

# Tilt-Seal™

High Performance Acrylic Latex

## Specification Data Sheet



### 1. BASIC USES

- Expansion joints in tilt-up pre-cast panels.
- Window perimeters, aluminum, vinyl, or wood.
- Non-fire rated penetrations
- Sound dampening of acoustically rated wall systems
- Exterior joints only. Tilt-Seal™ should not be used on site walls.

### 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's Tilt-Seal™ is a one part, high performance acrylic latex sealant specially designed for use in pre-cast tilt-up panel joints. Tilt-Seal is perfect where movement is anticipated and flexibility is needed. It has excellent resistance to ultra violet rays, ozone and airborne contaminants.

#### Limitations:

- Avoid application of sealant if significant rain event is anticipated within a twenty-four hour period.
- Applications under prolonged water conditions.
- Maximum application temperature: 95°F. At temperatures greater than 95°F, please call Pecora Technical Services. Project mock-ups under site specific conditions are recommended.

#### PACKAGING

- 5-gallon (18.9 L) pails

#### COLOR

- Limestone

- Surfaces contaminated with oils, dirt, or release agents.
- **CAUTION:** Use of this product inconsistent with these specifications may cause product to fail.

### 4. TECHNICAL DATA

Applicable Standards: Tilt-Seal™ meets and exceeds ASTM C920 Type S, Grade NS, Class 25, Use G, A, M, and O, ASTM C834-95, AAMA 802.3-92 Type I and II, 805.2-92.

### 5. INSTALLATION

**Application Equipment:** Standard bulk caulking guns and/or sealant pumping equipment may be used for successful sealant application from 5 gallon pails. Hoses and pumps of automated pumping equipment should be air tight to prevent drying/curing of sealant pre-maturely.

**Joint Design:** Good joint design in the construction industry dictates a joint width of four times the anticipated movement. Pecora's data indicates that this product

should be used strictly in joints between 3/8" and 1" in width. Sealant depth should be a minimum of 0.25 inches for joints up to 0.50 inches wide and 1/2 the width in joints up to 1 inch wide. For joints greater than 1 inch wide, please call Pecora Technical Services. Through cure times will also be prolonged in joints of greater dimensions.

**Joint Preparation:** Contact area should be clean, sound and free of contaminating substances such as oil, grease, asphalt, tar, etc. Dampness but not saturation or standing water in porous substrates can be tolerated. **Keep sacking material out of tilt-up panel joints that will be filled with Tilt-Seal™.**

**Joint Backing:** Joints greater than 1/2" (12 mm) deep should be filled to within 1/2" (12 mm) of the surface with either polyethylene or polyurethane backer rod, preferably of a non-gassing, non-absorbing type. Use a diameter that will compress about 25% when installed. In joints too shallow to take backer rod, use a bond

### TYPICAL PHYSICAL PROPERTIES

Test Property	Value	Test Procedure
Adhesion and Peel (pli)		AAMA 800-94
Concrete	28	
Aluminum	29	
Glass	27	
PVC	27	
Wood	28	
Artificial Weathering	Pass	ASTM C732
Cycle Movement (±25)		ASTM C719
Aluminum	Pass	
Glass	Pass	
Concrete	Pass	
Extrudability (4 g/sec.)	Pass	ASTM C731
Hardness, Shore A	28	ASTM C661
Low Temperature Flex	Pass	ASTM C793
Tack Free Time (hours)	1-2	ASTM C679
Slump	<0.2" (Pass)	ASTM D2202
VOC (g/L)	<50	ASTM D3960
Volume Shrinkage		
Colors	26%	ASTM C1241
Translucent	50%	ASTM C1241

breaker tape to prevent three-sided adhesion.

**Priming:** Priming generally is not required.

**Application:** Do not apply this product when temperatures are 95°F and on the rise. Although the freezing point of Tilt-Seal™ is considerably below 32°F (0°C), for best performance, protect it from severe cold and apply above 40°F (4°C). Fill all joints completely and tool flush with surface to ensure full contact to both sides of the joint and present a smooth surface.

For architectural joints, use a resilient backer rod to control sealant depth or bond breaker tape to prevent three sided adhesion in shallow but moving joints. Fill joints completely and tool to ensure full contact to joint sides.

**Painting:** Sealant may be painted within 24 hours after application with high quality grades of latex or oil-based paints.

**Clean Up:** Water or damp cloth may be used to remove excess sealant from substrate and clean tools before cure. Cured sealant must be removed with a scraper or knife.

**Storage Life:** Eight months from date of manufacture when stored in original unopened bulk container below 80° F (27°). Sealant can withstand five (5) freeze-thaw cycles, however, for best performance, protect from serious cold.

**Precautions:** Tilt-Seal™ is non-flammable, non-toxic, non-irritating, and environmentally safe. Do not take internally. Refer to Material Safety Data Sheet for additional information.

**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](http://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 recaulk. No primer is required. If the bond has been affected, remove the sealant, clean and prepare the joint in accordance with the instructions under "INSTALLATION".

## 9. TECHNICAL SERVICES

Pecora representatives are available to assist you in selecting an appropriate product and to provide on-site application instructions or to conduct jobsite inspections. For further assistance call our Technical Service Department at 800-523-6688.

## 10. FILING SYSTEMS

- Sweet's Catalog File: [www.sweets.com](http://www.sweets.com)
- General Building
  - 07100 Waterproofing
  - 07920 Sealants
- Civil Engineering
  - 07100 Waterproofing



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