Thioflex 600

Section A : General Comments

High temperature working

It is suggested that, for temperatures above 35^{0}C, the following guidelines are adopted as good working practice:

(i) Store unmixed materials in a cool (preferably temperature controlled) environment, avoiding exposure to direct sunlight.

(ii) Keep equipment cool, arranging shade protection if necessary. It is especially important to keep cool those surfaces of the equipment which will come into direct contact with the material itself.

(iii) Try to avoid application during the hottest times of the day, arrange temporary shading as necessary.

(iv) Make sufficient material, plant and labour available to ensure that application is a continuous process.

Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement

Protective clothing	:	Protective overalls
	:	Good quality gloves, goggles and face mask
Preparation equipment	:	Proprietary blasting equipment Fosroc Joint Cleaner
Mixing equipment	:	1 KW slow speed drill, 400 or 500 rpm, plus Fosroc Mixing Paddle MR2
Application equipment	:	Brush
		Fosroc Barrel Gun
		Joint shaping tool

Application - points of note

Fosroc operates a policy to encourage the use, where possible, of approved or licensed applicators. This ensures that repairs are completed satisfactorily so that the long term performance of the materials is assured. For contractors who wish to apply the materials themselves Fosroc is also able to offer technical assistance and training, either on-site or at its Training Centre in Dubai.

Section B : Application Method

1.0 Joint Preparation

Refer to the Joint width/depth ratio as per manufacturers instructions in the technical data sheet.

1.1 The substrate to which Thioflex 600 is bonded must be clean, dry and sound. All arris repairs should be effected using a Fosroc repair compound.

1.2 Remove all dirt, surface laitence, residual joint former or other contamination from joint faces by power wire brushing, grinding or grit-blasting. Ensure usage of dry, oil-free compressed air for blowing all joints. Oil or grease can be removed using Fosroc Joint cleaner.

1.3 All expansion joints must be filled with fillers; tightly packed with no gaps or voids existing at the base of the sealing slot.

1.4 For construction or contraction joints, a bond breaker or back up tape is recommended, but in joints where hydrostatic pressure exists, only bond breaking tapes must be used.

2.0 Mixing

2.1 Gun Grade

2.1.1 The two components of Thioflex 600, supplied in correct mixing proportions, must be thoroughly mixed for atleast 2 minutes using the recommended Fosroc MR2 mixing paddle fitted to a slow speed electric drill.

2.1.2 Ensure that the inside of the tin is scraped with a flat bladed tool so that there is no component on the sides left unmixed.

2.1.3 Mixing should be continued for a further three minutes. The total mixing time is 5 minutes.

2.2 Pouring Grade

2.2.1 The two components of Thioflex 600, supplied in correct mixing proportions, must be thoroughly mixed for 5 minutes.

2.2.2 Ensure proper mixing of the material right at the bottom of the tin, as it will effect the curing otherwise.

3.0 Priming

3.1 Non-Porous Substrate

3.1.1 The substrate to which Thioflex 600 is bonded must be primed with MS2 Primer.

3.1.2 Apply the primer onto the surface using a brush and leave to dry for 10 to 30 minutes prior to sealant application.

3.2 Porous Substrates

3.2.1 The substrate must be primed with Primer 7E; a two component.

3.2.2 Add component A of Primer 7E to component B and mix thoroughly until a homogeneous dispersion is achieved.

3.2.2 Apply one thin coat of Primer7E onto the surface using a clean, dry brush, ensuring complete coverage.

3.2.3 The mixed Thioflex 600 must be applied when the primer is tack free.

3.2.4 Ensure application of Thioflex 600 within 6 hours @ 20°C, or 3 hours @ 35°C. Re-priming is necessary if application is delayed.

4.0 Application

Thioflex 600 must not be used in direct contact with materials containing pitch or bitumen.

4.1 After completion of mixing of the two components, place the single hole follower plate over the Thioflex and fill directly into a Fosroc Barrel Gun.

4.2 Gun Thioflex 600 firmly into the joint to ensure complete wetting of the bonding surfaces.

4.3 The pouring grade may be poured directly into horizontal joints. For application to horizontal joints less than 15mm wide, load the Thioflex 600 into a Fosroc “G” Gun. For quantity application, a Fosroc 1.5litre gun is available.

4.4 Compress and smooth the sealant with a joint shaping tool wetted with a dilute detergent solution.

4.5 Upon smoothening of the sealant, immediately strip off any masking tape.

5.0 Cleaning

5.1Clean all equipment immediately after use with Fosroc Solvent 102.

Section C : Approval and variations

This method statement is offered by Fosroc as a ‘standard proposal’ for the application of Thioflex 600. It remains the responsibility of the Engineer to determine the correct method for any given application.

Where alternative methods are to be used, these must be submitted to Fosroc for approval, in writing, prior to commencement of any work. Fosroc will not accept responsibility or liability for variations to the above method statement under any other condition.