



**Corrosion  
Engineering™**

AN ERGONARMOR COMPANY

**TECHNICAL INFORMATION**

*CES-130*

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## ***CORROSION ENGINEERING SPECIFICATION FOR INSTALLATION***

### ***FLEXJOINT® JOINT FILLERS***

#### ***1. SCOPE***

- 1.1 This specification governs the installation of FLEXJOINT and FLEXJOINT Polysulfide Joint Fillers.
- 1.2 Other applicable documents include product data sheets CE-133, CE-241, and drawings CED-1015, CED-1018, and CED-1020.

#### ***2. JOINT DESIGN***

- 2.1 See drawings numbered CED-1015, CED-1018, and CED-1020, for design and depth of joints in brickwork, toppings and concrete. Follow procedures given in CES-307 for expansion joints in brickwork, and CES-310 for epoxy floor surfacings .

#### ***3. SURFACE PREPARATION***

##### ***3.1 New Surfaces***

- 3.1.1 Where new joint surfaces of concrete are clean, remove laitance and loose particles by brushing or with air blast. For formed concrete, clean the surfaces by power wire brushing or slightly sand blasting the edges of the panel, Be sure that top edges of joints are square, sharp and clean, and sides are at 90° from surface.

##### ***3.2 Old Surfaces***

- 3.2.1 Rout old joint to a width approximately twice the depth of the joint. Cut joints so tips are square, 90° corners. Clean sides of joint by scraping or sandblasting. Remove loose particles by brushing or air blast. Be sure that all surfaces to be bonded are completely clean and

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sound.

- 3.3 Cover bottom of joint with electrical grade (plastic) tape or other bond release agent.
- 3.4 Prime all surfaces by brushing PENNTROWEL Epoxy Primer prior to use of FLEXJOINT Joint Filler, and FLEXJOINT Polysulfide Primer for FLEXJOINT Polysulfide Joint Filler. Fill primed joint within 4 hours and while primer is still "tacky". If for any reason elapsed time of 4 hours is exceeded, or Primer is no longer "tacky", re-prime.
- 3.5 Avoid excess use of primer. Wipe away any excess .

**4. INSTALLATION**

- 4.1 To insure a neat appearance use duct tape along side of joint to protect concrete from overflow. Take care not to allow tape to come into contact with surfaces to which the sealant must adhere. Remove tape within two hours after application.
- 4.2 Pour contents of FLEXJOINT Hardener can into FLEXJOINT Resin can and mix thoroughly.
- 4.3 Caulking Grade is applied by knife or caulking gun in one application.
- 4.4 Pouring Grade is poured into open joint from mixing container. For best results, use a pouring can with a spout shaped to fit the joint. This will serve to fill the joint from the bottom up and will produce a joint with fewer entrapped air bubbles. Fill in two closely succeeding applications, filling the joint almost full in the first pour, permitting filler to settle, then fill completely in the second pour. Do not apply FLEXJOINT Joint Filler when the substrate temperature is under 50<sup>0</sup> F (10<sup>0</sup> C) or when substrate is wet. Contact Corrosion Engineering for instructions.
- 4.5 Horizontal joints should be poured as soon as the material has been properly mixed. Vertical and sloping joints should be poured 15 minutes after mixing.

**5. CLEAN UP**

- 5.1 Clean tools before the sealant has set by using mineral spirits or kerosene. Clean hands with waterless hand cleaner.

**6. SAFETY PRECAUTIONS AND DISCLAIMER**

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- 6.1 FLEXJOINT Joint Filler components, and mixes of them present a number of hazards. Read before using and follow the hazard information, precautions, and first aid directions on the individual product labels and Material Safety Data Sheets.
- 6.2 The statements, technical information and recommendations contained herein are believed to be accurate as of the date hereof. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, Corrosion Engineering expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information; NO WARRANTY OF FITNESS FOR ANY PARTICULAR PURPOSE, WARRANTY OF MERCHANTABILITY OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED, IS MADE CONCERNING THE GOODS DESCRIBED OR THE INFORMATION PROVIDED HEREIN. The information provided herein relates only to the specific product designated and may not be applicable when such product is used in combination with other materials or in any process. The user should thoroughly test any application before installation. Nothing contained herein should be taken as an inducement to infringe any patent and the user is advised to take appropriate steps to be assured that any proposed use of the product will not result in patent infringement.
- 6.3 Please contact Corrosion Engineering for specific recommendations at +1-610-833-4000 or fax +1-610-833-3040.

***[www.flexjoint.com](http://www.flexjoint.com)***