

I. PRODUCT NAME: Pecora 865 Architectural Silicone Sealant

BASIC USES

Pecora 865 is designed primarily for sealing expansion and control joints in precast concrete panels, perimeter sealing of doors and windows and other building components. The sealant adheres well to concrete, masonry, steel, aluminum and many plastics, generally without need for a primer.

2. MANUFACTURER

Pecora Corporation
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800-523-6688
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3. PRODUCT DESCRIPTION

Pecora 865 is one-part, medium modulus, neutral-curing, high-performance silicone sealant that cures with atmospheric moisture to form a durable, flexible building seal. Because of its high extension/compression recovery properties and strong adhesion to most building materials, Pecora 865 performs exceptionally well under dynamic conditions accommodating long-term movement of $\pm 50\%$ in properly designed joints.

Limitations:

Pecora 865 should not be used in the following applications:

- Sealing horizontal decks, patios, driveway or terrace joints.
- Sealing submerged joints or below the waterline in marine applications.
- In totally confined or air-free spaces.
- In areas that will be painted after application of the sealant. (Sealant should be applied after painting is completed).
- Sealing natural stone, marble, granite, etc. without testing by Pecora laboratory in accordance with ASTM C-1248. (865 should never be used with kerf clips on natural stone; use either 890 silicone or Dynatrol I-XL polyurethane).

PACKAGING

- 10.3 fl. oz. (0.30 L) cartridges
- 20 oz. (0.59 L) sausages
- 2 gallon (7.57 L) pails

COLOR

- Black, Aluminum Stone, Classic Bronze, Limestone, Off White, Tru-White

4. TECHNICAL DATA

Applicable Standards: Pecora 865 Silicone meets or exceeds the requirements of the following industry specifications; TT-S-001543A, TT-S-00230C, Class A, CGSB-19GP-9, ASTM C-920, Class 25, Type S, Grade NS, Use NT, G, A, M, O.

5. INSTALLATION

Joint Design: Pecora 865 Architectural Silicone Sealant should be no thicker than 3/8" (9mm) and no thinner than 1/8" (3mm) for joints where excessive movement is expected. Ideally, the ratio of joint width to the sealant depth should be about 2:1 when appropriate. Lap shear joints should have a bead width which is equal to or greater than the total anticipated movement. Small curtainwall

panels and lites should allow a minimum width of 1/4" (6mm) for the sealant bead. Larger panels for which a great deal of movement is expected should allow a minimum width of 1/2" (12mm) for the sealant bead. Glazing of plastic lites and panels fabricated from plastic require larger than usual, joint dimensions due to the plastics high coefficient of thermal expansion.

The width of building expansion joints varies because of seasonal and daily changes in temperature. If Pecora 865 silicone cannot be installed when the design width is approximately halfway between the dimensional extremes, the designed joint must be at least twice the total anticipated joint movement. Good architectural practice calls for joint design of four times the anticipated movement due to construction tolerances and material variations.

Surface Preparation: Clean all joints and glazing areas by removal of foreign matter and contaminants such as oil, dust, grease, frost, water, surface dirt, old sealants or glazing compounds and any protective coating.

TABLE 1: TYPICAL UNCURED PROPERTIES
at 77°F (25°C), 50% R.H.

Test Property	Value	Test Procedure
Flow, Sag, Slump	Nil	ASTM C639
Full Adhesion (days)	7-14	
Tack Free Time (hours)	3	ASTM C679
Through Cure (days)	7-14	
Tool/Work Time (minutes)	14-15	Pecora Corporation

TABLE 2: TYPICAL CURED PROPERTIES
After 7 days cure at 77°F (25°C), 50% R.H.

Test Property	Value	Test Procedure
Dynamic Movement Capability (%)	± 50	TT-S-1543A
Elongation at break (%)	500	ASTM D412
Hardness, Shore A	45	ASTM C661
Ozone/UV Resistance	Excellent	Weatherometer
Peel Strength on alum, glass & concrete (pli)	30	ASTM C794
Staining, Color Change	None	ASTM C510
Tear Strength (pli)	40	ASTM D624
Temperature Range (°F (°C))	-60 to 300 (-51 to 149)	
Tensile Strength @ 100% elongation (psi)	70	ASTM D412
VOC Content (g/L)	12	ASTM D3960

Porous substrates and precast concrete panels using form release agents other than polyethylene film should be cleaned by grinding, saw cutting, blast cleaning (water or sand), mechanical abrading or a combination of these methods which will provide a sound, clean and dry surface for sealant application. Dust, loose particles, etc. should be blown out of joints with oil-free compressed air or vacuum cleaned. 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.

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

Priming: Pecora 865 does not require priming on most common substrates. However, we strongly suggest adhesion pretesting, either in the field or in our laboratory, on all porous substrates, particularly brick.

When primer is needed, P-46 should be used on porous substrates and P-120 on special metal and plastic surfaces.

Also, Pecora offers complimentary adhesion and stain testing in its laboratory on actual field samples of substrate from the jobsite or on representative samples from the same lots. Contact Technical Services for details.

Joint Backing: Backer rod controls the depth of the sealant and allows it to be applied under pressure. Use a size that will compress 25%.

Denver Foam open-cell polyurethane or reticulated (soft) polyethylene rod is recommended. Closed-cell polyethylene may be used but care must be taken not to puncture the rod which can cause outgassing or bubbling/blistering in the sealant.

In joints too shallow for backer rod, use a polyethylene bond-breaker tape to prevent three-sided adhesion.

Application: All joints should be masked to ensure a neat appearance and prevent sealant applied outside the joint confining from imparting a discoloration to the substrate.

Sealant should be applied in a continuous operation using sufficient pressure to fill the joint and make complete contact to the joint sides. Tool the sealant slightly concave using dry-tooling techniques. Consult Technical Services prior to tooling with solvent. Do not tool with soap or detergent and water solutions.

Tool Time (initial skin): 14-15 minutes at 77°F (25°C), 50% relative humidity. Higher temperatures and/or humidity will shorten this time.

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 to which it has been misapplied.

Shelf Life: Pecora 865 Silicone has a shelf life of 12 months from date of manufacture when stored in unopened cartridges at temperatures lower than 80°F (27°C), or 9 months in tightly sealed bulk packages and performs equally well during any part of this shelf life.

Precautions: Use sealant in well ventilated areas. Contact with uncured sealant may irritate eyes and skin. Flush eyes with water for 15 minutes and seek medical attention if irritation persists. May be harmful if swallowed. For additional health and safety information, consult manufacturer's MSDS.

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

6. 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.

7. 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. 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.

8. 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"

9. 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 or 215-723-6051.

10. FILING SYSTEMS

- Electronic Spec-Data®
- Spec-Data®II
- Sweet's Catalog File: www.sweets.com
- General Building
 - 07100 Waterproofing
 - 07920 Sealants
 - 08850 Glazing
- Civil Engineering
 - 07100 Waterproofing

11. FAST FAX Document Codes

1-888-4PECORA (473-2672)

- Data Sheet 548
- M. S. D. S. 549



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