

Pecora 985 - Dispensing Equipment Guidelines

The Pecora 985 Structural Silicone Sealant is a fast curing two part, high modulus, neutral curing silicone sealant specially formulated and compounded for use in shop-fabrication of structurally glazed curtainwall systems. The sealant exhibits an adjustable cure rate of 5 to 50 minutes allowing for fast fabrication and early movement of completed units. The use of a variable ratio dispensing system is required in order to apply the 985 Structural Silicone Sealant. Pecora recommends the *Graco ExactaBlend AGP* (Advanced Glazing Proportioner) to effectively dispense the sealant.

Information regarding the Grace ExactaBlend AGP dispensing equipment can be found on the Grace website at the following link:

<http://www.graco.com/us/en/products/sealants-and-adhesives/exactablend-agp.html>

Graco products are purchased via authorized distributors. A distributor locator can be accessed here:

<http://www.graco.com/us/en/where-to-buy.html?where-to-buy-code-na=graco:where-to-buy-code/aftd/agp&where-to-buy-code-emea=graco:emea-where-to-buy-code/sae/emea226&wcmmode=disabled>



Activator Portion (Curing Agent) - Storage & Handling

985 Activator is a concentrated blend of highly reactive silicone crosslinkers and catalyst. Because of this high concentration of reactive ingredients, 985 activator is very sensitive to atmospheric moisture. This sensitivity reveals itself as crystallization or hardening of the activator at the air / surface interface. When exposed to a combination of high humidity (>50% R.H.) and high temperature (> 70°F) the rate of crystallization or hardening increases as these conditions increase. Once crystallization occurs the hardened material is not usable as a curative and can also clog or slow automated application equipment. It is therefore extremely important to minimize or completely exclude atmospheric moisture from coming in contact with the activator portion of 985.

All pail lids must be kept tightly in place when not in use and the material stored in a cool and dry area, if feasible. Transferring opened pails to pail ram and follower plate should be done with minimal exposure of the activator to atmospheric moisture. Never allow opened pail to remain exposed to air for more than 2-3 minutes. If surface crystallization does occur the hardened material should be removed with a trowel or spatula before placing under the follower plate. Also any liquid vehicle that may be separated during storage or shipping should be reincorporated at this time. This can be easily done with a paint mixing stick or metal spatula by simple hand mixing until a uniform paste consistency is achieved.

Once 985 activator is introduced into the application equipment it remains very important to exclude atmospheric moisture from the system. This means ensuring airtight seals and dry air or zero nitrogen being used in pressure applications where there is the risk of introduction of pressurized air into the system.