

# Pecora 896HIS

## Specification Data Sheet



High Impact Silicone / Security, Impact, and Blast Applications

### I. BASIC USES

- Protective Glazing
- Impact glazing applications
- Structural Glazing
- Blast Protective Glazing
- Tamper Resistant Security Applications

### 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, and tamper resistant security applications. It features 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)

- High Shore A durometer per tamper resistant performance in security applications
- 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 -

- 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.
- For cartridge applications requiring sealant beads less than 3/16" Pecora recommends the 1215 Gun Grade or Semi Self-Leveling (SSL) Silicone Seam Sealer.

### PACKAGING

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

### COLOR

- Black, Aluminum Stone, Translucent

### 4. TECHNICAL DATA

#### 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
<b>Cure time / Full adhesion</b>		
Confined joint configurations (weeks)	2-3	Pecora Corp.
Exposed joint configurations (days)	7	

#### TYPICAL CURED PROPERTIES

Test Property	Value	Test Procedure
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 C794
Ozone/UV Resistance	Excellent	ASTM C793
Staining, Color Change	None	ASTM C510
Service Temperature Range (°F)	-60 to +300	Pecora Corporation

## 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.

## 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 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.

**Storage:** 9 months for 20 oz sausage packs, 6 months in 10.1 oz cartridges or 50 gallon drums from the date of manufacture when stored in original, airtight containers at temperatures below 90°F (32°C).

**Precautions:** Use in well-ventilated areas. Contact with uncured sealant may irritate eyes or skin. Flush eyes with water for fifteen minutes and seek medical attention if irritation persists. May be harmful if swallowed.

Consult 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 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

• CSI MasterFormat Designations:

-07 92 00: Joint Sealants

-08 85 00: Glazing Accessories

-08 88 53: Security Glazing

-08 88 50: Ballistics-Resistant Glazing

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