

# FLEXI-FILL 530

## 100% SOLIDS EPOXY PASTE FILLER & SEALANT

### DESCRIPTION:

**FLEXI-FILL 530** is a unique two component, slightly flexibilized 100% solids epoxy-acrylate-isocyanate terpolymer adhesive for surface-sealing cracks and filling small depressions in a wide variety of substrates. Suitable substrates include terra cotta, concrete, masonry, steel, aluminum and stone.

**FLEXI-FILL 530** is a paste adhesive, which should be used neat or mixed with coarse filler and tooled onto bonding surfaces. Although it is packaged in premeasured “A” (Resin) and “B” (Hardener) components, the mix ratio is far less critical than for traditional 2-part epoxy formulations. This allows the user to adjust working consistency at different temperatures. This variable ratio feature makes **FLEXI-FILL 530** a true “all season” epoxy adhesive and sealant.

### PROPERTIES:

Mix Ratios, By Volume	4:1 to 8:1*
Gel Time, 100g @ 25 <sup>o</sup> C	5-7 Minutes
Through-Set Time	2-6 Hours
Tensile Strength	10,200 psi
Tensile Bond Strength	>300 psi (Concrete)
Elongation	4%
Flexural Strength	Approx. 15,000 psi

### SURFACE PREPARATION:

Apply to clean, dry surfaces free of dust, dirt, grease, oil, coatings or other extraneous material which may hinder adhesion. Concrete and masonry surfaces may be smooth or rough, but must be sound, clean

and free of laitance, efflorescence, curing compounds or contaminants. Cracks should be cleaned out and surface opening should be widened as required to achieve efficient filling of cavity.



*Repairs to granite surface cracks at the South Carolina State House were repaired using a custom-matched **FLEXI-FILL 530** with added granite aggregates.*

### \*VARIABLE MIX RATIO

Units are pre-measured as approximately 4:1 resin to hardener by volume. To increase pot life and reduce sag in warm weather, reduce the amount of hardener by up to 50%. To accelerate set and reduce viscosity in cold weather, use up to 100% more hardener.

### APPLICATION:

Pour all or part (minimum 50%) of the contents of the bottle of Hardener (Part B) into the Resin (Part A).

Thoroughly mix the two **530** components by slow speed drill or thorough hand tool mixing. Mix in small quantities, as will be applied in 3-5 minutes. Work material completely along container sides and from top to bottom to assure complete blending of all materials.

Apply by trowel, or using disposable caulk cartridges. Tool as required to completely fill all depressions and voids. Protect adjacent surfaces with heavy duct tape. Do not build up heavy excess material along tape edges. Pull tape after initial set. Immediately remove any runs or excess adhesive

using Xylene. Clamp or brace pieces in place, when required, and maintain support until adhesive has set completely. **Do not suspend stone pieces by uncured adhesive alone, as slippage may occur prior to set.** Mechanically reinforce heavy pieces with threaded rod, in accordance with good restoration practices.

After initial set, product goes through a stage of cure characterized by relatively soft, “rubbery” consistencies. At this stage, the product may be readily cut away with a sharp blade. This provides an opportunity for clean and inconspicuous crack repairs, as it is possible to overbuild the product initially and then “slice” it back flush with adjacent surfaces after initial cure. Product may also be sanded within 24 hours of placement.

**BEFORE**



**AFTER**



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dirt, excess hardener or exudation prior to topcoating.

#### **TEMPERATURE:**

Temperature of product and substrates affect cure rate. Low temperatures increase viscosity and slow cure. Very cold surfaces may require heating or priming with solvent-thinned epoxy paste. High temperatures reduce viscosity and accelerate cure. Refer to variable mix ratio instructions.

**Minimum application temperature** is -5 degrees F, and curing continues down to -20 degrees F.

**Maximum application temperature** is 90 degrees F, and product may be force-cured up to 180 degrees F.

#### **SAFETY & HANDLING:**

**WARNING: Hardener is a Corrosive Liquid (Skin). Avoid skin and eye contact.** Use protective gloves, goggles, and clothing as required to prevent contact. Use with adequate ventilation. Do not use in areas where food products are stored, unless first removing all materials which may absorb product vapor. Read and observe all safety and handling guidelines as detailed in the Material Safety Data Sheets supplied with this product.

Store above 50 and below 90 degrees Fahrenheit for best results.

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