1. BASIC USES
Synthacalk™ GC2+ provides a durable, elastomeric, weather-tight seal for caulking joints in commercial and industrial projects. It is particularly effective where exposure to solvents or chemicals is anticipated.

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

3. PRODUCT DESCRIPTION
Typical Applications: Synthacalk™ GC2+ is a two part, polysulfide, non sag sealant that maintains an effective bond between materials of similar or dissimilar porosities, surface texture, or expansion coefficients. Typical applications include swimming pools, fountains, cooling towers, fuel and chemical storage tanks, wastewater treatment and petrochemical plants.

Limitations: Synthacalk™ GC2+ is not recommended for:
• Structural or butt glazing.
• Joints less than 1/4" (6 mm) in width or depth.
• Certain architectural paints and finishes without prior testing.

PACKAGING
• 1-1/2 gallon (3.8L) unit
Consisting of base and activator nested in 2-gallon pail.

COLOR
• Dark Grey

4. TECHNICAL DATA
Applicable Standards: Synthacalk™ GC2+ meets or exceeds all aspects of Federal Specification TT-S-00227E, Type II, Class A in all respects except Section 3.5.7, “Stain and Color Change”, ASTM C920, Type M, Grade NS, Class 25, Use, NT, T, M, G, A, with the exception of ASTM C510 “Stain and Color Change”, Also exceeds the test requirements of ASTM C1247 for sealants exposed to continuous immersion in liquids and NSF Standards 61, Section 6 for Joining and Sealing Materials.

Synthacalk™ GC2+ two component joint sealant is resistant to the effects of sunlight, rain, snow, ozone, aging, shrinkage, and the daily and seasonal cyclic changes in temperature, even after years of exposure.

5. INSTALLATION
Joint Design: The minimum width of the joint should be 4 times the anticipated movement, but not less than 1/4” (6 mm). Maximum recommended width is 1” (24 mm). The depth of the joint should be no more than one-half the width without exceeding the minimum/maximum limits. Maximum depth should be 1/2” (12 mm). For additional information, contact Pecora’s Technical Services Department.

Surface Preparation: Joint interface must be clean, dry, and free from oils, loose mortar, laitance, waterproofings, and other contaminants. A thorough grinding, sandblasting, or solvent cleaning may be required to expose clean, sound surfaces.

Priming: Synthacalk™ P53VOC primer must be applied under joint surfaces. Sealing must be applied after primer has dried, but within 8 hours after application.

Joint Backing: Backer rod is necessary to control depth of sealant and provide a base for tooling pressure. Backer rods should be closed-cell polyethylene foam. Use a size that will compress at least 25% when inserted into the joint. In joints too shallow for backer rod, a bond-breaker tape should be used to prevent three sided adhesion. (Typical bond breakers are polyethylene tape or coated papers).

Application: Synthacalk™ GC2+ is supplied in a non-sag consistency which will gun easily with conventional caulking equipment. Fill joint completely, using standard caulking equipment and tool immediately. Proper width to depth ratios must be maintained. Thorough blending of the base and activator components is essential for optimum sealant performance. Remove the Activator (Part A) from the Base (Part B) container. Also, be sure to remove the polyethylene sheet or tray. Before adding Part A, mix Part B with a Pecora #2 mixing paddle with a low speed, heavy duty electric drill. Then, add Part A to Part B and mix for six (6) minutes, or until the material is completely blended, scraping down the sides of the container and mixing paddle periodically during mixing.

NOTE: Do not mix base and activator components from one shipment with components from another.

Application Life: 1 hour at 75° F (24° C); higher temperatures shorten application life. Substrate temperature must range between 50° F (10° C) and 110° F (43° C).

Shelf Life: One year in original, unopened containers stored at temperatures lower than 80°F (26°C).

<table>
<thead>
<tr>
<th>Test Property</th>
<th>Value</th>
<th>Test Procedure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Specific Gravity, mixed (g/ml)</td>
<td>1.70</td>
<td>ASTM D70</td>
</tr>
<tr>
<td>Solids (%)</td>
<td>100</td>
<td>ASTM C1250</td>
</tr>
<tr>
<td>Joint Movement (%)</td>
<td>+/-25</td>
<td>ASTM C719</td>
</tr>
<tr>
<td>Hardness (Shore A)</td>
<td>25-30</td>
<td>ASTM C661</td>
</tr>
<tr>
<td>Work Life (hours)</td>
<td>1</td>
<td>Pecora Corporation</td>
</tr>
<tr>
<td>Tack-Free (hours)</td>
<td>&lt;24</td>
<td>ASTM C679</td>
</tr>
<tr>
<td>Elongation (%)</td>
<td>500-550</td>
<td>ASTM D412</td>
</tr>
<tr>
<td>Tensile Strength (psi)</td>
<td>150-200</td>
<td>ASTM D412</td>
</tr>
<tr>
<td>100% Modulus (psi)</td>
<td>50</td>
<td>ASTM D412</td>
</tr>
<tr>
<td>200% Modulus (psi)</td>
<td>80</td>
<td>ASTM D412</td>
</tr>
</tbody>
</table>

Since Pecora architectural sealants are applied to varied substrates under diverse environmental conditions and construction situations it is recommended that substrate testing be conducted prior to application.
Tooling: Tooling is recommended immediately after application to ensure full contact with the joint interfaces. Dry tooling is preferred. Care should be taken to avoid contamination of open joints.

Clean Up: Remove Synthacalk™ GC2+ from equipment before it cures. Recommended solvents are MEK®, Toluene® or Xylene®. These solvents are not effective after cure. Cured material may be removed by cutting with sharp tools, sandpapering or softening with chlorinated solvents.

*(Solvents mentioned are toxic and flammable. Observe solvent manufacturer’s precautions and refer to Safety Data Sheets.)*

Allow Synthacalk™ GC2+ to attain a complete cure before filling caulked area with water (7 days minimum). Surface of Synthacalk™ GC2+ can be painted after complete cure.

Precautions: Wear gloves or a barrier hand cream. Avoid direct contact with material; do not take internally. Remove promptly from skin with a commercial hand cleaner before eating or smoking. Avoid inhaling vapors.

FOR PROFESSIONAL USE ONLY.

KEEP OUT OF THE REACH OF CHILDREN.

6. AVAILABILITY AND COST

Pecora products are available from our plants and warehouses, or from stocking distributors in all major cities. For the name and telephone number of your nearest representative call 800-523-6688 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 in materials for, or refund the purchase price of, any product proven to be defective when installed in accordance with our published recommendations and in application considered by us as suitable for this product. This warranty is in lieu of any and all other warranties, expressed or implied, and in no case will Pecora be liable for 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 information and assistance, please call our Technical Services department at 215-723-6051 or 800-523-6688.

10. FILING SYSTEMS

http://www.4specs.com

07 10 00 Waterprooﬁng
07 92 00 Sealants

CHEMICAL RESISTANCE CHART

This data should only be used as a guide. It is recommended to test the material under actual (or at least simulated) service conditions before specification and/or use.

Rating Key:

R = Recommended
C = Intermittent Contact; not continuous immersion
NR = Not Recommended

| Rating | Acetic Acid, 10% | Acetic Acid, 50% | Acetic Acid, Glacial | Acetic Anhydride | Acrylic Acid | Acrylic Resin | Alumunium Sulfate, Solution, 50% | Ammonium Chloride Solution, 50% | Ammonium Hydroxide, Solution, 28% | Ammonium Perchlorate, 15% | Ammonium Persulfate, 50% | Ammonium Polysulphate | Ammonium Sulfate, Solution, 30% | Amyl Alcohol | Arachis Oil, PP, Acetate | ASTM fuel A | ASTM fuel B | ASTM fuel C | ASTM fuel D | Barium Hydroxide, 10% | Benzene | Benzoic Acid, 9-88 | Benzocarbonate, 5% | Borax Solutions, 25% | Boric Acid Solution, 20% | Boronhydride Solution | Luteanol, 1,4 | Butyl Benzo Phthalate | Butyl Cellosolve | Butyl Cellosolve Acetate | Butyl Polyester | Butyl Oxotol | Calcium Chloride Solutions, 50% | Calcium Hydroxide, 20% | Calcium Hypochlorite, 50% | Carbon Disulfide | Carbon Tetrachloride | Carbitol Acetate | Carbitol Alcohol | Caustic Potash, 45% | Caustic Soda | Chlorinated Water, 1ppm | Chlorinated Water, 10ppm | Chlorinated Water, 100ppm | Chronic Acid | Chronic Acid, 35% | Copper Sulphate Solution, 20% | Creosote | Cumene Hydroperoxide | Cyclohexane | Dibutyl Carbitol | Diethylen Glycol | Diphenyl Formamide | Epichlorohydrin | Ethyl Acetate | Ethyl Acrylate | Ethyl Alcohol | Ethyl Acrylate | Ethyl Alcohol | Ethylene Glycol | Ferric Chloride, 50% | Ferrous Sulphate, 10% | Fluoric Acid, 10% | Formic Acid, 90% | Fuel Oil/ Diesel Fuel | Fluoride Acetate | Gasoline | Gasoline, Leaded | Gasoline, Unleaded | Gasket | Glycol Ether EM | Hestane | Herbicides | Hexane | Hexane Glycol | Hydrochloric Acid, 20% | Hydrochloric Acid, 37% | Hydrofluoric Acid, 5% | Hydrofluoric Acid, 10% | Hydrofluoric Acid, 40% | Hydrogen Peroxide, 3% | Hydrogen Peroxide, 20% | Hydrogen Peroxide, 35% | Isobutyl Alcohol | Isobutyl Isobutyrate | Isophorone, 79% | Isopropyl Alcohol | Isophorone | Isophorone | Jet Fuel (See ASTM Fuels) | Kerosene | Lacquer Solvents | Linseed Oil | Lubricating Oils | Magnesium Chloride Solution, 20% | Magnesium Hydroxide Solution, 30% | Malathion 50 | Maleic Anhydride, 25%, Slurry | 2-Mercaptosulphonic | Methanol | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate | Methyl Acrylate |

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