

# CRACKBOND<sup>®</sup> JF-90 HD

## Semi-Rigid Epoxy



### Product Description

CRACKBOND<sup>®</sup> JF-90 HD is a two component, moisture insensitive heavy duty epoxy joint filler and crack filling material. Its semi-rigid design allows for use in industrial floors exposed to hard-wheeled forklift traffic. It may be used in temperatures between 60 °F and 120 °F (16 °C and 49 °C).

### General Uses & Applications

- Used to fill concrete control joints
- Fill cut or formed contraction/construction joints
- Crack filler for cracks, spalls and concrete control joints

### Advantages & Features

- Semi-rigid formula allows for moderate joint movement
- Heavy-duty formulation with Shore A Hardness of 90
- Protects joint edges from spalling due to wheeled traffic
- Keeps joints free of debris and provides a continuous surface for weight loading
- Shaves easily
- Paintable
- Cures on damp surfaces
- Easy to mix - 1:1 ratio
- Self-priming
- Moisture insensitive
- Does not embrittle with age

**Availability:** Adhesives Technology Corp. (ATC) products are available online and through select distributors serving all your construction needs. Please contact ATC for a distributor near you or visit [www.atcepoxy.com](http://www.atcepoxy.com) to search for a distributor by zip code.

**Color & Ratio:** Part A (Resin) Gray; Part B (Hardener) Dark Amber, Mixed Ratio: 1:1 by volume, Mixed Color - Light Concrete Gray

**Storage & Shelf Life:** For best results, store between 40 °F and 90 °F (4 °C and 32 °C) in dry and dark conditions. Shelf life is 24 months when stored in unopened containers (12 months for cartridges).

**Installation:** Installation instructions are available within this Technical Data Sheet (TDS). Due to occasional updates, always obtain the most current revision. In order to achieve maximum results, proper installation is imperative.

**Clean-Up:** Always wear appropriate personal protective equipment such as safety glasses and gloves. Clean uncured materials from tools and equipment using a mild solvent, such as CRACKBOND<sup>®</sup> INDUSTRIAL CITRUS CLEANER from Adhesives Technology Corp. Cured material may only be removed mechanically using a sander or grinder. Collect with absorbent material. Flush area with water. Dispose of in accordance with local, state and federal disposal regulations.

### Limitations & Warnings:

- For professional use only
- Do not thin with solvents, as this will prevent cure
- Product should not be installed on new concrete floors until maximum concrete shrinkage has occurred in accordance with ACI 302
- Do not install until building is under permanent temperature control
- For best results, saw cuts should be installed to full depth and at least 1 in. deep in formed joints
- Epoxies may yellow, discolor, or chalk upon exposure to strong sources of Ultra-Violet radiation such as from sunlight, and some types of industrial artificial lighting
- Substrate temperatures should be a minimum of 40 °F
- Do not expose stored or uncured product to cold or hot temperatures below 40 °F (4 °C) or above 90 °F (32 °C) for any length of time

**Safety:** Please refer to the Safety Data Sheet (SDS) for CRACKBOND JF-90 HD published on ATC's website or call for more information at 1-800-892-1880.

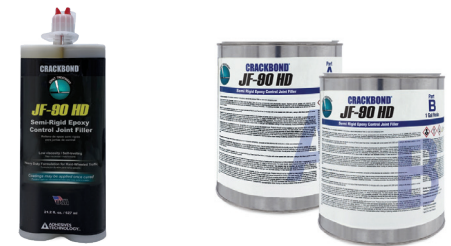
**Specification:** Joint filler material shall be a two component, 1:1 mix ratio semi-rigid epoxy. At 2 day cure, Shore A Hardness shall be 90 and Shore D Hardness shall be 45 per ASTM D2240. Joint filler shall be CRACKBOND JF-90 HD from Adhesives Technology Corp., Pompano Beach, Florida.

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TABLE 1: CRACKBOND JF-90 HD Packaging

Package Size	21.2 fl. oz. (627 ml) Cartridge <sup>1</sup>	2 Gallon (7.6 L) Kit	10 Gallon (38 L) Kit
Part #	A22-JF90	B2G-JF90	B5G-JF90-A B5G-JF90-B
Recommended Mixing Nozzle	T12	N/A	N/A
Manual Dispensing Tool	TM22HD		
Pneumatic Dispensing Tool	TA22HS-A	Pump <sup>2</sup>	Pump <sup>2</sup>
Case Qty.	12	1	1
Pallet Qty.	576	72	18
Pallet Weight (lb.)	1,000	1,480	1,660

- Each cartridge is packaged with one mixing nozzle.
- Contact ATC for recommended bulk dispensing manufacturers.



A22-JF90

B2G-JF90



B5G-JF90-A / B5G-JF90-B

TABLE 2: CRACKBOND JF-90 HD performance to ASTM Standards<sup>1,2,3</sup>

Property	Cure Time	ASTM Standard	Units	Sample Conditioning Temperature
				75 °F 24 °C
Gel Time 60 Gram Mass	----	C881	min	12
Tack-Free Time (30 mil Thin Film)	----	D2377	hr	2.33
Viscosity	----	D2196	cP	Part A: 4,030 Part B: 9,500 Nozzle mixed: 3,100
Tensile Strength	7 day	D638	psi (MPa)	1,000 (6.9)
Tensile Elongation			%	49.2
Bond Strength Hardened to Hardened	14 day	C882	psi (MPa)	690 (4.8)
Shore A Hardness	2 day	D2240	----	90
	14 day			98
Shore D Hardness	2 day	D2240	----	45
	14 day			55
Adhesion to Concrete	24 hr	D7234	psi (MPa)	270 (1.9)

TABLE 3: CRACKBOND JF-90 HD CURE SCHEDULE<sup>1,2,3</sup>

Base Material Temperature	Working Time	Trim/Shave Time <sup>4</sup>	Full Cure Time
°F (°C)			
75 (24)	75 min	3.0 - 5.0 hr	20 hr
90 (35)	60 min	2.5 - 4.5 hr	16 hr
120 (49)	30 min	2.0 - 3.5 hr	10 hr

- Working and full cure times are approximate, may be linearly interpolated between listed temperatures and are based on cartridge/nozzle system performance.
- Application Temperature: Substrate and ambient air temperature should be between 60 and 120 °F (16 and 49 °C).
- When ambient or base material temperature falls below 60 °F (16 °C), condition the product between 60 and 85 °F (16 and 29 °C) prior to use.
- Trim/Shave times are estimates and based on a 1/2 in. (13 mm) bead. At 75 °F (24 °C), some installers may prefer to wait 1 hour depending upon installation conditions. NOTE: Warming the CRACKBOND JF-90 HD control joint filler after the maximum time will extend shave window.

- Results based on testing conducted on a representative lot(s) of product. Average results will vary according to the tolerances of the given property.
- Full cure is listed above to obtain the given properties for each product characteristic.
- Results may vary due to environmental factors such as temperature, moisture and type of substrate.

Revision 1.0

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### Surface Preparation

(New Concrete) - Joints to be filled must be clean, free of curing compounds and structurally sound. Remove all oil, grease, dirt, laitance, curing compounds and any other foreign material that may cause issues with bonding. Abrasive cleaning and mechanical removal methods, such as a diamond grinding wheel are recommended. Area must be free of all dust and debris prior to installation.  
(Existing Concrete) - In existing concrete, the old joints must be routed out to remove old material and widen, if necessary.

### Mixing

**CARTRIDGE** - Remove the protective cap from the adhesive cartridge and insert the cartridge into the recommended dispensing tool. Before attaching the mixing nozzle, balance the cartridge by dispensing a small amount of material until both components are flowing evenly. Screw the proper ATC mixing nozzle onto the cartridge (do not modify mixing nozzle). Confirm that internal mixing element is in place prior to dispensing adhesive. Begin dispensing a small amount of material from the mixing nozzle onto a disposable surface until the material extruded is a smooth uniform gray color with no streaks. Material with an off color or streaking is not properly mixed and will not set properly or perform as expected. Do not use this part for installation. Once the proper mixture is achieved, discard the material initially extruded from the nozzle per federal, state, and local regulations, then begin installation.

**BULK** - Premix each component separately, then mix equal volumes of Part A and Part B for 3 minutes with a low speed drill (300 rpm), using a Jiffy Mixer paddle or similar. Mix only the amount that may be used during the pot life.

### Placement

Fine clean sand may be used to close off small shrinkage cracks in the bottom of joints prior to placement of CRACKBOND JF-90 HD. In accordance with ACI 302, semi-rigid epoxy fillers should be installed full depth in saw cut joints and at least 1 in. deep in formed joints. For best results, apply material between 65 °F - 85 °F (18 °C - 29 °C). JF-90 HD may be installed with a caulking gun or poured into the joint from a suitable container. Two passes may be required, as pourable leveling materials will settle in the joint. The second pass must be made within 12 hours at 75 °F (24 °C). Ultimately, the filled joint should be flush with the floor surface. Another installation technique is to overfill the joint, then once tack free, cut the JF-90 HD flush with a razor knife. A heat gun can facilitate cutting if it has hardened. Avoid overheating the cured JF-90 HD.