Isoalkanes	Silicone-to-silicone bonding
WACKER® Primer G 795	2	Yellowish	Isoalkanes	General purpose (preferably for addition-curing RTV-2 silicones)
WACKER® Primer G 718	1	Orange	Acetone/Toluene	Bonding RTV-1 silicones to thermoplastics and metals
WACKER® Primer FD	2	Yellowish	Acetone/Toluene	Porous, absorbent surfaces
WACKER® Primer AV A/B	5 / 100	Yellowish	Isopropanol	Wood and aluminum (preferably for addition-curing RTV-2 silicones)

# Primer Application Step by Step

- ▶ Clean and dry the substrates (must be free of dust, grease, oils or other contaminants).
- ▶ Very smooth surfaces can be roughened prior surface cleaning.
- ▶ Dilute the primer with non-polar solvents prior to use (1 part primer + 1-2 parts solvent).
- ▶ Apply by spraying, dipping or brushing (thin coat with no bubbles !).
- ▶ For absorbent surfaces: priming must be repeated several times.
- ▶ The primed parts must be air dried for at least 15 minutes.
- ▶ Let the primer crosslink for minimum 1 hour and maximum 12 hours
  - Alternatively: bake the primer for 15 to 40 minutes at 100 to 150 °C.
- ▶ Primed surfaces should be processed within 6 hours

## Note:

- ▶ A too-thick primer layer can reduce adhesion.
- ▶ Primers are sensitive to moisture.

# Primer Application Trouble Shooting

## When adhesion fails...

- ▶ Dilute the primer with a non-polar solvent, e.g. white spirit or a similar aliphatic solvent.
  - Note: the thinner a primer layer, the better
- ▶ Check the conditions at the production site (time, temperature, humidity).
  - Note: when rel. humidity & temperature is low, the primer needs more time to react.
- ▶ Check how the primer was stored prior use (dry/cool place ? Tightly closed container ?).
- ▶ Check the quality of the primer (Fresh primer used ? Cloudiness or white sediment visible in primer bottle ?)
  - Note: air moisture starts hydrolyzing the primer

▶ If there is a white precipitate, the primer should not be used !