

# Pecora 322FC

Fast Cure Traffic Silicone

## Specification Data Sheet



### I. BASIC USES

Pecora 322FC can be used in new construction as well as a restoration sealant in remedial work. Parking structures, parking lots, sidewalks, loading/material transfer docks, concrete roadways, and vehicular and pedestrian bridges and plazas. Typical surfaces sealed with Pecora 322FC include concrete, asphalt, carbon steel, and pre-cast pavers. All masonry surfaces typically require the use of a primer. Asphalt surfaces do not require primer use. Pecora 322FC is a self-leveling material for use in joints up to two inches in width with slopes of 6% or less. Please contact Pecora Technical Services before specifying this product.

### 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 322FC is a two-part, cold-applied, self-leveling, fast-curing, ultra-low modulus, 100% silicone material designed for sealing of concrete pavement joints experiencing thermal movement. Pecora 322FC cures to a resilient silicone rubber seal in a very short time when compared to a typical one part moisture cure sealant. This is especially beneficial when sealing joints that will experience movement shortly after sealant application. These applications include bridges, parking structures, parking lots, sidewalks, pedestrian decks and plazas.

#### Advantages:

- Excellent weatherability- This sealant's 100% silicone composition is virtually unaffected by UV, precipitation, ozone, and temperature extremes.
- Sealant will remain flexible under extreme temperature swings. (-49°F to 300°F)

- Fast Curing- This sealant's fast cure profile allows quick job site turn-around. Early movement will not affect sealant performance.
- Self-leveling- No tooling required when applied through typical static mixing equipment.
- One-to-one volume mix ratio- Packed in convenient sausage packs, static mixing required, easy loading, and minimal waste.
- Auto-bonding- Will bond to itself tenaciously without the need for priming.

#### Limitations:

- Pecora 322FC should not be used under the following conditions.
- In applications involving natural stones. There is the potential for staining these surfaces.
  - In totally confined spaces.
  - To surfaces that will be painted.

- In applications involving total water immersion.
- Sealant cannot be mixed in an open bucket using standard mixing paddles. Proper static mixing equipment must be used.
- This product is intended for industrial use only.
- For bridge nose repairing. In combination with polymeric nosing details.

#### PACKAGING

- 2 - 20 fl. oz. (592 ml) sausage kit. Including Part A and one labeled Part B are required for a total of 40 fl.oz. (1.18 L) per loading.
- Light Gray

### 4. TECHNICAL DATA

Applicable Standards: Complies with TT-S-0023C, TT-S-001543, ASTM C920, Class 100, Type M, Grade SL, Use T<sub>2</sub>, M, O, ASTM D5893 Type SL.

TABLE I: TYPICAL PROPERTIES  
(NOT INTENDED FOR USE IN PREPARING SPECIFICATIONS)

As Supplied	Type	Ultra-low modulus	
	Cure	Two-part	
	Color	White, Dark gray	
	Consistency	Self-leveling	
	Work life	20 minutes	
	Service time	24 hrs.	
	Full Cure, 77°F/50%RH	48 hrs	
As Cured 21 Days 77°F/50%RH	ASTM D 412	E <sub>B</sub> , %	1400
	ASTM D 412	T <sub>B</sub> , psi	50
	ASTM C 1135	25 <sub>M</sub> , psi	5
		50 <sub>M</sub> , psi	12
		150 <sub>M</sub> , psi	15
	ASTM C 1135	E <sub>b</sub> , %	>600
	ASTM C 719	% Movement	+100/-50
ASTM D 2240	Shore 00	55	

## 5. INSTALLATION

**Surface Preparation:** Joint surfaces and backer rod must be dry and free of all contaminants such as oil, grease, dust, corrosion, tar, asphalt, loose aggregate, frost, form release agents, and decorative and protective coatings. Methods of removal may include sandblasting, wire brushing. Refer to Pecora Technical Bulletin 109 for general surface preparation guidelines. Priming may be required. P-200 on concrete. No primer on asphalt. Proper adhesion should be confirmed prior to full scale production.

**Application:** Pecora 322FC is applied as a self-leveling material. It is a low modulus material, which will withstand extreme movement when applied properly. 322FC will withstand movement up to 100% in extension and 50% in compression. However, when designing joint systems it is advised that movement ranges are limited to +/- 25% movement. This will ensure a long lasting, durable bond by providing a built in tolerance for variations in job site conditions.

The Base and Activator are formulated to function as a unit. The two components should be used simultaneously in the Albion Engineering 20x20oz. AT Line Powered Multi-Component Sausage Gun, Model AT1200S.

**Static Tip Purging:** Purge static mixing tip with Part A only when not in use.

**Joint Design:** Maximum joint depth at the crown of the backer rod is 0.5 inches. Minimum joint depth at the crown of the backer rod is 0.25 inches. A closed cell backer rod is recommended. An open cell backer rod with continuous outer

impervious skin being acceptable when irregular joint widths are encountered. The open cell backer rod is more compressible and able to accommodate irregular joint widths. All sealant applications should be recessed from the joint surface a minimum of 0.25 inches. For joints in excess of 2.0 inches in width the recess requirement should be increased to as much as 0.5 inches.

**Tool Time:** (Initial Skin): 20 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 322FC has a shelf life of 12 months from date of manufacture when stored in an unopened sausage 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 the Safety Data Sheet (SDS) for more information.

**KEEP OUT OF REACH OF CHILDREN.**

**FOR PROFESSIONAL USE ONLY.**

## 6. AVAILABILITY AND COST

Pecora products are available from stocking distributors nationwide. For the name and telephone number of your nearest Pecora 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 installed in accordance with our published recommendations and in applications considered by us as suitable for this product. 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 effected, 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

<http://www.4specs.com>  
 03 99 20 Concrete Patching and Resurfacing  
 07 18 00 Traffic Coatings  
 07 92 00 Joint Sealants  
 08 85 00 Glazing Accessories

ESTIMATED SEALANT USAGE JOINT WIDTH, INCHES	JOINT DEPTH, INCHES	40 OZ. KIT YIELD LINEAR FEET
0.5	0.25	35
1.0	0.5	9
1.5	0.5	6
2.0	0.5	4.5
2.5	0.5	3.8
3.0	0.5	2.3

