

### BASIC USES

- In-shop fabrication of windows as a primary bedding compound for glass in wood, vinyl and aluminum and steel sash; as a seam sealer, as well as cap, toe or heel beads for windows and doors.
- Perimeter weather seal for field glazing and window installation.
- Single component secondary IGU seal.
- Structural glazing of glass, metal and plastic. It may also be used as a weatherseal in structural glazing applications.

### MANUFACTURER

#### Pecora Corporation

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### PRODUCT DESCRIPTION

Pecora 896FC is a fast curing, fluid-free, one-part neutral curing, medium modulus silicone sealant specially formulated for the window and door glazing industry. Cured in the presence of atmospheric moisture, 896FC skins within minutes, cures through (1/4" bead) within 3-6 hours and exhibits excellent green strength.

#### Product Feature:

- Tenacious primerless adhesion to vinyl, PVC, Kynar 500/Hylar 5000 based paint and coatings, anodized aluminum, wood and most other common substrates associated with the fenestration industry.
- High strength and movement capabilities facilitating its use in most demanding metal, vinyl and wood window applications.

- The fluid free formula improves compatibility with various window components such as secondary IGU seals, laminated glass, gaskets and setting blocks.
- Designed to be applied from cartridges, bulk dispensing equipment and automated glazing tables.
- Fast cure-through which enables the manufacturer to increase productivity by reducing the holding period resulting in faster shipment of finished units.
- Non-objectionable odor.
- UV additive option available for black light visibility in translucent and light colors.
- Beaded Spacers option where spacers can be added directly into the sealant reducing "squeeze out" and "starved bond lines" for a constantly higher performing seal.

**Limitations:** Pecora 896 FC Silicone glazing sealant should not be used in the following applications:

- In totally confined spaces void of atmospheric moisture.
- With building materials that bleed oils, plasticizers or solvents.

### PACKAGING

- 10.1 fl. oz. (300 ml) plastic cartridges
- 20 fl. oz. (592 ml) sausages
- 50-gallon (189 L) drums COLOR

### COLOR

- Standard: Translucent, Translucent with UV additive, Black
- Available in 90 gallon minimums:
  - Tru-White, Dark Bronze, Crystal Blue, Almond, Earthtone
  - Custom colors
  - Beaded Spacer Option
- On surfaces that will require painting. •Where abrasion or abuse is expected.
- No blanket approval is given by Pecora Corporation for structural glazing applications. Pecora offers a structural glazing appraisal program that is designed to reduce the risk for all project participants and is required for all structural glazing projects.

TABLE 1: TYPICAL PHYSICAL PROPERTIES

TEST PROPERTY	VALUE	TEST PROCEDURE
Elastomer Formation (minutes)	<5	Pecora
Through-cure, 1/4" bead (hours)	3-6*	Pecora
Lap Shear (green) Strength (psi)		ASTM C961
1 hr	3.0	
2 hrs	10.9	
3 hrs	22.2	
Peel Adhesion		
Kynar	Pass	ASTM C794-10
Clean Anodized Aluminum	Pass	
Vinyl	Pass	
Hardness Shore A	27	ASTM C661
Elongation (%)	850	ASTM D412
Tensile Strength (psi)	200	ASTM D412
Modulus, 100 % Elongation (psi)	45	ASTM D412
Dynamic Joint Movement (%)	±25	ASTM C719
Staining (including vinyl)	None	TFS-001543A (Com-NBS)
Ultraviolet & Ozone Resistance	Excellent	
Service Temperature Range	-60°F to +300°F	
VOC (g/L)	<100	ASTM D3960
VOC Emissions (TVOC)	<2 ug (0.002 mg)/ou m	CDPH v1.1-2010 (CA Specification 01350)

\* Increased atmospheric moisture will decrease cure time

### TECHNICAL DATA

Federal Specification TT-S-001543 A, TT-S-00230C Class A and ASTM C-920, Class 25, Type S, Grade NS, Use G, A, M, O, ASTM C-1184-g1.AAMA 802.3 Type I & II, AAMA 805.2, CAN 2-19.13-M82 (19-GPgMA).

### 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.

**Application:** Install backup material or joint filler. 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.

**Structural Sealant Joint Design:** The design professional is responsible for the determination of the structural sealant joint dimension based on design windloads, glass sizes and anticipated thermal movement. Pecora Corporation must verify and approve joint dimensions on an individual project basis.

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

**Shelf Life:** Pecora 896FC silicone glazing sealant has a shelf life of nine (9) months from the date of manufacture when stored at temperatures lower than 80°F (27°C).  
**Precautions:** Use with adequate ventilation or wear an appropriate

NIOSH-approved respirator. Contact with uncured sealant or with vapors generated during curing may cause respiratory tract irritation. Contact with skin or eyes may cause irritation or allergic reaction. Avoid contact and wash thoroughly after handling. May be harmful if swallowed. Refer to Safety Data Sheet (SDS) for more information.

**Priming:** Pecora 896FC 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.

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

### 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 one of our locations listed below or visit our website at [www.pecora.com](http://www.pecora.com).

### 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 proved 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 of 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.

### MAINTENANCE

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

### 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 or 215-723-6051.

### FILING SYSTEMS

CSI MasterFormat Designation  
- 07 92 00 - Joint Sealants  
- 08 85 00 - Glazing Accessories