Technical Information Sheet

Acolan® FLEXFILL

Article No. 6275

Solvent-free, filled, flexible, unplasticized, 2-component binder on an epoxy resin base.

Property profile:

Acolan FlexFill is a flexible, filled epoxy resin binder with sufficient flowing properties for levelling smaller unevenness and roughness profiles.

Range of use:

Acolan FlexFill is used as a priming or smoothing filler for levelling smaller unevenness and roughness profiles on substrates prior to coating. It can also be used as a grano sprinkling finish.
After corresponding priming, it can also be used on wood and metal substrates. Its suitability as a priming filler on bituminous mastic concrete should be determined on a respective trial surface.

Characteristic data of the product:

	Comp. A	Comp. B	Mixture
Viscosity (25° C):	4500 mPas	210 mPas	paste
Appearance:	sand	yellowish	sand
Density (20°C):	2.02 g/cm³	1.06 g/cm³	1.78 g/cm³
Odour:	neutral	amine	weak
Flash point:	> 100°C	> 100°C	> 100°C

Mixing ratio:
Parts by weight 84 : 16
Parts by volume: 73.7 : 26.3

Pot-life at +20°C: 20 min., 10 kg mixture

A-Shore hardness: 88

D-Shore hardness: 45

Adhesive strength:
Pure Acolan FlexFill: > 2.0 N/mm²
Acolan FlexFill + ASM 05: > 2.0 N/mm²
Acolan FlexFill + ASM 08: > 2.0 N/mm²
Compressive strength: > 60 N/mm²
Flexural/tensile strength: > 20 N/mm²

Loading capacity: Foot traffic after approx. 12 hours at a temperature of 20°C. Full mechanical and chemical loading capacity is achieved after 7 days at a hardening temperature of 20°C.

Mixing time: 3 minutes

Substrates:

All sufficiently load-bearing, cement bound materials such as concrete and cement screeds are suitable. The minimum compressive strength of the substrate must be 25 N/mm² and minimum tear strength 1.5 N/mm². Floor slabs should be protected in a suitable manner against rising capillary moisture. The surfaces to be treated must be clean.. Soiling, cement skin or layers of silicate, substances with a parting effect such as oil, grease, paraffin, abraded rubber, parting and curing agents and the remains of coatings should be removed by steel ball jetting (Blastrac), sandblasting, flame blasting or grinding. Remove dust thoroughly afterward with an industrial vacuum cleaner.

Directions:

Mixing:
The two components are packaged in a special container in the proper mixing ratio. Produce the mixture according to the DBV Code of Practice "Using Cold-Cured Resins in Concrete Construction – part 3.2 – Using Cold-Cured Resins on Concrete". The hardener component (B) should be completely added to the resin component (A). Use suitable mixing equipment when mixing filled systems, e.g. a Beba Positive Mixer, mixing with a max. speed of 400 rpm.
A minimum mixing time of 3 minutes should be observed. The larger the amount to be mixed and/or the more viscous the components, the longer the material needs to be mixed. Streaks indicate insufficient mixing. Especially when the components have different viscosity, the lesser mixed material that adheres to the sides and bottom of the container as well as on mixing tools should be scraped off and returned to the mixture. The mixture should then be filled into a separate, clean container and mixed again. It is then ready to use. Insufficiently mixed material causes the formation of blisters and soft, incompletely reacted spots. Then apply the material in the designated manner.
In case of need, mix Acolan FlexFill with Acolan SelectMix 05, resp. 08 in the appropriate mix ratio

Application:
Acolan FlexFill is applied to the prepared substrate with a suitable adhesive spreader with a tooth blade, smoothing trowel or tooth squeegee, applying at least 1.5 kg/m². The fresh layer is then evenly worked through with a spiked roller at least twice, cross-wise and length-wise. Immediately after de-airing, the respective blinding material, e.g. Acolan Sediment Flakes, are sprinkled evenly and generously over the fresh layer. Fixation and sealing are carried out according to the Technical Information Sheets for the respective products. In

order to level up larger roughness profiles, 0.5 parts by weight of Acolan SelectMix 05, resp. 0.8 parts by weight Acolan SelectMix 08 may be added. If Acolan SelectMix is used, the minimum application rate of Acolan FlexFill is increased to 2.0 kg/m², with the corresponding quantity of Acolan SelectMix.

Working guidelines:

The ambient temperature and the temperature of the substrate should not fall below +8°C. Hardening is accelerated at higher temperatures and delayed at lower temperatures. The formation of condensation on surfaces to be coated which often occurs if the temperature falls below the condensation point temperature considerably reduces adhesional strength. In the case of multiple-layer construction, the following layer should never be applied if the temperature of the substrate is less than or equal to the condensation point temperature. For this reason, the condensation point temperature should be at least 3°C below the temperature of the substrate to be coated. (To determine the condensation point temperature, relative humidity and air temperature are measured with, e.g. a thermohygrometer and determined with the aid of a condensation point table.) If the temperature relationship is unfavourable, the use of heating equipment will be required. To avoid adhesion problems on multiple-layered construction, each lower layer should be blinded with quartz sand.

Note:

Higher temperatures and larger amounts reduce working time; lower temperatures increase working time.

Dew point table:

Air temp.	Condensation point temperature[1] in °C with a relative humidity of:													
°C	30%	35%	40%	45%	50%	55%	60%	65%	70%	75%	80%	85%	90%	95%
30	10.5	12.9	14.9	16.8	18.4	20.0	21.4	22.7	23.9	25.1	26.2	27.2	28.2	29.1
29	9.7	12.0	14.0	15.9	17.5	19.0	20.4	21.7	23.0	24.1	25.2	26.2	27.2	28.1
28	8.8	11.1	13.1	15.0	16.6	18.1	19.5	20.8	22.0	23.2	24.2	25.2	26.2	27.1
27	8.0	10.2	12.2	14.1	15.7	17.2	18.6	19.9	21.1	22.2	23.3	24.3	25.2	26.1
26	7.1	9.4	11.4	13.2	14.8	16.3	17.6	18.9	20.1	21.2	22.3	23.3	24.2	25.1
25	6.2	8.5	10.5	12.2	13.9	15.3	16.7	18.0	19.1	20.3	21.3	22.3	23.2	24.1
24	5.4	7.6	9.6	11.3	12.9	14.4	15.8	17.0	18.2	19.3	20.3	21.3	22.3	23.1
23	4.5	6.7	8.7	10.4	12.0	13.5	14.8	16.1	17.2	18.3	19.4	20.3	21.3	22.2
22	3.6	5.9	7.8	9.5	11.1	12.5	13.9	15.1	16.3	17.4	18.4	19.4	20.3	21.3
21	2.8	5.0	6.9	8.6	10.2	11.6	12.9	14.2	15.3	16.4	17.4	18.4	19.3	20.2
20	1.9	4.1	6.0	7.7	9.3	10.7	12.0	13.2	14.4	15.4	16.4	17.4	18.3	19.2
19	1.0	3.2	5.1	6.8	8.3	9.8	11.1	12.3	13.4	14.5	15.5	16.4	17.3	18.2
18	0.2	2.3	4.2	5.9	7.4	8.8	10.1	11.3	12.5	13.5	14.5	15.4	16.3	17.2
17	-0.6	1.4	3.3	5.0	6.5	7.9	9.2	10.4	11.5	12.5	13.5	14.5	15.3	16.2
16	-1.4	0.5	2.4	4.1	5.6	7.0	8.2	9.4	10.5	11.6	12.6	13.5	14.4	15.2
15	-2.2	-0.3	1.5	3.2	4.7	6.1	7.3	8.5	9.6	10.6	11.6	12.5	13.4	14.2
14	-2.9	-1.0	0.6	2.3	3.7	5.1	6.4	7.5	8.6	9.8	10.6	11.5	12.4	13.2
13	-3.7	-1.9	-0.1	1.3	2.8	4.2	5.5	6.6	7.7	8.7	9.6	10.5	11.4	12.2
12	-4.5	-2.6	-1.0	0.4	1.9	3.2	4.5	5.7	6.7	7.7	8.7	9.6	10.4	11.2
11	-5.2	-3.4	-1.8	-0.4	1.0	2.3	3.5	4.7	5.8	6.7	7.7	8.6	9.4	10.2
10	-6.0	-4.2	-2.6	-1.2	0.1	1.4	2.6	3.7	4.8	5.8	6.7	7.6	8.4	9.2

[1]) Approximations may be interpolated linearly.

Tools and cleaning:

- Suitable mixing equipment (e.g. Beba Positive Mixer)
- Adhesive spreader (Art. No. 4232) with appropriate toothed blade (depending on substrate)
- Suitable tooth squeegee
- Nail shoes (Art. No. 4010)
- Spiked roller with metal bow (25 cm = Art. No. 4009, 50 cm = Art. No. 5038 and bow = Art. No. 5039)

Clean tools, equipment and any spilled material immediately while fresh with V 101. Wear protective gloves.

Packaging, application rate and storing:

Packaging: 10 kg and 20 kg tin cans

Application rate:
1.5 kg/m² pure material
at least 2.0 kg/m² as a priming filler with Acolan SelectMix and 1.0 kg/m² Acolan SelectMix 05 or 1.6 kg/m² Acolan SelectMix 08
The amount required depends on the substrate and building site conditions and should be determined on a sufficiently large trial surface.

Shelf-life:
At least 6 months in original, unopened and unmixed containers stored cool but frost free.

Safety, ecology, disposal:

Further information concerning safety during transport, storage and handling as well as for disposal is found in the latest Safety Data Sheet.

GISCODE: RE 1

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