

M-CRETE 600 – CONCRETE EXPANSION JOINT FILLER

M-CRETE 600 – Concrete Expansion Joint Filler

This is a pouring grade, two-part, pitch free polyurethane sealant for internal and external expansion joint sealing. M-CRETE can be used for construction joints in concrete paved areas, docks, container depots, industrial factories, and warehousing.

The product has very high adhesion to most materials when used with a suitable epoxy primer.

M-CRETE 600 – Concrete Expansion Joint Filler is cold applied and is therefore economic to use on small run jobs such as remedial re-sealing of joints in busy areas such as loading yards and hardstanding's.

Typical Uses

- Used for Sealing Construction & Expansion Joints in Concrete

Application Guide

Surface Preparation

- All joints should be completely dry and free from all traces of dirt, dust grease and any previous sealants and other foreign matter.
- Cleaning may be carried out by grit blasting, grinding, sawing or water jetting.
- Wire brush must only be used for the removal of filler boards.
- In all cases a clean bonding surface must be obtained.
- Joint sides must be parallel and straight. Spalled joints should be prepared with an appropriate repair mortar such as [M-CRETE 200 – Heavy Duty Epoxy Screed](#)

Priming

- Once all preparation work is complete, place into the joint a bond breaker or foam backing rod to form the correct cross section for the joint sealant. And to ensure M-CRETE 600 – Concrete Expansion Joint Filler does not bond to the base of the expansion joint.
- All joint faces should be primed with the [M-CRETE 600P – Surface Primer](#), care being taken to ensure complete coverage.

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- After priming allow half an hour for the solvent to evaporate. If application of M-CRETE 600 is delayed for more than 2 hours after priming, joints should be re-primed.
- Optimum performance will be achieved by sealing joints that are dry.

APG-REV2- 2022

Environmental Checks

Prior to mixing, please ensure the following:

- The base component is at a temperature between 15-25°C.
- Do not apply the material when the ambient or substrate temperature is below 4°C or less than 3°C above dew point.

Mixing

- Mix both Part-A and part-B together in full units as supplied. For small quantities use a mixing ratio of **3.5:1 by volume or 4.5:1 by weight**
- Stir the contents of Pack B and add the entire contents to Pack A and stir for a full five minutes, preferably using a slow speed electric drill (max 500 r.p.m.) with a mixer paddle, until a completely homogeneous mix is obtained.
- Take care to avoid including excess air.
- Mixing is made easier if the Pack B is added and mixed in two stages

Use all mixed material within 25 – 35 minutes at 20°C.

Product Application

- Pour or gun apply immediately into the primed joint.
- Current practice requires that the sealant shall be poured to a level between 3mm (Summer) and 6mm (Winter) below the wearing concrete surface.

Technical Information

Appearance	Base Activator	Black/grey liquid Amber liquid
Mixing Ratio	By weight: By volume:	4.5:1 3.5:1
Density	Base Activator Mixed	1.35 1.05 1.28
Solids Content		100%

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Usable Life	10°C	90 minutes
	20°C	45 minutes
	30°C	22 minutes
Coverage per 4.5ltr	Joint depth x width x mm	Liner metres
	10 x 10	45.0
	10 x 15	30.15
	10 x 20	22.5
	10 x 25	18.0
	10 x 30	14.98
	15 x 15	20.02
	15 x 20	14.98
	15 x 25	12.01
	15 x 30	10.03
	20 x 20	11.25
	20 x 25	9.0
	20 x 30	7.65
	25 x 25	7.2
25 x 30	5.98	
Cure Times at 20°C	Foot Traffic	24 hours
	Vehicles	36 hours
Storage Life	Unopened and stored in dry conditions (15-30°C)	18 Months
Movement	Movement Accommodation Factor	+/- 25%
Adhesion	Tested to BS 5212	100% at 20°C
Resilience	Tested to BS 5212 95%	95%
Hardness	Tested to ASTM D2240	Shore A 25
Chemical Resistance	The product resists attack by a wide variety of low concentration industrial chemicals:	

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Legal Notice

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It is the responsibility of the customer to determine the products suitability for use.

Maxkote accepts no liability arising out of the use of this information or the product described herein.

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