

BASIC USES

- Protective Glazing
- Impact-Resistant Glazing
- Pressure-Resistant Glazing
- Ballistics-Resistant Glazing
- Tamper-Resistant Security Glazing Applications
- Structural Sealant Glazing (SSG)

MANUFACTURER

Pecora Corporation

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

PRODUCT DESCRIPTION

Pecora 896HIS (High Impact Silicone) is a one-component, neutral curing, high impact silicone sealant designed for blast resistant, structural, and protective glazing, and tamper resistant security applications. It features very high tear and tensile strengths as well as excellent adhesion to a variety of substrates including vinyl, anodized aluminum and fluoropolymer coatings such as Kynar™ – generally without the need for priming.

Advantages: Pecora 896HIS features:

- Superior Adhesion: Bonds tenaciously to most substrates without the need for priming.
- Excellent Weatherability: Virtually unaffected by exposure to UV, temperature extremes, ozone, and precipitation due to its 100 percent silicone formulation.
- Resilient: Will remain flexible under extreme temperature swings (-60°F to 300°F).
- High Shore A durometer hardness per tamper resistant performance in security applications
- Superior tear and tensile strength

- Successfully tested for use in protective and impact glazing applications
- Fast cure in confined joint configurations

Limitations: Pecora 896HIS should not be used:

- Below grade or for sealing marine joints at or below the waterline.
- In designs that will be painted after applications of the sealant. Sealant should be applied after painting is completed.
- For cartridge applications requiring sealant beads less than 3/16" diameter Pecora recommends the 1215 Gun Grade or Semi Self-Leveling (SSL) Silicone Seam Sealer.

TECHNICAL DATA

Applicable Standards: Pecora 896HIS meets or exceeds the requirements of the following industry specifications:

TT-S-230C, Class A; TT-S-001543A Class A, ASTM C920, Class 25, Type S, Grade NS, Use G, A, O, C1184 Type S, Use G & O Impact and Cycle Testing of Fenestration Products.

PACKAGING

- 10.1 fl. oz. (300 ml) cartridges
- 50-gallon (189 liter) drums

COLOR

- Black, Aluminum Stone, Translucent

INSTALLATION

Surface Preparation: Clean all joint and glazing surfaces by removing foreign matter and contaminants such as oil, dust, grease, frost, water, surface dirt, old sealants or glazing compounds and any protective coating. Metal, glass and plastic surfaces should be cleaned by solvent procedure or by mechanical means. Soap or detergent and water cleaning treatments are not recommended. Cleaning of all surfaces should be done on the same day on which the sealant is applied.

TYPICAL UNCURED PROPERTIES

| Test Property | Value | Test Procedure |
|---------------------------------------|-------|----------------|
| Flow, Sag, Slump | nil | ASTM C-639 |
| Tool/Work Time (minutes) | 3-5 | Pecora Corp. |
| Tack free time (minutes) | 20 | ASTM C-679 |
| Cure time / Full adhesion | | |
| Confined joint configurations (weeks) | 2-3 | Pecora Corp. |
| Exposed joint configurations (days) | 7 | |

TYPICAL UNCURED PROPERTIES

| Test Property | Value | Test Procedure |
|---------------------------------|-------------------------------|----------------------------|
| Test Property | Value | Test Procedure |
| Hardness (Shore A) | 45 | ASTM C661 |
| Ultimate Extension (%) | 475 | ASTM D412 |
| Modulus @ 100% Elongation (psi) | 120 | ASTM D412 |
| Ultimate Tensile Strength (psi) | 375 | ASTM C1135 |
| Tear Strength (ppi) | 43 | ASTM D624 |
| Peel Strength (pli) | 45 | ASTM C794 |
| Ozone/UV Resistance | Excellent | ASTM C793 |
| Staining, Color Change | None | ASTM C510 |
| Service Temperature Range (°F) | -60 to +300 | Pecora Corporation VOC VOC |
| VOC Content (g/L) | 121 (Filled) 82 (Translucent) | ASTM D3960 |

Cleaning: Excess sealant should be removed from all surfaces while still uncured. Cured sealant is very difficult, if not impossible; to remove without altering or damaging the surface it is adhered to.

CAUTION: Solvents may be toxic and/or flammable. Refer to solvent manufacturer's instructions or Safety Data Sheets.

Priming: Pecora 896HIS does not require priming on most common substrates. However, Pecora recommends adhesion pre-testing, either in the field or in Pecora's laboratory, particularly on special coatings or surface treatments which may impair optimum adhesion. Where primer is indicated, P-120 should be used on special metal and plastic surfaces.

Pecora routinely conducts project specific adhesion, compatibility, and staining tests in its laboratory on representative substrate samples. Consult Technical Services for details.

Application: Install back-up material, setting blocks, spacer shims and tapes. Mask areas to be protected from overfill and tooling. Conduct test applications for adhesion verification when appropriate.

Storage: Six months from date of manufacture when stored in original airtight containers at temperatures below 90° F (32° C).

Precautions: Use in well-ventilated areas. Contact with uncured sealant may irritate eyes or skin. Flush eyes with water for fifteen minutes and seek medical attention if irritation persists. May be harmful if swallowed.

Consult Safety Data Sheet for additional 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.

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 re-caulk. No primer is necessary. If the bond has been affected, remove the sealant, clean and repair joint in accordance with instructions under "INSTALLATION".

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.

FILING SYSTEMS

- CSI MasterFormat Designations:
 - 07 92 00: Joint Sealants
 - 08 44 23: Structural Sealant Glazed Curtain Walls
 - 08 88 53: Security Glazing
 - 08 88 50: Ballistics-Resistant Glazing