

# Thioflex 600 Pouring Grade

**Fuel resistant, multi-component, pouring grade, polysulphide joint sealant for horizontal movement joints**

## USES

Sealing horizontal movement joints in building and civil engineering structures, including roads, floors, airfields and subways.

## ADVANTAGES

- Forms a tough, elastic, rubber-like seal
- Accommodates continuous and pronounced cyclic movement
- Excellent adhesion to most common substrates
- High resistance to ageing reduces physical damage due to climatic extremes

## DESCRIPTION

A multi-component joint sealant, based on a liquid polysulphide polymer, which when mixed and applied, cures to form a tough, rubber-like seal. The cured sealant exhibits excellent adhesion to most primed surfaces including concrete, aluminium and stainless steel.

Thioflex 600 Pouring Grade for joints in horizontal surfaces is supplied in grey colour only in 4 and 16 litre packs with the base and curing agent in separate tins.

Thioflex 600 Pouring Grade is recommended for sealing expansion joints and stress relief joints in floors or other horizontal surfaces.

## DESIGN CRITERIA

Thioflex 600 Pouring Grade may be applied to joints between 5 and 50 mm wide. Joints which are expected to experience cyclic movements should be designed to an optimum width:depth ratio of 2:1, subject to the overriding recommended minimum sealant depths set out below:

5 mm for metals and other non-porous surfaces;

10 mm for all porous surfaces;

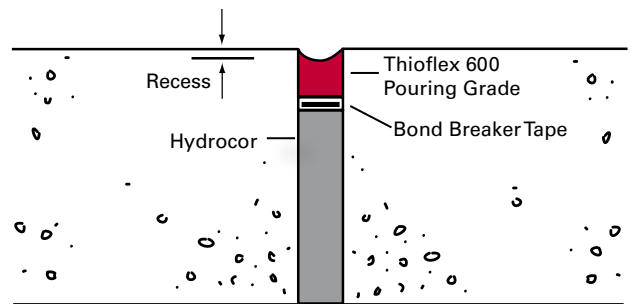
20 mm for trafficable joints and those subject to hydrostatic pressures.

All joints subject to repeated movement should be

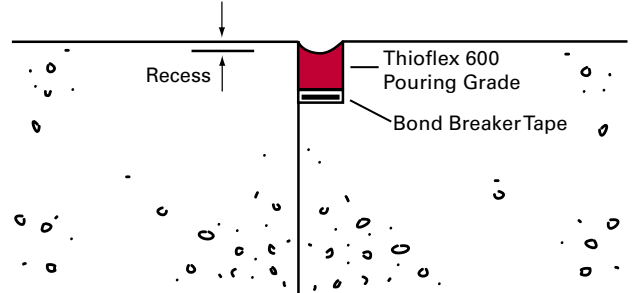
designed and spaced so that the total movement in tension and compression does not exceed 50% of the joint width at the time of sealing. Total movement in shear should not exceed 50% of joint width at the time of sealing.

All movement joints shall be recessed 2 mm below flush so that during joint contraction the sealant does not protrude above the surface and so become susceptible to damage from traffic.

### TYPICAL EXPANSION JOINT



### TYPICAL CONSTRUCTION JOINT



## TECHNICAL SUPPORT

Parchem offers a technical support package to specifiers and contractors as well as on-site technical advice from staff with experience in the construction industry.

# Thioflex 600 Pouring Grade



## PROPERTIES

<b>Form:</b>	Multi-part component
	Base: viscous liquid
	Curing agent: paste
<b>Colour:</b>	Grey
<b>Movement accommodation factor:</b>	50% total (+/- 25%)
<b>Physical/chemical change:</b>	Chemical cure
<b>Application life:</b>	2 - 4 hours @ 25°C
<b>Setting time:</b>	72 hours @ 5°C 36 hours @ 15°C 18 hours @ 25°C
<b>Cure time:</b>	4 weeks @ 5°C 2 weeks @ 15°C 1 week @ 25°C
<b>Application temperature:</b>	5 - 50°C
<b>Hardness shore 'A' @ 25°C:</b>	15 - 23
<b>Chemical resistance to occasional spillage:</b>	Dilute acids resistant Dilute alkalis resistant Petrol resistant Aviation fuels resistant Diesel fuel resistant Kerosene resistant Lubricating oils resistant Skydrol resistant White spirit resistant Chlorinated solvents not resistant Aromatic solvents not resistant Dilute oxidising acids not resistant
<b>Solids content:</b>	>98%
<b>Density:</b>	1.65 kg / litre

## MAINTENANCE

No special requirements, any damage identified during normal building inspections should be repaired or replaced as appropriate.

## SPECIFICATION CLAUSES

Joints shall be sealed using Thioflex 600 Pouring Grade, two part, sealant, manufactured by Parchem. Joints shall be prepared and the sealant mixed and applied in accordance with the manufacturer's current Technical Data Sheet.

## APPLICATION INSTRUCTIONS

### JOINT PREPARATION

The joint surfaces must be thoroughly dry, clean and frost free. Remove all dust and laitance by rigorous wire brushing, grinding or grit blasting. Remove all rust, scale and protective lacquers from metal surfaces. Remove any oil or grease with Parchem Solvent.

Any expansion joint filler must be checked to ensure it is tightly packed and no gaps or voids exist at the base of the sealing slot before positioning a bond breaker tape.

Note: the use of a bond breaker tape is not required in expansion joints containing polyethylene foam joint fillers. For construction or contraction joints polyethylene bond breaker tape or back-up strip must be used.

Where a particularly neat finish is required, mask the face edges of the joint before priming and remove immediately after tooling is completed.

### PRIMING

**Primer 4:** For use on metals and ceramics. It is a one-component chemically active clear liquid for brush or pad application. One thin coat should be applied and allowed to dry for a minimum of 5 minutes prior to sealant application.

**Primer 7:** It is a one-component chemically active straw coloured liquid for brush application to concrete, stone, brickwork, timber and unglazed edges of ceramic tiles. Apply an even coat of Primer 7 to the bonding faces of the joint. Excessively porous surfaces may need more than one coat – this is evident where applied primer does not give a smooth, glossy surface when dry. Allow final coat to become touch dry (approx. 1 hour) before application of Thioflex 600 Pouring Grade.

Any primed areas not sealed within 8 hours of primer application will need to be re-primed 1 hour prior to sealant application.

### IMPORTANT FOR ALL PRIMERS

Avoid over priming resulting in an excess of primer in the base of the joint or application beyond faces. **The mixed Thioflex 600 must be applied when the primer is tack free,** that is after the evaporation of the solvent but before the primer film has completely reacted. If joints are not sealed within 8 hours of primer application, they must be re-primed and allowed to become touch dry as previously stated.

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## MIXING

Thioflex 600 Pouring Grade is supplied in two separate containers. The small container contents should be transferred to the larger tin. Mix thoroughly using a slow speed drill (300-500 rpm) fitted with a Paddle Stirrer for 5 minutes. Only thorough mixing, including material right at the bottom of the tin, will result in proper curing. In cold weather Thioflex 600 mixes more easily if stored overnight at room temperature. The pouring grade may be poured directly into horizontal joints. For application to horizontal joints less than 15 mm wide load into a suitable gun.

## FINISHING

Note: Thioflex 600 Pouring Grade is NOT a 'self levelling' material. Release of air bubbles from joints with rough or porous faces will be enhanced by tooling the sealant surface with a convex tool. Any masking tape should be removed immediately after tooling.

## CLEANING

Clean equipment immediately after use with Parchem Solvent. Cured sealant can only be removed mechanically or after soaking in Parchem Solvent.

## CONTRACT APPLICATION

The designer or contractor may wish to use the services of a specialist sub-contractor for joint sealing work. Names of preferred sub-contractors are available from Parchem.

## LIMITATIONS

Over-painting of sealants is not recommended because of the inability of paint films to accept movement. However, if required, trials should be carried out to determine compatibility.

Thioflex 600 Pouring Grade should not be used in direct contact with materials containing pitch or bitumen.

Thioflex 600 Pouring Grade should not be used in joints in reservoirs or other water retaining structures which may be subject to high chlorination levels or biologically active conditions.

## ESTIMATING

### Packaging

**Thioflex 600 PG:** 4 & 16 litre pack

**Primer 4:** 250 ml tin

**Primer 7:** 1 litre can

**Parchem Solvent:** 4 and 20 litre drums

## GUIDE TO QUANTITIES

Joint size in mm	Litres per metre run	Metre run per 4 litre pack
5 x 5	0.025	160.00
5 x 10	0.050	80.00
10 x 5	0.050	80.00
10 x 10	0.100	40.00
20 x 10	0.200	20.00
20 x 15	0.300	13.30
20 x 20	0.400	10.00
40 x 20	0.800	5.00
40 x 25	1.000	4.00
40 x 30	1.200	3.20
40 x 40	1.600	2.40
50 x 25	1.250	3.20
50 x 30	1.500	2.60
50 x 40	2.000	2.00
50 x 50	2.500	1.60

1 litre of Primer 4 to 100 litres of Thioflex 600 Pouring Grade.

1 litre of Primer 7 to 30 litres of Thioflex 600 Pouring Grade.

These are theoretical yields. No allowance has been made for variation in joint width or wastage.

## STORAGE

Storage life of 12 months in original containers when kept in dry conditions between 5°C and 27°C.

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## ADDITIONAL INFORMATION

Parchem provides a wide range of complementary products which include:

- concrete repair – cementitious and epoxy
- grouts and anchors – cementitious and epoxy
- waterproofing membranes – liquid applied, cementitious and bituminous sheet membranes
- waterstops – pvc and swellable
- joint sealants – building, civil and chemical resistant
- industrial flooring systems – cementitious and epoxy
- architectural coatings
- filler boards – swellable cork, bituminous and backing rod
- ancillary products

For further information on any of the above, please consult with your local Parchem sales office.

## IMPORTANT NOTICE

A Material Safety Data Sheet (MSDS) and Technical Data Sheet (TDS) are available from the Parchem website or upon request from the nearest Parchem sales office. Read the MSDS and TDS carefully prior to use as application or performance data may change from time to time. In emergency, contact any Poisons Information Centre (phone 13 11 26 within Australia) or a doctor for advice.

## PRODUCT DISCLAIMER

This Technical Data Sheet (TDS) summarises our best knowledge of the product, including how to use and apply the product based on the information available at the time. You should read this TDS carefully and consider the information in the context of how the product will be used, including in conjunction with any other product and the type of surfaces to, and the manner in which, the product will be applied. Our responsibility for products sold is subject to our standard terms and conditions of sale. Parchem does not accept any liability either directly or indirectly for any losses suffered in connection with the use or application of the product whether or not in accordance with any advice, specification, recommendation or information given by it.

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