Pecora® DynaThane 800MM

Two-Component, Rapid Curing, Semi-Rigid, Polyurethane/ Polyurea Hybrid Control Joint Resin

PECORA CORPORATION®

SPECIFICATION DATA SHEET

BASIC USES

- Pecora DynaThane 800MM is designed to fill and support saw cut crack control joints in concrete exposed to vehicular traffic in industrial and warehouse floors including commercial refrigerators and freezers.
- Tamper resistant security sealant applications.

MANUFACTURER

Pecora Corporation

165 Wambold Road
Harleysville, PA 19438
Phone: 215-723-6051
800-523-6688
Fax: 215-721-0286
Website: www.pecora.com

PRODUCT DESCRIPTION

Pecora DynaThane 800MM (Machine Mix) is a two-part, semi-rigid, pourable, low odor, low VOC, rapid curing, flexible, polyurethane/polyurea hybrid control joint resin which is used specifically to protect concrete floor joint edges against breaking (spalling) caused by the rigid wheels of industrial vehicular traffic. Pecora DynaThane 800MM utilizes a rapid curing, polyurethane/polyurea hybrid formulation that cures within minutes which minimizes downtime and allows for a quicker return to service.

Pecora DynaThane 800MM requires no primer under normal conditions, is 100% solids (will not shrink), cures to a semi-rigid hardness, and can be applied at ambient temperatures down to -15˚F (-26˚C).

Pecora Dynathane 800MM exhibits a high Shore A hardness and is acceptable for use in secure facilities or areas requiring a tamper-resistant security sealant such as correctional institutions, detention centers, or high-security commercial settings.

LIMITATIONS

- Dynamic joints where thermal movement is anticipated.
- Exterior joints exposed to UV.
- Where color stability is required.
- Exposure to hydrocarbon fueled temporary heating utilized during the joint filler installation process.

APPLICABLE STANDARDS

There are currently no government or ASTM standards for semi-rigid joint fillers. Pecora DynaThane 800MM meets or exceeds the criteria outline in the following industry standards: American Concrete Institute (ACI) Guides/ Specifications: 301-16, 302.1-R15, 310-R13, 360R-10. Portland Cement Association (PCA): Concrete Floor on Ground, Third Edition 2008. FDA Title 21 CFR 177.2600 and CFR 177.1550. Meets USDA requirements for use in meat and poultry processing facilities where incidental contact may occur. CFIA compliance for use in food processing or packaging facilities where incidental contact may occur.

APPLICATION

Surface Preparation: Concrete floors should have a minimum cure of 28 days prior to joint filling. Since concrete shrinks for many months, and shrinkage results in the widening of joints, filling should always be delayed for as long as the schedule allows. If filling in refrigerated areas (coolers/freezers), the room should be stabilized at its final operating temperature for 7-14 days or longer, if possible. Joints should be clean and dry.

Pecora DynaThane 800MM must bond to clean, exposed concrete for the full intended filler depth. Joints must be free of saw laitance, dirt, debris, coatings, sealers, etc. Apply to freshly cut joints which have been vacuumed during the saw cutting process to remove all loose debris and dust. Upon completion of saw cutting processes, vacuum any remaining dust/debris from joint. Simply "raking" debris out of joint is not an acceptable means of joint cleaning.

Dispensing Equipment: Pecora DynaThane 800MM is dispensed via prepackaged side-by-side dual cartridges or from bulk packaging via dual component pumps (1:1 mix ratio). Both methods will require disposable static mixing nozzles. Do not attempt to hand mix the 800MM as the working time (pot life) is extremely short. Refer to Pecora Technical Bulletin #223 for Dynathane 800MM bulk packaging dispensing equipment recommendations and guidelines.

- **600mL Dual Component Cartridges** will require a manual, pneumatic, or battery powered 1:1 ratio dual component gun for dispensing. Static mixing nozzles are included. Static mixing nozzles should contain 32

PACKAGING

- 600mL side-by-side 1:1 dual component cartridge
- 10-gallon kit:
  - 5-gallon pail, Part A
  - 5-gallon pail, Part B

COLOR

- Gray, Mortar Gray, custom colors available upon request.

TYPICAL PHYSICAL PROPERTIES & COVERAGE RATES

Test Property	Results	Test Procedure
Viscosity, Part A, cps	<3000	Brookfield
Viscosity, Part B, cps	<3000	Brookfield
Color, mixed	Gray	Pecora Corporation
Mix Ratio, by volume	1:1	Pecora Corporation
Shore A hardness, points	85	ASTM D2240
Shore D hardness, points	33	ASTM D2240
Adhesion to Concrete, psi	>300	ASTM D4541
Shave Time @ 75°F, minutes	15	Pecora Corporation
Shave Time @ -15°F, minutes	30	Pecora Corporation
Solids Content, %	100	Pecora Corporation
Shrinkage	None	Pecora Corporation
Pot Life @ 75°F, seconds	30	Pecora Corporation
Initial Cure/Gel @ 75°F, seconds	45	Pecora Corporation
Open to Light Traffic @ 75°F, minutes	15 minutes	Pecora Corporation
Open to Light Traffic @ -15°F, minutes	30 minutes	Pecora Corporation
Open to Full Traffic @ 75°F, minutes	30 minutes	Pecora Corporation
Open to Full Traffic @ -15°F, minutes	60 minutes	Pecora Corporation
Tensile Elongation, %	140	ASTM D412
Tensile Strength, psi	600	ASTM D412

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mixing elements and have a ½" inner diameter. Deviation from these nozzle specifications may affect the cure and razoring times. Consult Pecora Technical Service with any questions regarding the nozzle specifications.

- **10-gallon Bulk Kits** will require dual component pumping equipment capable of dispensing the materials at a 1:1 mix ratio. There are numerous pump models currently available including single man operated and hand-held options. The pumps are predominantly electric powered with select manufacturers offering battery powered capabilities for cordless operation. Refer to Pecora Technical Bulletin #223 for Dynathane 800MM bulk packaging dispensing equipment recommendations and guidelines.

Dispensing Guidelines:
600mL Dual Component Cartridges:

1. Remove threaded collar and plug from cartridge tip. Discard the plug.
2. Attach the static mixing nozzle by sliding the threaded collar over the mixing nozzle then secure by threading the collar onto the cartridge tip.
   a. If work is stopped for more than a one (1) minute, a new nozzle will be required when resuming work.
3. Place cartridge into dispensing gun cradle ensuring proper alignment and a secure fit.
4. Always extrude approximately 1 to 2 fl. oz. before starting application to avoid unactivated material entering joint.
5. Fill joints as described under Joint Filling.

10-gallon Bulk Kits:

- Pump purging will be required to clear any oils from the factory for new pumps or solvent and/or previous materials from an existing pump. Pecora recommends following the pump manufacturer's procedure for purging.
- Pecora requires isopropyl alcohol for purging and cleaning. Consult Technical Service for alternate solvents.
- Hoppers, hopper screens, and hoses should be clean and free of debris.
- Pumps are to be set at a 1:1 ratio, by volume.
- Monitor the material volumes as the components are being dispensed. The levels within the hoppers should remain even as the material is dispensed. If not, check the pump settings and adjust the mix ratio accordingly.
- Pre-mix both base and activator components before adding to dispensing equipment.
- Perform periodic cure tests to ensure the proper mix ratio is being maintained.
- Fill joints as described under Joint Filling.

Joint Filling: Crack control joints typically are cut utilizing a diamond blade saw capable of creating crack control joints at a depth of ⅓ the full thickness of the concrete slab.

Through-Slab Construction (Formed) Joints (or any joints exceeding 2" depth): The installer may use silica sand or backer rod if it is held down at least 2" from the top surface. Contact Pecora Technical Service for information on special conditions.

Coverage Rates

Joint Size (Width x Depth), inches	Lineal Feet per Gallon, Lf/gal
1/8 x 2	77.0
1/4 x 2	38.5
1/2 x 2	19.3
3/4 x 2	12.8

Note: Refer to the Pecora Online Calculator for material estimates and coverages for joint sizes that deviate from those published here.

General Installation Technique:

1. Typically, joints may be filled in a single pass. Fill the joint from the bottom up and slightly overfilling to create a crown. If filling in a single pass then proceed to Step #4. If two passes are preferred or necessary, proceed to steps 2 and 3.
2. Install the first pass of Pecora DynaThane 800MM to within ½" of floor surface. Observe for any areas of seepage that will require re-filling with the second pass.
3. Make second pass and overfill joint (crown).
4. Allow Pecora DynaThane 800MM to cure into a solid, usually 15 minutes at 75°F, before razoring.
5. Complete the installation by finishing (shaving) the top surface of the sealant by using a tile razor floor scraper or similar tool. This is achieved by shaving off the overfill crown AFTER the Pecora DynaThane 800MM has cured into a solid. Surface razoring time is 15 minutes at 75°F.

To provide effective concrete joint edge protection, the Pecora DynaThane 800MM final profile must be flush with the floor surface. Extreme low or high ambient temperatures will affect the cure and razoring time. For information regarding DynaThane 800MM chemical resistance, refer to Pecora Technical Bulletin #224.

SHELF LIFE

One (1) year in dual cartridge packaging and two (2) years in bulk packaging from date of manufacture when stored at 80°F or below.

WARNINGS AND HAZARDS:

Before use refer to SDS for important warnings and safety information. Avoid contact with skin, eyes, or clothing. The use of gloves, aprons or other protective devices is recommended. In case of skin contact, wash thoroughly with soap and water. If contact with eyes is made, flush thoroughly with clear water and get medical attention.

FOR PROFESSIONAL USE ONLY. KEEP OUT OF THE REACH OF CHILDREN.

LIMITED WARRANTY

Pecora Corporation warrants this product to be free of defects. Under this warranty, we will provide, at no charge, replacement materials for, or refund the purchase price of, any product proven to be defective when installed in accordance with our published recommendations and in applications considered by us as suitable for this product. This warranty is in lieu of any and all other warranties, expressed or implied, and in no case will Pecora be liable for incidental or consequential damages.

TECHNICAL SERVICES

Pecora representatives are available to assist you in selecting an appropriate product and to provide on-site application instructions. For further information and assistance, please call our Technical Service department at 215-723-6051 or 800-523-6688.