

Pecora 896HIS

High Impact Silicone / Security, Impact, and Blast Applications

Specification Data Sheet



1. BASIC USES

- Protective Glazing
- Impact glazing applications
- Structural Glazing
- Blast Protective Glazing

2. MANUFACTURER

Pecora Corporation
165 Wambold Road
Harleysville, PA 19438
Phone: 215-723-6051
800-523-6688
Fax: 215-721-0286
Website: www.pecora.com

3. PRODUCT DESCRIPTION

Pecora 896HIS (High Impact Silicone) is a one-component, neutral curing, high impact silicone sealant designed for blast resistant, structural, and protective glazing applications. It features fast cure, very high tear and tensile strengths as well as excellent adhesion to a variety of substrates including vinyl, anodized aluminum and fluoropolymer coatings such as Kynar™ – generally without the need for priming.

Advantages: Pecora 896HIS offers the following features -

- Superior adhesion: Will bond tenaciously to most substrates without the need for priming.
- Excellent weatherability: Because of its 100% silicone composition, it is virtually unaffected by UV, precipitation, ozone, and temperature extremes.
- Resilient: Will remain flexible under extreme temperature swings (-60°F to 300°F)

- Superior tear and tensile strength
 - Successfully tested for use in protective and impact glazing applications
 - Fast cure in confined joint configurations
- Limitations:** Pecora 896HIS should not be used in the following applications -
- Sealing horizontal decks, patios, driveway or terrace joints where abrasion or physical abuse is encountered.
 - Below grade or sealing submerged joints or below the waterline in marine uses.
 - In designs that will be painted after applications of the sealant. Sealant should be applied after painting is completed.

4. TECHNICAL DATA

Applicable standards: Pecora 896HIS meets or exceeds the requirements of the following industry specifications: TT-S-230C, Class A; TT-S-001543A Class A, ASTM C920, Class 25, Type S, Grade NS, Use G, A, O, ASTM C-1184, AAMA 506-00 Hurricane Impact and Cycle Testing of Fenestration Products.

PACKAGING

- Pecora 896HIS is packaged in 10.1 oz cartridges, 5 gallon pails, and 50 gallon drums.

COLOR

- Call customer service for color availability.

TYPICAL UNCURED PROPERTIES

Test Property	Value	Test Procedure
Flow, Sag, Slump	nil	ASTM C-639
Tool/Work Time (minutes)	3-5	Pecora Corp.
Tack free time (minutes)	20	ASTM C-679
Cure time / Full adhesion		
Confined joint configurations (weeks)	2-3	Pecora Corp.
Exposed joint configurations (days)	7	

TYPICAL CURED PROPERTIES

Test Property	Value	Test Procedure
Dynamic Joint Movement	±25	ASTM C719
Hardness (Shore A)	45	ASTM C661
Ultimate Extension (%)	475	ASTM D412
Modulus @ 100% Elongation (psi)	120	ASTM D412
Ultimate Tensile Strength (psi)	375	ASTM C1135
Tear Strength (ppi)	43	ASTM D624
Peel Strength (pli)	45	ASTM D794
Ozone/UV Resistance	Excellent	ASTM C793
Staining, Color Change	None	ASTM C510
Service Temperature Range (°F)	-60 to +300	Pecora Corporation
VOC g/L	<100 g/L	ASTM D3960

5. INSTALLATION

Surface Preparation: Clean all joints and glazing areas by removing foreign matter and contaminants such as oil, dust, grease, frost, water, surface dirt, old sealants or glazing compounds and any protective coating. Metal, glass and plastic surfaces should be cleaned by solvent procedure or by mechanical means. Soap or detergent and water cleaning treatments are not recommended. Cleaning of all surfaces should be done on the same day on which the sealant is applied.

Cleaning: Excess sealant should be removed from all surfaces with mineral spirits while still uncured. Cured sealant is very difficult, if not impossible; to remove without altering or damaging the surface it is adhered to.

CAUTION: Solvents may be toxic and/or flammable. Refer to solvent manufacturer's instructions or Material Safety Data Sheets.

Priming: Pecora 896HIS does not require priming on most common substrates. However, Pecora strongly suggests adhesion pre-testing, either in the field or in Pecora's laboratory, particularly on special coatings or surface treatments which may impair optimum adhesion. Where primer is indicated, P-120 should be used on special metal and plastic surfaces.

Pecora routinely conducts project specific adhesion, compatibility, and staining tests in its laboratory on representative substrate samples. Consult Technical Services for details.

Application: Install back-up material, setting blocks, spacer shims and tapes. Mask areas to be protected from overflow and tooling. Conduct test applications for adhesion verification when appropriate. Apply sealant in a continuous operation. In cap bead glazing, tool the sealant applied at

the sill so that precipitation and cleaning solutions will not pool.

Storage: 6 months from date of manufacture when stored in original, airtight containers at temperatures below 90°F (32°C).

Precautions: Contact with uncured sealant, with vapors generated during curing, or with dust formed from cured sealant MAY CAUSE EYE, SKIN OR RESPIRATORY TRACT IRRITATION AND POSSIBLE ALLERGIC REACTION. Do not breathe fumes, dusts, vapors or mist. Keep container closed when not in use. Use only with adequate ventilation or wear an appropriate NIOSH-approved respirator. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling. In case of eye contact, immediately rinse with clean water for at least 15 minutes with eyelids held open and get medical attention. HARMFUL IF SWALLOWED. Do not swallow or take internally. Keep away from heat, sparks, and flame.

**FOR PROFESSIONAL USE ONLY.
KEEP OUT OF THE REACH
OF CHILDREN.**

6. AVAILABILITY AND COST

Pecora products are available from stocking distributors nationwide. For the name and telephone number of your nearest representative, call the number below or visit our website at www.pecora.com.

7. WARRANTY

Pecora Corporation warrants its products to be free of defects. Under this warranty, we will provide, at no charge, replacement materials for, or refund the purchase price of, any product proven to be defective when used in strict accordance with our published recommendations and in

applications considered by us as suitable for this product. The determination of eligibility for this warranty, or the choice of remedy available under this warranty, shall be made in our sole discretion and any decisions made by Pecora Corporation shall be final. This warranty is in lieu of any and all other warranties, expressed or implied, including but not limited to a warranty of merchantability or fitness for a particular purpose and in no case will Pecora be liable for damages other than those expressly stated in this warranty, including but not limited to incidental or consequential damages.

8. MAINTENANCE

If the sealant is damaged and the bond is intact, cut out the damaged area and re-caulk. No primer is necessary. If the bond has been affected, remove the sealant, clean and repair joint in accordance with instructions under "INSTALLATION".

9. TECHNICAL SERVICES

Local Pecora representatives are available to assist you in selecting an appropriate product and to provide on-site application instructions, or to conduct job-site inspections. For further information and assistance, please call our Technical Service department at 215-723-6051 or 800-523-6688.

10. FILING SYSTEMS

General Building
07100 Waterproofing
07920 Sealants
08850 Glazing
Civil Engineering
07100 Waterproofing

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