

Flexfill 60 Joint Filler – K-057

Description:

Flexfill 60 is a semi-rigid epoxy joint filler that 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.

Product

Advantages:

- ALL EPOXY TECHNOLOGY
- EXCELLENT DURABILITY
- VOC and BGE¹FREE
- HIGH RESILIENCY
- IDEAL 1:1 MIX RATIO
- VERY “FLOWABLE” CONSISTENCY – NEGLIGIBLE SHRINKAGE
- EASILY COATED WITH COMPATIBLE TOPPING
- BONDS TO MOST CONSTRUCTION MATERIALS

Handling

Properties:

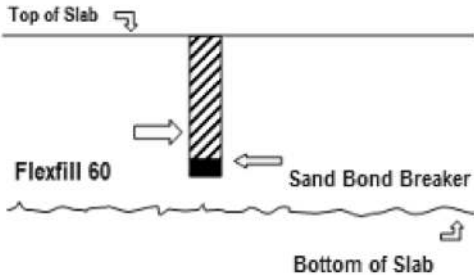
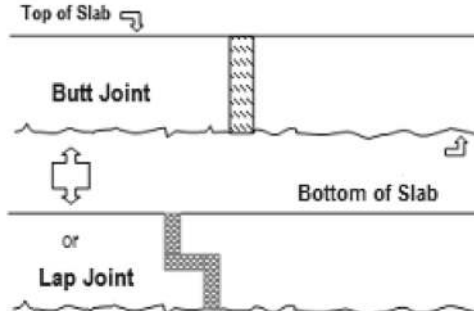
MIX RATIO BY VOLUME:	1:1
COLOR:	light grey
WORKLIFE, AFTER MIXING RESIN & HARDENER:	1 hour @ 72°F
APPLICATION THICKNESS:	1/8" or greater
CURING TIME:	16 hours
MIXED VISCOSITY @ 72°F:	5000 cP

Physical

Properties:

TENSILE STRENGTH:	360 psi	ASTM D 638
% TENSILE ELONGATION:	46	ASTM D 638
HARDNESS (SHORE A):	70 – 80	ASTM D 2240

WHAT TYPE OF JOINT ARE YOU FILLING?

TYPE 1		TYPE 2	
USE FLEXFILL 60 HERE		DO NOT USE FLEXFILL 60 HERE	
Names*:	Control joint Contraction joint Non-working joint	Names*:	Expansion joint Isolation joint Working joint Significant movement Formed
Characteristics:	No movement or negligible movement Sawcut	Characteristics:	Significant movement Formed
Typical Application:	Sawcut Control Joint	Typical Application:	Butt Joint or Lap Joint
			

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

1 - Butyl Glycidyl Ether. The EPA (SARA Title III, section 312) lists BGE as “Toxic” (per ANSI Z129.1) by skin absorption and an immediate health hazard.

**Joint
Preparation:**

Any loose concrete, previous joint compound or other materials must be removed to leave a clean, sound joint. In addition, all dirt, oil, sealers or chemical residue must also be removed for the full intended filler depth. To achieve optimum performance the joint must be saw cut with a diamond blade (if possible vacuum-equipped) in order to achieve a clean/dry surface for bonding. The blade should be run against each sidewall and extended the entire intended filler depth. After sawing, joint should be vacuumed to remove all dust/debris ("raking" debris out of joint is an unacceptable joint cleaning procedure). To prevent filler run-through you may "choke-off" the bottom of the joint by applying a ¼" deep (maximum) layer of dry, silica sand (30-60 mesh). Do not use a backer rod in saw cut contraction/control joints less than 2" deep. For those joints greater than 2" and construction joints (through-slab) you may use silica sand or a backer rod only if it is held down at least 2" from the top of joint.

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 top coated, 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 "Handling Properties". 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.

Flexfill 60, before it has fully cured, may be removed from tools with Copp's Enviro Kleen solvent or isopropyl alcohol.

Application:

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.

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.

Additional Info:

Important product 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.

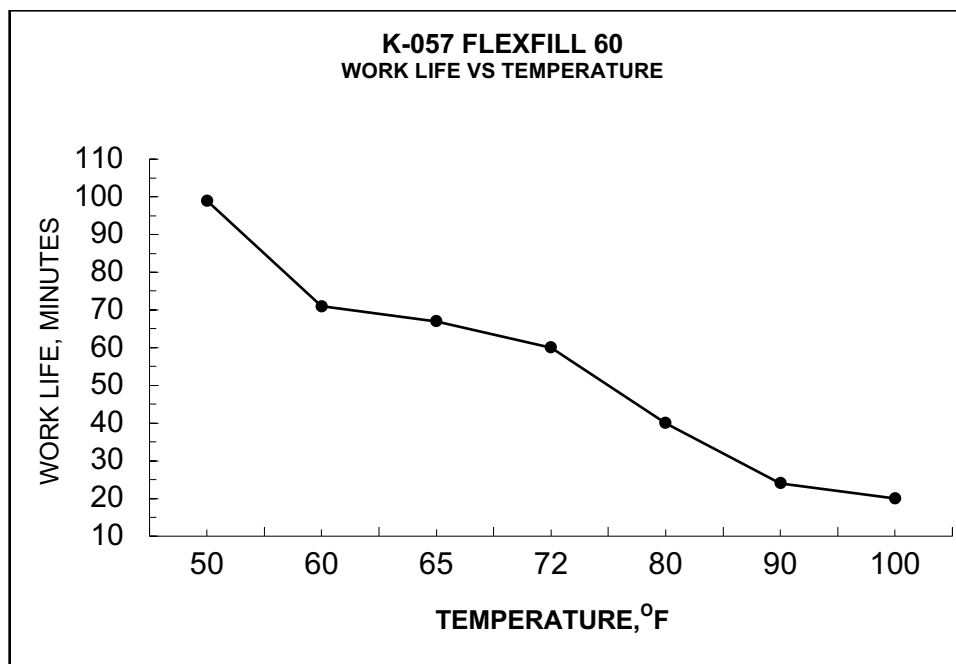
Shore A hardness relates to a standard for "hardness – softness" so that different materials may be measured against the same reference point.

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.

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

WORK LIFE VS TEMPERATURE



**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.

SAFETY PRECAUTIONS

Flexfill 60 is an epoxy resin system. Please refer to safety data sheets before using this product. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR EPOXY MATERIAL.**

FOR INDUSTRIAL USE ONLY

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