

FLEXFILL 60 JOINT FILLER

SEMI-RIGID EPOXY JOINT FILLER FOR CONTROL JOINTS OR CONTRACTION JOINTS

PRODUCT DESCRIPTION

Flexfill 60 has been specifically designed for filling sawcut control joints and contraction joints in concrete. Flexfill 60 is a two component, low viscosity liquid which cures to a semi-rigid, hard-rubber-like resiliency which supports joint edges to prevent edge deterioration and concrete spalling. Flexfill 60 joint filler bonds tightly to the sides of concrete joints, prevents contaminant and water penetration, and delivers high wear resistance and durability.

FLEXFILL 60 JOINT FILLER FEATURES

- ALL EPOXY TECHNOLOGY
- VOC and BGE FREE
- IDEAL 1:1 MIX RATIO
- USDA APPROVED
- EXCELLENT DURABILITY
- HIGH RESILIENCY
- BONDS TO MOST CONSTRUCTION MATERIALS
- EASILY COATED WITH COMPATIBLE TOPPING
- VERY "FLOWABLE" CONSISTENCY – NEGLIGIBLE SHRINKAGE

PRODUCT DESCRIPTION AND CHARACTERISTICS

TWO PART EPOXY, THERMOSETTING RESIN

- MIX RATIO BY VOLUME: 1:1
- COLOR: light grey
- WORKLIFE, AFTER MIXING RESIN & HARDENER: 1 hour @ 72°F
- APPLICATION THICKNESS: 1/8" or greater
- CURING TIME: 24 hours
- TENSILE STRENGTH (ASTM D-412): 430 psi
- % TENSILE ELONGATION: 86
- TENSILE STRENGTH (ASTM D-638): 440 psi
- % TENSILE ELONGATION: 88
- HARDNESS (SHORE A) : 60 – 70
- MIXED VISCOSITY @ 72°F: 3000 cP

PACKAGING

K-057-5 (0.5 gallon) = 108 in.³ = 24 linear ft. in 1/4" x 1-1/2" joint
 K-057-21 (2 gallons) = 457 in.³ = 101 linear ft. in 1/4" x 1-1/2" joint

STOP...WHAT TYPE OF JOINT ARE YOU FILLING?

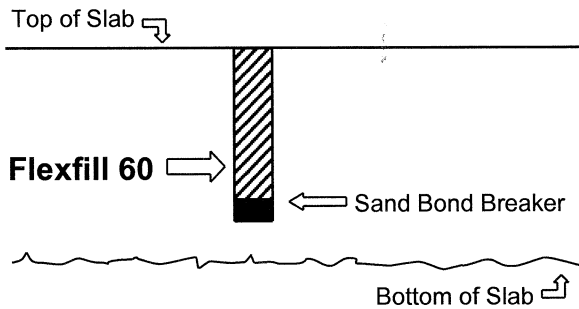
TYPE 1

USE FLEXFILL 60 HERE

Names*: Control joint
 Contraction joint
 Non-working joint

Characteristics: No movement or negligible movement
 Sawcut

Typical Application:
Sawcut Control Joint



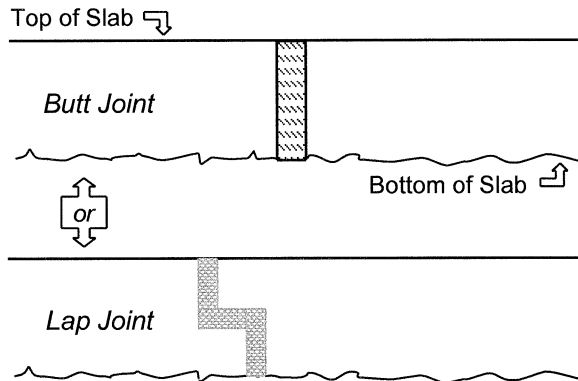
TYPE 2

DO NOT USE FLEXFILL 60 HERE

Names*: Expansion joint
 Isolation joint
 Working joint

Characteristics: Significant movement
 Formed

Typical Application:
Butt Joint or Lap Joint



* Name distinctions are based on American Concrete Institute, ACI 504R-90



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APPLICATION INSTRUCTIONS

WHEN TO INSTALL K-057: Flexfill 60 should not be installed on "green" concrete. A minimum 30-day concrete cure is required. 90-120 days is ideal. The ideal time to install is when the area is at its long term, stable temperature.

JOINT OR CRACK APPLICATION: Any loose concrete, previous joint compound or other materials must be removed to leave a clean, sound joint. All dirt, oil, sealers or chemical residue must be removed. To achieve optimum performance the joint should be sawcut, and/or chipped to leave a clean, dry surface for bonding. Prepared joint depth should be at least (minimum) two (2) times the width. Wire brush joint sides to remove laitance. Bond breaker must be used. Use of a 1/4" layer of 30-60 mesh dry silica sand in bottom of joint is recommended. The bond breaker is designed to prevent three-sided adhesion of the epoxy. Adhesion to the joint walls is the only adhesion desired. **DO NOT USE A BACKER ROD.** A backer rod does not produce a stable, long term load transfer.

APPLICATION: Do not rapidly change the temperature of the air/concrete before installing Flexfill 60. Keep the temperature constant, same as long term temperature. Floor temperature must be between 60 - 90 °F (15.5 - 32.2 °C) during application for complete cure. Temperatures below 50 °F (10 °C) will inhibit the cure resulting in a sticky surface. The liquid material should be stored at 60-90 °F prior to installation.

MIXING: Mix the Resin (Part A) and the Hardener (Part B) for 2-3 minutes with a slow speed (500 rpm or less) drill and Jiffy Mixer (mixing paddle). Pour the material into the joint. If a flush joint is desired slightly overfill the joint and let cure overnight, then use a floor scraper or knife-edge to cut the material flush with the concrete. If the joint material is to be topcoated, no cutting is necessary. If you need less than a full kit, do not "eyeball" the mixture. Accurately weigh or measure the resin and hardener following the mixing ratios under "PRODUCT DESCRIPTION AND CHARACTERISTICS." Flexfill 60 has a work life of one hour at 72 °F (22 °C), and can be applied as thickly as needed in one coat. If it is necessary to bond Flexfill 60 to itself, abrade the old material before pouring new material.

CLEAN-UP: Flexfill 60, before it has fully cured, may be removed from tools with Copps Enviro-Kleen solvent or isopropyl alcohol.

SAFETY: Flexfill 60 is an epoxy resin system. Please refer to Material Safety Data Sheets before using this product. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR EPOXY MATERIAL.**

EXPLANATION OF PRODUCT CHARACTERISTICS AND PHYSICAL PROPERTIES

Important product characteristics are listed on page 2 of this technical bulletin. Several key characteristics include tensile strength, percentage tensile elongation and Shore A hardness.

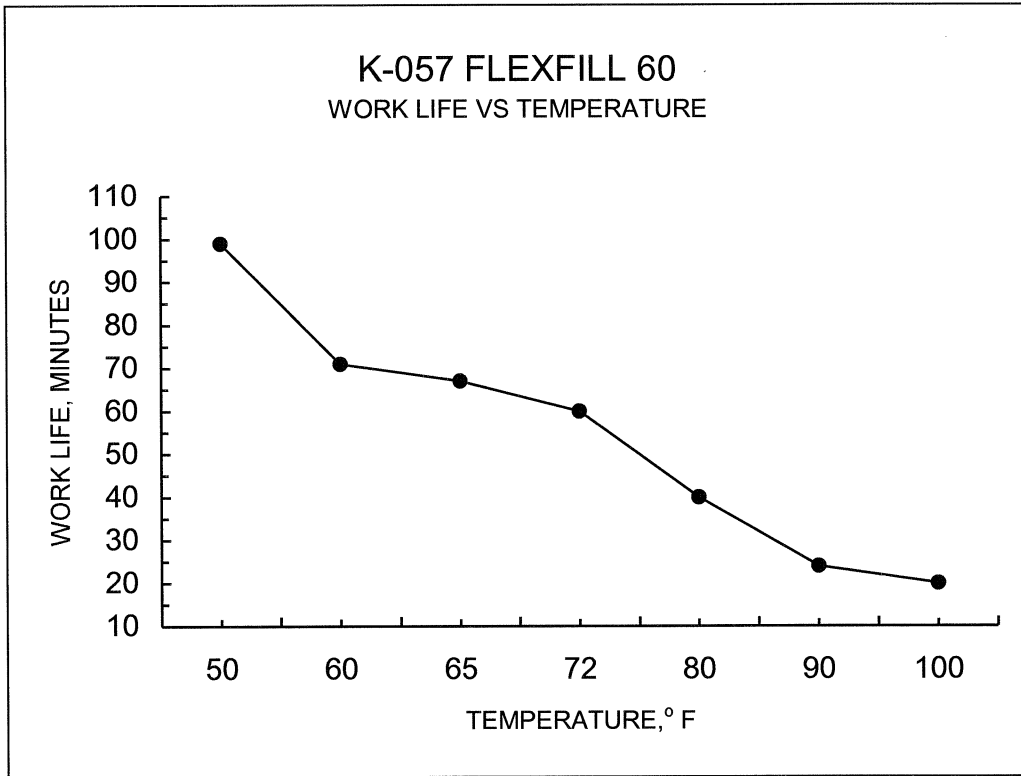
- These characteristics relate to Flexfill 60 after it has completely cured.
- In simple terms:

Tensile strength relates to the capacity of this material to hold together when stretched.

Percentage tensile elongation is the length the material can be stretched before failure.

Shore A hardness relates to a standard for "hardness – softness" so that different materials may be measured against the same reference point

Flexfill 60 has been designed to function as a joint filler. It must stretch or give to allow for expansion or contraction within the concrete slab. At the same time it must deliver adequate support to joint shoulders receiving the force of hard wheel traffic carrying heavy loads. It must bond to joint sides to provide a seal to prevent contaminant entry and its surface texture must deliver sufficient wear capacity. Extensive tests and use of Flexfill 60 demonstrate these capacities.



JOINT FILLER ESTIMATING CHART

LINEAL FEET PER GALLON

JOINT WIDTH	1/4"	1/2"	3/4"	1"	1-1/4"	1-1/2"
JOINT DEPTH						
1/2"	154.0					
3/4"	102.7					
1"	77.0	38.5				
1-1/4"	61.6	30.8				
1-1/2"	51.3	25.7	17.1			
1-3/4"	44.0	22.0	14.7			
2"	38.5	19.3	12.8	9.6		
2-1/2"	30.8	15.4	10.3	7.7	6.2	
3"	25.7	12.8	8.6	6.4	5.1	4.3

Move across "Joint Width" row to the width of your joint, then down its column to match the corresponding depth of your joint in the "Joint Depth" column. The number of lineal feet filled with one gallon of material is specified at the intersection.

WARRANTY AND DISCLAIMER

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