

# Pecora 896

High Performance Silicone Window & Door Sealant

## Specification Data Sheet



### 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.

### 2. MANUFACTURER

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

### 3. PRODUCT DESCRIPTION

Pecora 896 is a one-part neutralcuring, 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" (6 mm) bead) in less than 24 hours and develops quicksure adhesion.

#### Product Features:

- Tenacious primerless adhesion to vinyl, PVC, Kynar 500/Hylar 5000 based paint and coatings, anodized aluminum, wood and most other common substrates associated with the fenestration industry.
- High strength and extreme movement capabilities facilitating its use in most demanding metal, vinyl and wood window applications.
- Fast cure-through 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:

- In totally confined or air free spaces.
- With building materials that bleed oils, plasticizers or solvents.
- On surfaces that will require painting.
- Where abrasion or abuse is expected.

#### PACKAGING

- 10.3 fl. oz. (.305 ml) plastic cartridges
- 5-gallon (18.9 L) pails
- 50-gallon (189 L) drums

#### COLOR

- Available in standard architectural colors of Black, Tru-White, Translucent, Dark Bronze, Crystal Blue, Almond and Earthtone; 32 Color-Flex Special colors, and an almost unlimited range of custom colors (certain restrictions apply). The latter two items are available in quantities as low as 30 gallons.

### 4. TECHNICAL DATA

Federal Specification TT-S-001543 A, TT-S-00230C Class A and ASTM C-920, Class 25, Type S, Grade NS, Use NT, G, A, M, O, ASTM C-1184-91. AAMA 802.3 Type I & II, AAMA 805.2, AAMA 803.3-92 Type I, AAMA 803.3-92 Type II (896-SSL). CAN 2-19.13-M82 (19-GP-9MA).

### 5. INSTALLATION

**Joint Design:** A thin bead of silicone will accommodate more movement than a thick bead. The width or depth of the sealant should not be less than 1/8" (3 mm). In joints up to 3/8" (9 mm) wide, depth of the sealant should be equal to the width. In joints over 3/8" (9 mm), but not exceeding one inch (25 mm), the depth should be maintained at 3/8" (9 mm).

**Application:** Install backup material or joint filler. Apply sealant in a continuous operation. In cap bead glazing, tool the sealant applied at the sill so that precipitation and cleaning solutions will not pool.

### TYPICAL PHYSICAL PROPERTIES

Test Property	Value	Test Procedure
Cure Time 1/4" bead (hours)	<24	ASTM C679-87
Dynamic Joint Movement (%)	±50	ASTM C719-93
Elongation (%)	550	ASTM D412-87
Hardness Shore A	27	ASTM C661-93
Modulus, 100 % Elongation (psi)	55	ASTM D412-87
Staining (including vinyl)	None	TT-S-001543A (Com-NBS)
Tack-Free Time (minutes)	8-15	ASTM C679-87
Temperature Range (°F)	-60° F - +300° F	
Tensile Strength (psi)	225	ASTM D412-87
Ultraviolet & Ozone Resistance	Excellent	

**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 six (6) 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 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. Refer to Material Safety Data Sheet.

**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 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.

**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 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](http://www.sweets.com)
- General Building
  - 07100 Waterproofing
  - 07920 Sealants
  - 08850 Glazing
- Civil Engineering
  - 07100 Waterproofing

**II. FAST FAX Document Codes**

**1-888-4PECORA (473-2672)**

- Data Sheet 606
- M. S. D. S. 607



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