

### BASIC USES

Pecora 860 is an economical, one-part, acetoxysilicone sealant designed for glass shop glazing jobs, industrial applications and general purpose sealing. The sealant cures in the presence of moisture and adheres well without primer to glass, many plastics, aluminum and steel, fiberglass, ceramics and wood, including painted surfaces.

### MANUFACTURER

#### Pecora Corporation

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### PRODUCT DESCRIPTION

When fully cured and washed, Pecora 860 meets the requirements of FDA Regulation 21CFR177-2600 for use on countertops and other areas where it may be in repeated contact with food.

**Limitations:** Pecora 860 should not be used:

- In aquariums or under water.
- On masonry, concrete or natural stone.
- On copper, lead or galvanized metal.
- On oily woods or building materials that bleed oils, plasticizers or solvents, including some types of setting blocks, gaskets and tapes.
- In totally confined areas which would retard the sealant cure.
- In structural glazing applications.
- On surfaces that require the sealant to be painted.
- For below grade applications.
- On horizontal traffic areas.

### TECHNICAL DATA

Consult Typical Physical Properties Chart.

#### Applicable Standards

FDA and USDA Approved. Meets or exceeds Federal Specifications TT-S-00230C and TT-S-001543A (COM-NBS) and ASTM C-920 Type S, Class 25, and Mil-A-46106A, Type 1, CAN/CGSB-19.13-M87.

### INSTALLATION

**Joint Design:** Joints should be designed four times the anticipated movement of building components. Joints should not be less than 1/8" (3 mm) wide. In joints up to 3/8" (9 mm) wide, the depth should be equal to the width. In joints wider than 3/8" (9 mm) and not exceeding 1" (25 mm), the depth should be maintained at 3/8" (9 mm).

**Surface Preparation:** Surfaces should be clean, dry and free of all contaminants such as protective coatings, oils, grease and soap or detergent films.

**Primer:** No primer is required for aluminum and glass surfaces. However, for maximum adhesion on other glazing materials, priming may be recommended. A bead of silicone sealant on the substrate material is always recommended to test adhesion prior to job use. Some materials such as fluoropolymer coatings, PVC, polycarbonate, acrylic

### PACKAGING

- 10.1 fl. oz. (300 ml) plastic cartridges

### COLOR

- Black, Metallic Aluminum, Tru-White, Translucent

and other materials with variable surface characteristics often need priming.

Primers for other substrates:  
Wood (pine): P-120

Metals (copper, steel, and some aluminum): P-120

**Masking:** Surfaces adjacent to joints should be masked before priming and/or sealant application to prevent staining and present a neat sealant line.

**Backer Rod:** Install a resilient, nongassing backer rod or bond breaker tape in joint too shallow for backer rod.

**Application:** The sealant should be applied in a continuous operation using sufficient pressure to fill the joint completely and ensure firm contact to the joint sides.

**Tooling:** Tool sealant slightly concave before skin forms (5 to 10 minutes). The sealant normally is tack free within 30 minutes and cures through (1/8" (3 mm) bead) within 24 hours, depending on temperature and humidity.

TABLE 1: TYPICAL PHYSICAL PROPERTIES

TEST PROPERTY	VALUE	TEST PROCEDURE
Elongation (%)	475	ASTM D412
Hardness, Shore A	20-25	ASTM C661
Movement Capability (%)	+25	ASTM C719
Tensile Strength		
@ 100% Elongation, modulus (psi)	62	ASTM D412
Ultimate (psi)	270	ASTM D412
VOC Content: (g/L)	25	ASTM D3960

**Cleaning:** Immediately remove all uncured sealant and smears adjacent to joints with mineral spirits. For equipment cleanup, also use mineral spirits. Consult manufacturer's MSDS for handling and safety precautions.

**Shelf Life:** 12 months in original unopened cartridges when stored at temperatures below 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..

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

### 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).

### 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.

### 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".

### 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 00-523-6688.

### FILING SYSTEMS

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

