PECORA CORPORATION
Architectural Weatherproofing Products
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TB #214
Pecora 985 10:1 Cartridge Field Kit
Application Guidelines

PRODUCT
Pecora 985 Two Part Structural Silicone Sealant
10:1 CARTRIDGE FIELD KIT

PRODUCT DESCRIPTION
Fast curing, two-part, high modulus, neutral cure structural silicone sealant

COLOR
Base:	White
Curing Agent:	Black
Mixed:	Dark Grey (color code 970)

PACKAGING
490mL 10:1 dual cartridge field kit
12 cartridges per case (includes 12 static mixing tips, 3 threaded collars and 3 adapters)

DISPENSING EQUIPMENT
Battery Operated: Meritool Power Push 7000 Series Cordless Two Component Cartridge Dispenser, 20V 10:1 Mixpac 400 type (photo 1)

Photo 1

BASIC USES
Field applied structural glazing of glass and other substrates
In-shop structural glazing where a two-part sealant pump is not available
Field repairs of structurally glazed glass units
As a fast-curing adhesive for applications such as panel stiffeners

APPLICATION GUIDELINES

Surface Preparation
Thoroughly clean joint surfaces and glazing areas with solvent to remove all foreign material and contaminants such as oil, dust, grease, frost, water, old sealants or glazing compounds and any protective coatings. Cleaning of surfaces should be done just prior to the sealant's application. Soap or detergent and water solutions should not be used to clean lest they leave a form release film on the surface. Structural glazing requires even greater attention to surface cleaning. Technical Bulletin #56 addresses the proper procedures in greater detail.

Priming
The application of sealant primer may be required and should be determined via laboratory adhesion testing. Pecora requires that laboratory adhesion/compatibility testing on representative substrates and a glazing review be conducted for all structural glazing projects. Refer to the requirements published in Technical Bulletin #56. For most recent updates, please visit www.pecora.com

Sealant Application Procedure
Install backup fillers, setting blocks, spacer shims and tapes as specified. Apply any required sealant primers. Prepare cartridges and apply sealant as follows:

1. **Remove the collar and green plug from the nozzle end of the dual cartridge. (photo 2)**
2. **Attach static mixing nozzle by aligning small and large orifices then slide the collar over the nozzle and thread onto cartridge (photo 3).** A quarter to half turn is all that is necessary to secure the collar.
3. **Release locking mechanism and retract plunger rod on gun then slide cartridge into cradle of dispenser taking care to align slotted area of cartridge within slots of cradle.** Cartridge should be secure within cradle with nominal play. **Push plunger rod up against the cartridge plungers and activate locking mechanism**.

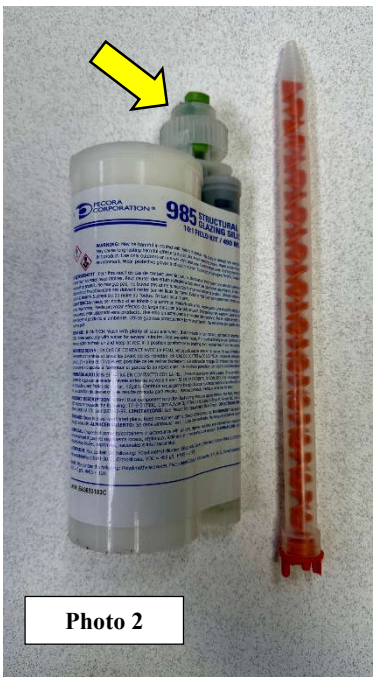

Photo 2


Photo 3

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4. **Depress trigger and dispense approximately 50 mL of sealant then test uniformity via the "Butterfly Test" as described in Pecora Technical Bulletin #164**. If necessary, repeat the purging process and Butterfly Test until the material is homogeneous.
    a. **Speed** and **Dose** can both be adjusted with the corresponding dials on the side of the tool. (photo 4). Both dials have an "off" position when spun all the way to the right. For the Dose this disables the function and allows the tool to run indefinitely while trigger is pulled. When the Speed dial is in the "off" position the tool is completely disabled and will not run. Adjust Speed dial to the desired flow rate. To minimize the chance of damage to the cartridge, the dispenser automatically adjusts its output force. You may experience a variation in motor speed associated with this function. If damage or blowback occur, adjust the speed control to a lower setting.
5. **Apply sealant.** A new static mixing nozzle is required for each cartridge. Do not reuse the static mixing nozzles.

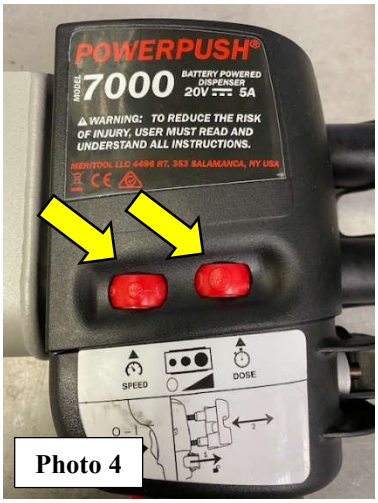

Photo 4

CLEANING

Excess sealant should be removed from all surfaces while still uncured using solvents such as Isopropyl Alcohol. Cured sealant is very difficult or impossible to remove completely without altering or damaging the surfaces to which the sealant has been misapplied.

CAUTION: Solvents used in cleaning may be toxic and/ or flammable. Refer to solvent manufacturer's instructions and Material Safety Data Sheet. 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.

SHELF LIFE & STORAGE

Twelve (12) months when stored in unopened cartridges at temperatures between 50°F and 80°F.

TYPICAL PHYSICAL PROPERTIES			
Test Property		**Value**	**Test Procedure**
Work Life, minutes		8-10	Pecora
Durometer Hardness, points	24hr cure	20-25	ASTM D2240
	7-day cure	30-35	
Ultimate Elongation, %	24hr cure	196	ASTM C1135
	7-day cure	134	
Ultimate Tensile Strength, psi	24hr cure	79	ASTM C1135
	7-day cure	133	
Modulus @ 100% Elongation	24hr cure	61	ASTM C1135
	7-day cure	110	
Movement Capability, %		+/-25	ASTM C719
Peel Adhesion		Pass	ASTM C794
Anodized Aluminum[1]			
Painted Aluminum (Kynar, Duranar)[1]			
Mill Finish Aluminum			
Glass[2]			
Vinyl			

[1] *Testing conducted on a variety of painted and anodized aluminum substrates with and without P-120 primer.*
[2] *Testing conducted on a variety of glass substrates without primer.*

TECHNICAL SERVICES

Pecora representatives are available to assist you in selecting an appropriate product and to provide on-site application instructions. For further information and assistance, please call our Technical Service department at 215-723-6051 or 800-523-6688.