

# Pecora® 985

## Structural Silicone Sealant



## SPECIFICATION DATA SHEET

### BASIC USES

- Pecora 985 is a fast-curing two-part, high modulus, neutral cure silicone sealant specially formulated for use in both field-applied and in-shop fabrication of structurally glazed systems.

### 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

The sealant is unaffected by UV, ozone, temperature extremes or atmospheric contamination and is compatible with a variety of plain and coated metals, high-performance glass, decorative paints, gaskets, setting blocks and spacers. (see note on page 2).

#### Features of Pecora 985:

- High tensile strength.
- Excellent working properties.
- Adjustable cure rate from 8 to 60 minutes allowing for fast fabrication and early movement of completed units.
- No lot matching of base and activator required.
- Unprimed adhesion to glass, reflective glass coatings, anodized aluminum and other metals and most fluorocarbon paints. (see priming).
- Negligible sag or slump.
- No corrosive by-products or objectionable odor.

**Limitations:** Conditions under which Pecora 985 should not be used:

- Where contact will be made with materials that bleed oils, plasticizers or solvents, i.e. impregnated wood, oil-based caulks, green or partially vulcanized rubber gaskets or tapes.
- In below-grade or submerged installations.
- In designs that require painting of the sealant.

### TECHNICAL DATA

**Applicable Standards:** Pecora 985 meets or exceeds the following: TT-S-00230C, Class A, Type II; ASTM C-920, Class 25, Type M, Grade NS, Use G,A,O; ASTM C-1184: AAMA 802.3-08, Type I; Missile Impact Miami-Dade PA 201 and SSID 12-99.

**Design:** The design professional is responsible for the determination of the structural sealant joint dimension based on design windloads, glass sizes and anticipated thermal movement. Pecora must verify and approve joint dimensions on an individual project basis.

#### Basic Design Parameters Include:

- Structural sealant thickness must not be less than 1/4" (6 mm).
- Structural bite must not be less than structural sealant thickness.
- Structural bite must be determined using the following formula:

$$\frac{W.L. \times (1/2) S}{12 \times 20} = C.W.$$

S = Short span of glass, feet

W.L. = Windload

PSF Constant = 12

Design Stress, psi Max. = 20

C.W. = Contact width

- The structural sealant joint must be able to be filled using standard caulking practices.
- The structural joint must not move during cure.

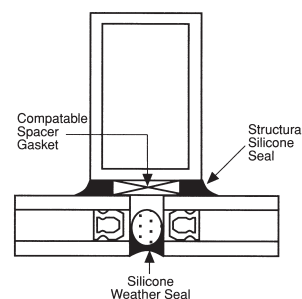
These are only preliminary guidelines. Consistent with common industry practice, PECORA CORPORATION DOES NOT GIVE BLANKET APPROVAL FOR STRUCTURAL GLAZING APPLICATIONS. PECORA TECHNICAL BULLETIN #56 OFFERS A STRUCTURAL GLAZING APPRAISAL PROGRAM DESIGNED TO REDUCE THE

### PACKAGING

- 55-gallon kits (208 L)
- 50-gallons (189 L) Part A Base and
- 5-gallons (18.9 L) Part B Curing Agent
- 490 ml (16.6 fl oz) 10:1 Dual Component Cartridge Field Kit

### COLOR

- Dark Gray (when mixed)
- Consult Pecora Technical Service for additional color options



RISK FOR ALL PROJECT PARTICIPANTS. STRUCTURAL PROJECT DETAILS MUST BE REVIEWED BY PECORA AND ALL SYSTEM COMPONENTS PRETESTED FOR ADHESION AND COMPATIBILITY BEFORE APPROVAL IS GIVEN.

### INSTALLATION

**Surface Preparation:** No sealant will maintain long-term adhesion if the substrate is not properly cleaned before

#### TYPICAL PHYSICAL PROPERTIES & COVERAGE RATES

| Test Property                                | Value                         | Test Procedure     |
|----------------------------------------------|-------------------------------|--------------------|
| <b>As Supplied - Base</b>                    |                               |                    |
| Specific Gravity                             | 1.20                          | ASTM D2320         |
| <b>As Supplied - Curing Agent</b>            |                               |                    |
| Specific Gravity                             | 1.03                          | ASTM D2320         |
| Flammability                                 | Non-Flammable                 | ASTM D1310         |
| <b>After Mixing*</b>                         |                               |                    |
| Specific Gravity                             | 1.18                          | ASTM D2320         |
| Working Time (minutes)                       | 15                            | Pecora Corporation |
| Corrosiveness                                | Non-corrosive                 | ASTM D3310         |
| Consistency                                  | Non-slumping                  | ASTM D2202         |
| VOC (g/L)                                    | 60                            | ASTM D3960         |
| VOC Emissions (TVOC)                         | Pass (All Exposure Scenarios) | CDPH v1.2-2017     |
| <b>As Cured - 7 Days at Room Temperature</b> |                               |                    |
| Shore A                                      | 35                            | ASTM D2240         |
| Elongation (%)                               | 134                           | ASTM C1135         |
| Ultimate Tensile Strength (psi)              | 130                           | ASTM C1135         |
| Stress @ 25% Extension (psi)                 | 34                            | ASTM C1135         |
| Movement Capability (%)                      | ±25                           | ASTM C719          |
| Cold Flow, Creep                             | Negligible                    | ASTM D2294         |
| Heat Resistance (°F (°C))                    | 300 (148)                     | Pecora Corporation |

\*Mixed by weight 12:1 or by volume at 10:1 base-to-curing-agent ratio.

# Pecora® 985

## Structural Silicone Sealant



## SPECIFICATION DATA SHEET

the sealant is applied. 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 (see caution).

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.

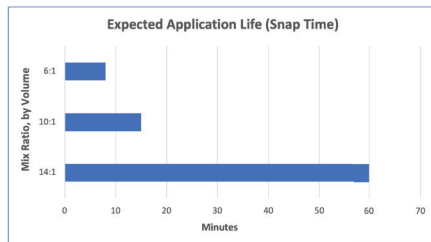
Structural glazing requires even greater attention to surface cleaning. Technical Bulletin #56 addresses the proper procedures in greater detail.

**Priming:** In most cases Pecora 985 does not require priming. However, unusual materials, special coatings and surface treatments may impair adhesion. Because of the unpredictability of such surfaces, a lab test is recommended to check adhesion with and without primer. If primer is necessary, P-120 should be used on metal.

**Note:** Pecora requires that adhesion and compatibility testing is conducted in its laboratory on substrates to be sealed on the project. Actual samples from the job are preferred although representative samples are acceptable, keeping in mind that representative samples often differ from material actually supplied on the job. For most recent updates, please visit our website at [www.pecora.com](http://www.pecora.com).

**Application:** Install backup fillers, setting blocks, spacer shims and tapes as specified. Apply 985 silicone in one continuous operation. Tool sealant at once after application. Tool concave with a firm continuous stroke to assure complete sealant contact with the substrate and present a neat appearance. Remove masking tape. In glazing applications be sure that the sealant is tooled at the sills so that precipitation and cleaning solutions will not pool. Pecora 985 silicone can be applied at temperatures as low as -15° F provided all surfaces are dry and frost free.

**Application (Pot) Life:** Depends on rate of cure and relative humidity conditions. Variable cure rate ("snap time") of 8 to 60 minutes may be obtained by adjusting the Base/Activator ratio as shown in the following graph. When supplied in bulk packaging, the 985 curing agent should be stirred before use because settling can occur during shipment.



### Dual Component Cartridge

**Application:** Pecora 985 two-component silicone is also supplied in a 490mL 10:1 dual component cartridge package configuration for use in both in-shop and field glazing. Be aware that when using the cartridge option the base/activator is supplied at a fixed mix ratio and cannot be adjusted. A 10:1 (by volume) dual component dispensing gun will be required for use. The required static mixing nozzles and adapters are provided with each case of cartridges. Refer to Pecora Technical Bulletin #214 for detailed application instructions and equipment recommendations.

**Cleaning:** Excess sealant should be removed from all surfaces while still uncured using solvents such as Toluene, Xylene or Methyl Ethyl Ketone (MEK). \* 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.

**Shelf Life:** Pecora 985 has a shelf life of two (2) years from date of manufacture when stored in unopened bulk containers and cartridges 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 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 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](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 used in strict 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, including but not limited to a warranty of merchantability or fitness for a particular purpose and in no case will Pecora be liable for damages other than those expressly stated in this warranty, including but not limited to 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 the 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 call our Technical Service Department at 800-523-6688.

### FILING SYSTEMS

#### CSI MasterFormat Designations:

- 07 92 00 Joint Sealants
- 08 44 26 Structural Glass Curtain Walls
- 08 85 00 Glazing Accessories