

### BASIC USES

In-shop fabrication of windows as a primary bedding compound for glass in wood, vinyl and aluminum and steel sash; as a seam sealer, as well as cap, toe or heel beads for windows and doors.

Perimeter weatherseal for field glazing and window installation.

### MANUFACTURER

#### Pecora Corporation

165 Wambold Road  
Harleysville, PA 19438  
Phone: 215-723-6051  
800-523-6688  
Fax: 215-721-0286  
Website: [www.pecora.com](http://www.pecora.com)

### PRODUCT DESCRIPTION

Pecora 896 is a one-part neutral curing, medium-modulus silicone sealant specially formulated for the window and door glazing industry. Cured in the presence of atmospheric moisture, 896 skins within minutes, cures through (1/4" bead) in less than 24 hours and exhibits excellent green strength.

#### Product Features:

- Generally primerless adhesion to most non-porous surfaces such as vinyl, PVC, Kynar 500/Hylar 5000 based paint and coatings, anodized aluminum, and most other common substrates associated with the fenestration industry. Adhesion testing is always recommended to ensure proper performance.
- High strength and extreme movement capabilities facilitating its use in most demanding metal, vinyl and wood window applications.
- Fast through-cure which enables the manufacturer to increase productivity by reducing the holding period resulting in faster shipment of finished units
- Designed to be applied from cartridges, bulk dispensing equipment and automatic glazing tables.

- Compatible with all tested insulating glass units.
- Non-objectionable odor.
- A Seam Sealing Formulation (896 SSL) is also available.

**Limitations:** Pecora 896 Silicone glazing sealant should not be used in the following applications:

- To seal polycarbonate substrates.
- With building materials that bleed oils, plasticizers or solvents.
- On surfaces that will require painting.
- Where abrasion or abuse is expected.
- For cartridge applications requiring sealant beads less than 3/16" Pecora recommends the 1215 Gun Grade or Semi Self-Leveling (SSL) Silicone Seam Sealer.

### TECHNICAL DATA

Federal Specification TT-S-001543 A, TT-S-00230C Class A and ASTM C-920, Class 50, Type S, Grade NS, Use G.A.M.O., ASTM C-1184, AAMA 802.3 Type II, 805.2 Group C. CAN 2-19.13-M82 (19-GP-9MA).

### INSTALLATION

#### Directions for Use:

A. For traditional expansion joints a minimum joint width of 1/4" is required along with joint depth of a minimum 3/16".

### PACKAGING

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

### COLOR

- Available in standard architectural colors of Black, Tru-White, Translucent, Dark Bronze, Crystal Blue, Almond and Earthtone.
- Custom colors available in 30 gallon minimums.

B. When utilized as a bedding compound, window designs should be taken into consideration in close cooperation with the window manufacturer to determine proper glue line thickness and width.

C. All heel, toe, and cap beads should be applied and tooled to shed water.

D. Proper surface preparation should consist of removing all contaminants and foreign materials utilizing appropriate cleaning solvents. Consult Pecora Technical Bulletin TB74 for specific solvent cleaning procedures.

#### All Surfaces must be sound, clean and dry:

A. Install back-up material, setting blocks, spacer shims and tapes. Mask areas to be protected from overfill and tooling.

B. Conduct test applications for adhesion verification to ensure proper performance.

#### TYPICAL PHYSICAL PROPERTIES

| Test Property                              | Value                         | Test Procedure         |
|--------------------------------------------|-------------------------------|------------------------|
| Cure Time at 77°F/50%RH, 1/4" bead (hours) | 15                            | Pecora Corporation     |
| Dynamic Joint Movement (%)                 | ±50                           | ASTMC719               |
| Elongation (%)                             | 550                           | ASTMD412               |
| Durometer Hardness (Shore A)               | 27                            | ASTMC661               |
| Modulus, 100 %Elongation (psi)             | 55                            | ASTM D412              |
| Staining (including vinyl)                 | None                          | TT-S-001543A (Com-NBS) |
| Tack-Free Time (minutes)                   | 8-15                          | ASTM C679              |
| Service Temperature Range (°F)             | -60° F to 300° F              | Pecora Corporation     |
| Application Temperature                    | -20°F to 120°F                | Pecora Corporation     |
| Tensile Strength (psi)                     | 225                           | ASTM D412              |
| Ozone Resistance                           | Excellent                     | ASTM D1149             |
| VOC (g/L)                                  | 50                            | ASTM D3960             |
| VOC Emissions (TVOC)                       | Pass (All Exposure Scenarios) | CDPH V1.2-2017         |

# Pecora® 896

High Performance Silicone Window & Door Sealant



## SPECIFICATION DATA SHEET

C. Excess sealant should be removed from all surfaces while still uncured. Cured sealant is very difficult, if not impossible, to remove without damaging the surface.

D. Dries tack free in approx. 5 to 20 minutes depending on temperature and humidity.

E. Through cures will vary with glue line thickness, joint configuration, and ambient moisture exposure.

**Cleaning:** Excess sealant should be removed from all surfaces while still uncured. Cured sealant is very difficult to remove without altering or damaging the surfaces to which the sealant has been misapplied.

**Shelf Life:** Pecora 896 silicone glazing sealant has a shelf life of twelve (12) months from the date of manufacture when stored in unopened cartridges at temperatures lower than 80°F (27°C) or nine (9) months in tightly sealed bulk packages and performs equally well during any part of this shelf life.

**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 Safety Data Sheet (SDS) for more information.

**FOR PROFESSIONAL USE ONLY. KEEP  
OUT OF THE REACH OF CHILDREN.**

### AVAILABILITY AND COST

Pecora products are available from our plants and warehouses, or from stocking distributors in all major cities. For the name and telephone number of your nearest representative call one of our locations listed below or visit our website at [www.pecora.com](http://www.pecora.com).

### 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.

### 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 instructions under "INSTALLATION".

### 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 please call our technical services team at 215-723-6051 or 800-523-6688.

### FILING SYSTEMS

**•CSI MasterFormat Designations:**

-07 92 00: Joint Sealants

-08 85 00: Glazing Accessories