



FLEXI-FILL 530

100% Solids Epoxy Paste Filler and 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° 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.

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. **Maximum application is ¼” thickness, to limit thermal expansion.**

Immediately remove any runs or excess with Xylene. Clamp or brace pieces in place, when required, and maintain support until adhesive has set completely. Mechanically reinforce heavy pieces with stainless 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.

Top coatings, such as *ELASTOWALL 351*, may be applied after the material has set through. Surface should be cleaned of 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 °F, and curing continues down to -20 °F.

Maximum application temperature is 90 °F, and product may be force-cured up to 180 °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 Safety Data Sheets supplied with this product.

Store above 50 and below 90 °F for best results.

FOR COMMERCIAL AND INDUSTRIAL USE ONLY



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