



### 1. BASIC USES

- Expansion and control joints in precast panels, tilt walls and curtainwalls
- Bedding panels, coping joints, window and door perimeters, and EIFS perimeters
- Glazing 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

PCS Pecora Contractor Silicone is a one-part, neutral cure, medium modulus silicone sealant designed for moving joints in exterior window and door perimeters, concrete panels, tilt-up panels, curtainwall and EIFS.

#### Product Advantages:

- Primerless adhesion to most common building substrates.
- 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 conditions.
- PCS Translucent silicone is 100% compatible for edge contact to laminated and insulated glass units.

#### Limitations:

Pecora PCS should not be used in the following applications:

- Continuous water immersion
- Natural stones without prior testing for compatibility
- Laminated or insulated glass without prior compatibility testing for all PCS Pecora Contractor Silicone colors except translucent.

### PACKAGING

- 10.1 fl. oz. (300 ml) plastic cartridges
- 20 oz. (592ml) sausages
- 2 gallon (7.57L) pails (Special Order available in 30 gallon minimum quantities)

### COLOR

- Window Bronze, Anodized Aluminum, Aluminum Stone, Tru-White, Translucent, Limestone, Black, Sandstone
- Custom colors are available in 30 gallon minimum quantities.

### 4. TECHNICAL DATA

PCS Pecora Contractor Silicone meets or exceeds the requirements of the following industry specifications:

ASTM C-920, Class 50, Type S, Grade NS, Use G,M,A,O TT-S-230C, Class A CGSB-19GP-9 CAN/CGSB-19.13-M87

Acceptance by U.S. Department of Agriculture for use in meat and poultry processing plants.

### 5. INSTALLATION

**Joint Design:** A thin bead of silicone will accommodate more movement than a thick bead. The bead should be no thicker than 3/8" (9 mm) and no thinner than 1/8" (3 mm) for joints where excessive movement is expected. Ideally, the ratio of joint width to the sealant depth should be about 2:1 when appropriate. Lap shear joints should have a bead width which is

equal to or greater than the total anticipated movement. Small curtainwall panels and lites should allow a minimum width of 1/4" (6 mm) for the sealant bead. Larger panels for which a great deal of movement is expected should allow a minimum width of 1/2" (12 mm) for the sealant bead. Glazing of plastic lites and panels fabricated from plastic require larger than usual joint dimensions due to the plastics high coefficient of thermal expansion. The width of building expansion joints varies because of seasonal and daily changes in temperature. If PCS cannot be installed when the design width is approximately halfway between the dimensional extremes, the designed joint must be at least twice the total anticipated joint movement. Good architectural practice calls for joint design of four times the anticipated movement due to construction tolerances and material variances.

**Surface Preparation:** Clean all joints and glazing areas by removal of foreign matter and contaminants such as oil, dust, grease, frost, water, surface dirt, old sealants or glazing compounds and any protective coating. Porous substrates and precast concrete panels using form release agents other than polyethylene film should be cleaned by grinding, saw cutting, blast cleaning (water or sand), mechanical abrading or a combination of these methods which will provide a sound, clean and dry surface for sealant application. Dust, loose particles, etc. should be blown

### TYPICAL PHYSICAL PROPERTIES

| Test Property                     | Value       | Test Procedure |
|-----------------------------------|-------------|----------------|
| Cure Time 1/4" bead (hours)       | 6           | Pecora         |
| Dynamic Joint Movement (%)        | ±50         | ASTM C-719     |
| Elongation (%)                    | 650         | ASTM D-412     |
| Tensile Strength (psi)            | 110         | ASTM D-412     |
| Modulus, 100 % Elongation (psi)   | 35          | ASTM D-412     |
| Hardness Shore A                  | 18          | ASTM C-661     |
| Tack-Free Time (minutes)          | 30          | ASTM C-679     |
| Service Temperature Range (°F)    | -60 to +300 | Pecora         |
| Accelerated Weathering, 5000 hrs. | Pass        | ASTM C-793     |
| VOC (g/L)                         | 50          | ASTM D-3960    |

out of joints with oil-free compressed air or vacuum cleaned. 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.

**CAUTION:** Solvents may be toxic and/or flammable. Refer to solvent manufacturer's instructions or Material Safety Data Sheets.

**Priming:** PCS Pecora Contractor Silicone does not require priming on most common substrates. However, we strongly suggest adhesion pretesting, either in the field or in our laboratory, on all porous substrates, particularly brick, as well as unusual building materials and other substrates where special coatings or surface treatments may impair optimum adhesion. Where primer is indicated, P-150 should be used on porous substrates and P-120 on special metal and plastic surfaces. Also, Pecora offers complimentary adhesion and stain testing in its laboratory on actual field samples of substrate from the jobsite or on representative samples from the same lots. Contact Technical Services for details.

**Joint Backing:** Backer rod controls the depth of the sealant and allows it to be applied under pressure. Use a size that will compress 25%. Denver Foam open-cell polyurethane or reticulated (soft) polyethylene rod is recommended. Closed-cell polyethylene may be used but care must be taken not to puncture the rod which can cause outgassing or bubbling/blistering in the sealant. In joints too shallow for backer rod, use a polyethylene bond-breaker tape to prevent three-sided adhesion.

**Application:** All joints should be masked to ensure a neat appearance and prevent sealant applied outside the joint confines from imparting a discoloration to the substrate. Sealant should be applied in a continuous operation using sufficient pressure to fill the joint and make complete contact to the joint sides. Tool the sealant slightly concave using dry-tooling

techniques. Consult Technical Services prior to tooling with solvent. Do not tool with soap or detergent and water solutions.

**Tool Time:** (Initial skin): 15-25 minutes at 77°F (25°C), 50% relative humidity. Higher temperatures and/or humidity will shorten this time.

**Cleaning:** Immediately remove all excess sealant and smears adjacent to joints with mineral spirits. Also use mineral spirits for removing uncured sealant from equipment. Remove cured sealant by scraping, sandpapering, etc. (Caution: mineral spirits is flammable and toxic. Observe manufacturer's precautions.)

**Shelf Life:** Pecora Contractor Silicone has a shelf life of 12 months from date of manufacture when stored in unopened cartridges or sausages at temperatures lower than 80° F (27° C), or 9 months in tightly-sealed bulk packages 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 Material Safety Data Sheet (MSDS) for more 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. LIMITED WARRANTY

Pecora Corporation warrants PCS Pecora Contractor Silicone to meet the published specifications within the published shelf life. Under this warranty, we will provide, at no charge, replacement materials for or refund the purchase price of PCS if proven to fail to conform to published specifica-

tions. 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 damage.

## 8. MAINTENANCE

If the sealant is damaged and the bond is intact, 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 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

