

ARMOR MANUFACTURING CO.
A-420 'DURA-FILL' HEAT STABILIZED CRACK FILLER
PRODUCT DATA 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.

Dura-Fill H.S. is unique in that it is 100 % asphalt and Thermo Plastic Rubber. Since it does not incorporate crumb rubber, its specific gravity or weight per gallon, is greater than other hot pour crack fillers.

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:

Crumb Rubber Content.....	None
Thermo Plastic Rubber Content.....	10%
Recommended Application Temp.....	350°-400°F
Pour Temp. Range.....	280°-450°F
Maximum Heating Temp.....	450°F
Bond @ 0°F (1" mandrel).....	pass
Penetration (150 gr/5 sec.).....	50 Max.
Softening Point.....	200° F Min.
Resiliency.....	60% Min.
Specific Gravity.....	1.02
Weight Per Gallon.....	8.60 Lbs. Per Gallon Min.
Asphalt Compatibility.....	Compatible

PACKAGING: Dura-Fill H.S. is packaged in 2-25 lb. poly-bags in a 50 lb. high strength corrugated box. Each pallet contains 36 boxes or approximately 1,800 lbs. of Dura-Fill.

APPLICATION: See reverse side for application instructions.

**ARMOR MANUFACTURING CO. DURA-FILL A-420
HEAT STABILIZED CRACK FILLER PRODUCT DATA BULLETIN**



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 650°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. Melters 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
	¾"	½"	16.6
	¾"	¾"	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.