

Pecora 1215 Seam Sealer

Specification Data Sheet



High Performance Silicone Narrow Joint Sealant

1. BASIC USES

- In-shop fabrication of windows and doors for narrow corner joints and seams
- Fastener heads and rivet seams
- Butt joint seams

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 1215 Seam Sealer is a one-component, neutral curing, 100% silicone based seam sealer designed for sealing narrow joints and seams in glazing applications as well as other industrial OEM processes. It features low odor, ease of application, fast moisture cure, 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 Silicone Seam Sealer offers the following features -

- Rapid through cure
- VOC compliant and mild odor
- Superior adhesion: Will bond tenaciously to most substrates without the need for priming.
- Adheres extremely well to glass fiber reinforced polyamide composite structured thermal barriers.
- Excellent weatherability and color stability: Because of its 100% silicone composition, it is virtually unaffected by UV, ozone, and temperature extremes.

- Resilient: Will remain flexible under extreme temperature swings (-60°F to 300°F)
 - Compatible with polymeric thermal break systems
 - Black light sensitive for accurate in process Quality Control checks (available in Tru-White and Translucent).
 - Fast cure
 - High Solids
 - Easily adapted to existing processes currently utilizing traditional high VOC sealant materials.
 - Will not harm plastics such as polycarbonate or acrylic.
 - Compatible with acrylic and polycarbonate based security glazing materials (Lexan® and Plexiglas®).
- Limitations:** Pecora 1215 Seam Sealer should not be used in the following applications -
- Sealing submerged joints or below the waterline in marine uses.
 - In designs that will be painted after application of the sealant. Sealant should be applied after painting is completed.

- In expansion and control joints.

Product Option: Pecora offers a Semi-Self Leveling (SSL) option with the 1215 Seam Sealer. In addition to small orifice pump-ability, the 1215-SSL technology will flow in a controlled manner around screw heads, bolt holes, corner details and mechanical fasteners without the need for further tooling. Please contact the Pecora Technical Service Group for more details regarding the 1215-SSL technology and availability.

4. TECHNICAL DATA

Applicable standards: Pecora Silicone Seam Sealer meets or exceeds the requirements of the following industry specifications: AAMA 803.3, Type I&II

PACKAGING

- 10.1 oz. (300ml) cartridges
- 5-gallon (18.9L) pails
- 50-gallon (189L) drums

COLOR

- Tru-White, Translucent and Black

TYPICAL UNCURED PROPERTIES

Test Property	Value	Test Procedure
Sag, inches (1/8" thickness)	<0.1	ASTM C-2202
Initial Skin (minutes)	15-20	Pecora Corp.
Through Cure, 1/8" bead (minutes)	120	Pecora Corp.
Odor	Mild	Pecora Corp.
% Solids	82	Pecora Corp.
Viscosity (cps, Brookfield)	60,000	Pecora Corp.

TYPICAL CURED PROPERTIES

Test Property	Value	Test Procedure
Ultimate Extension (%)	300	ASTM D-412
Modulus @ 100% ext. (psi)	40	ASTM D-412
Ultimate Tensile strength (psi)	75	ASTM D-412
Peel strength (pli)	Pass	AAMA 803.3, sec.2.4
Ozone/UV resistance	Excellent	ASTM C-793
Staining, color change	Excellent	ASTM C-510
Service temp. range (°F)	-60 to +300	Pecora Corp.
VOC (g/L)	<250	ASTM D-2369

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.

Priming: Pecora 1215 Seam Sealer 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: Do not open 1215 until ready for use. 1215 is sensitive to humidity. Replace lid or Plews gun pin when not in use. Application by cartridge or Plews gun is recommended. When appropriate, mask areas to be protected from overfill and tooling. Remove masking tape while sealant is still uncured. Avoid air entrapment during application and tooling.

Cleaning: Excess sealant should be removed from all surfaces while still uncured using Iso-propyl Alcohol or Windex®. Cured sealant is very difficult to remove without altering or damaging the surface it is adhered to. Refer to solvent manufacturer's Material Safety Data Sheet.

Shelf Life: Twelve months from manufacture in original, unopened containers when stored at temperatures below 80°F (27°C).

Precautions: Contact with uncured sealant, with vapors generated during curing, or with dust formed from cured sealant may cause eye, skin, or respiratory tract irritation and possible allergic reaction. Use only with adequate ventilation or wear an appropriate NIOSH-approved respirator. Avoid contact and wash thoroughly after handling. May be harmful if swallowed. Keep away from heat, sparks and flame. 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.

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 installed in 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, 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 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

General Building
07100 Waterproofing
07920 Sealants
08850 Glazing
Civil Engineering
07100 Waterproofing



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