

**DURA FILL H.S. CRACK FILLER A-420
PRODUCT DATA AND APPLICATION BULLETIN**



PRODUCT:

Dura-Fill H.S. heat stabilized formula for direct fired kettles. This low penetration, self leveling, rapid melting crack filler is flexible to 0° F, and stays resistant to tracking even at elevated temperatures.

Dura-Fill H.S. is a specialty grade, premium quality joint and crack sealing compound, specifically formulated for direct fired heaters, because it is heat stabilized. The heat stabilized formula will withstand temperatures up to 550°F without experiencing degradation. Conventional sealants must be melted in oil jacketed heating kettles which have longer melting times and are more expensive than direct fired heaters.

USES:

Dura-Fill H.S. is recommended for sealing of joints and cracks in Portland cement and asphaltic pavements and parking lots. It is designed to seal expansion and contraction joints, longitudinal and traverse cracks, joints between concrete and asphaltic shoulders and random cracks. Dura-Fill H.S. is relatively hard and has a high softening point which makes it well suited for use on parking lots. It needs no sanding, sets up quickly and is firm under pedestrian traffic.

PRODUCT DATA:

Recommended Application Temp.....	350° -450°F
Pour Temp. Range.....	280° -550°F
Maximum Heating Temp.....	550°F
Bond @ 0°F.....	(1" mandrel)-pass
Penetration (150gr/5sec).....	40
Softening Point.....	185°F min.
Resiliency.....	60%
Specific Gravity.....	1.02
Asphalt Compatibility.....	Compatible



TECHNICAL BULLETIN H.S.-1

ARMOR MANUFACTURING APPLICATION DATA FOR DURA FILL H.S. CRACK FILLER

PREPARATION: Proper surface preparation will facilitate adequate adhesion and consequently the maximum service life of the sealant. In order for proper adhesion, the crack must be free of moisture, dust, loose aggregate, or other contaminants. The substrate and air temperatures must be 40°F or above. Compressed air, routing or power driven brush cleaners are the preferred methods of preparation. Joints should be sized so that the maximum extension and compression does not exceed 50% of the width. Best results are obtained when sealant depths to width ratios do not exceed 2 to 1 and the joints are opened to at least ½ inch wide.

APPLICATION: Dura-Fill H.S. may be melted in direct fired or oil jacketed kettles. The heat stabilized formula can withstand temperatures up to 550°F.

Carefully insert small quantities of H.S. and the plastic bag into the melting equipment while the agitator is turned off. Load the material slowly to avoid splash back. After the initial load has reached the recommended pouring temperature, fresh material may be added to the melter as sealant is used. Melt only the amount of material that will be used the same day. Sealer can be applied using a pressure feed wand system or through a pour pot. Melter equipped with hydraulic pressure material lines should purge any material remaining in the lines at the end of each sealing operation. Material remaining in the melter may be reheated as required. Applied sealer should be followed up with an application squeegee before it is cured so as to insure material penetration and even appearance.

COVERAGE:	WIDTH	DEPTH	POUND/100 LINEAL FEET	3/8"3/8" 6.2
	3/8"	½"	8.3	
	½"	½"	11.1	
	½"	1"	22.2	
	3/4"	½"	16.6	
	3/4"	3/4"	25.0	

CAUTION: Note: The temperature of the heat transfer oil should not exceed 525°F. Do not heat Dura-Fill H.S. above the maximum heating temperature or do not maintain it at that temperature for prolonged periods of time (6 hours). This could cause the material to gel in the equipment or fail in the joints. A significant viscosity increase accompanied by stringiness signals the approach of gelatin. If this occurs, immediately remove the material from the melter and dispose of it.