

### BASIC USES

Pecora 322FC is utilized to seal joints in roadways, parking structures, bridges and airfields where the sealant is subjected to vehicular and pedestrian traffic. Typical substrates include, but not limited to, concrete, asphalt, metal, and precast pavers.

### 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 322FC is a two-part, cold-applied, self-leveling, fast-curing, ultra-low modulus, 100% silicone material designed for sealing of pavement joints experiencing thermal movement. Pecora 322FC cures to a resilient silicone rubber seal in a very short time when compared to a typical one part moisture curing sealant. This is especially beneficial when sealing joints that will experience movement shortly after sealant application. These applications include bridges, parking structures, parking lots, sidewalks, pedestrian decks and plazas.

#### Advantages:

- Excellent weatherability- This sealant's 100% silicone composition is virtually unaffected by UV, precipitation, ozone, and temperature extremes.
- Sealant will remain flexible under extreme temperature swings (-49° to 300°F).
- Fast Curing- Fast cure profile allows quick job site turn-

- around. Early movement will not affect sealant performance.
- Self-leveling- No tooling required when applied through typical static mixing equipment.
- One-to-one volume mix ratio- Packed in convenient sausage packs, that are easy loading and yield minimal waste.
- Auto-bonding- Will bond to itself tenaciously without the need for priming.

#### Limitations:

- Pecora 322FC should not be used under the following conditions.
- In applications involving natural stones. There is the potential for staining these surfaces.
  - In totally confined spaces.
  - To surfaces that will be painted.
  - In applications involving total water immersion.
  - Sealant cannot be mixed in an open bucket using standard mixing paddles. Proper static mixing equipment must be used.
  - In joints with a slope greater than 6%.
  - This product is intended for industrial use only.
  - For bridge nose repairing. In combination with polymeric nosing details.

### TECHNICAL DATA

**Applicable Standards:** Complies with TT-S0023C, TT-S-001543, ASTM C920, Class 100, Type M, Grade SL, Use T2, M, O, ASTM D5893 Type SL.

### PACKAGING

- 2 - 20 fl. oz.(592 ml) sausage kit. Including Part A and one labeled Part B are required for a total of 40 fl.oz. (1.18 L) per loading.

### COLOR

- Gray

### INSTALLATION

**Surface Preparation:** Joint surfaces and backer rod must be dry and free of all contaminants such as oil, grease, dust, corrosion, tar, asphalt, loose aggregate, frost, form release agents, and decorative and protective coatings. Methods of removal may include sandblasting, wire brushing. Refer to Pecora Technical Bulletin 109 for general surface preparation guidelines. Priming may be required. P-225 is recommended on concrete and P-200 on asphalt. Proper adhesion should be confirmed prior to full scale production.

**Application:** Pecora 322FC is applied as a self-leveling material. It is a low modulus material, which will withstand extreme movement when applied properly. 322FC will withstand movement up to 100% in extension and 50% in compression. The Base and Activator are formulated to function as a unit. The two components should

**TABLE 1: TYPICAL PHYSICAL PROPERTIES (NOT INTENDED FOR USE IN PREPARING SPECIFICATIONS)**

As Supplied	Type	Ultra-low modulus	
	Cure	Two-part, Chemical cure	
	Color Part A, Part B	White, Dark gray	
	Consistency	Self-leveling	
	Work life	20 minutes	
	Service time	24 hrs.	
	Full Cure, 77°F/50%RH	48 hrs	
As Supplied	ASTM D 412	E <sub>b</sub> , %	1400
	ASTM D 412	T <sub>b</sub> , psi	50
	ASTM C 1135	25M, psi	5
		50M, psi	12
		150M, psi	15
	ASTM C 1135	E <sub>b</sub> , %	>600
	ASTM C 719	% Movement	+100/-50
	ASTM D 2240	Shore 00	55

be used simultaneously in the Albion Engineering 20x20oz. AT Line Powered Multi-Component Sausage Gun, Model AT1200S.

**Static Tip Purging:** Purge static mixing tip with Part A only when not in use.

**Joint Design:** Maximum joint depth at the crown of the backer rod is 0.5 inches. Minimum Joint depth at the crown of the backer rod is 0.25 inches. A closed cell backer rod is recommended. An open cell backer rod with continuous outer impervious skin is acceptable when irregular joint widths are encountered. The open cell backer rod is more compressible and able to accommodate irregular joint widths. All sealant applications should be recessed from the joint surface a minimum of 0.25 inches. For joints in excess of 2.0 inches in width the recess requirement should be increased to as much as 0.5 inches.

**Tool Time:** (Initial Skin): 20 minutes at 77°F (25°C), 50% relative humidity. Higher temperatures and/or humidity will shorten this time.

**Cleaning:** Immediately remove all excess sealant and smears adjacent to joints with mineral spirits. Also use mineral spirits for removing uncured sealant from equipment. Remove cured sealant by scraping, sandpapering, etc. (Caution: mineral spirits is flammable and toxic. Observe manufacturer's precautions.)

**Shelf Life:** Pecora 322FC has a shelf life of 12 months from date of manufacture when stored

in an unopened sausages 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 the 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 Pecora 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 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.

### 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 effected, 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

<http://www.4specs.com>  
03 99 20 Concrete Patching and Resurfacing  
07 18 00 Traffic Coatings  
07 92 00 Joint Sealants  
08 85 00 Glazing Accessories

ESTIMATED SEALANT USAGE JOINT WIDTH, INCHES	JOINT DEPTH, INCHES	40 OZ. KIT YIELD LINEAR FEET
0.5	0.25	42
1.0	0.5	10
1.5	0.5	7
2.0	0.5	5.5
2.5	0.5	4.3
3.0	0.5	3.5