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PRODUCT DATA SHEET
PAVEMENT JOINT ADHESIVE

PART NO. 34524

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READ BEFORE USING THIS PRODUCT

GENERAL Crafco Pavement Joint Adhesive is a hot-applied modified asphalt composition used to adhere and tack longitudinal cold construction joints in asphalt concrete pavements. Pavement Joint Adhesive increases durability and life of joints through improved bonding and sealing. Long term research in several studies has proven that Crafco Pavement Joint Adhesive provides the best joint performance of all methods available.

Asphalt concrete is usually less dense at longitudinal construction joints due to unconfined compaction at the edge of the first pass. The adjoining mat is usually denser at the joint due to the lateral confinement provided by the first pass. The result is a joint containing the wedge shaped area of the first mat which is lower density.. This area is weaker under traffic, and permits intrusion of water and air which causes premature deterioration of the asphalt concrete at the joint, many times within 2 or 3 years. Various methods of constructing joints with improved performance have been studied and are used. These methods include using hot joints from side-by-side paving, cutting the edge of the first pass and removing the low density material, and use of rolled low slope wedge joints. These methods are time consuming, costly, and have not performed as well as Crafco Pavement Joint Adhesive.

Crafco Pavement Joint Adhesive is applied in approximately a 1/8 inch (3mm) thick band over the edge of the first paving pass prior to placing the adjoining mat. This application waterproofs the underlying area of low density asphalt concrete and provides adhesive bonding between the adjoining mats. Moisture and air intrusion into the lower density asphalt concrete are reduced and mixture durability at the joint is increased.

Crafco Pavement Joint Adhesive is a solid material which is simply removed from its container, heated to application temperature, and applied to the joint face prior to construction of the adjacent asphalt concrete mat. When the adjacent lane is placed and compacted, the heat from the asphalt concrete and the roller pressure causes the joint adhesive to adhere strongly along the joint face resulting in strong bonding between overlay passes and waterproofing of the joint. Use of Crafco Pavement Joint Adhesive also creates a joint with improved resistance to thermal expansion and contraction.

Crafco Pavement Joint Adhesive can also be used for waterproofing exposed edges of asphalt pavements such as at curb and gutter or shoulder interfaces. Additionally, waterproofing can be assured where manhole covers and hand valves (gas, water, etc.) are installed in asphalt concrete pavement. The physical characteristics of Crafco Pavement Joint Adhesive have been designed to produce a material which has appropriate application consistency, adhesion, flow, bleeding resistance, and flexibility for use at construction joint faces.

Crafco Pavement Joint Adhesive has been a quality Crafco product for over 15 years, and has achieved the Crafco **CERTIFIED PERFORMANCE** designation due to its excellent, documented performance. Several states have adopted the joint adhesive method due to the excellent and consistent performance that has been provided by Crafco Pavement Joint Adhesive. VOC = 0 g/l.

SPECIFICATION CONFORMANCE Recommended specification limits for Pavement Joint Adhesive are:

<u>Test</u>	<u>Specification Limits</u>
Brookfield Viscosity, 400°F (204°C) (ASTM D2669)	4,000 - 10,000 cp
Cone Penetration, 77°F (25°C) (ASTM D 5329)	60-100
Flow, 140°F (60°C) (ASTM D 5329)	5 mm maximum
Resilience, 77°F (25°C) (ASTM D 5329)	30% minimum
Ductility, 77°F (25°C) (ASTM D 113)	30 cm minimum
Ductility, 39.2°F (4°C) (ASTM D 113)	30 cm minimum
Tensile Adhesion, 77°F (25°C) (ASTM D 5329)	500% minimum
Flexibility, 0°F (-18°C) (ASTM D3111 modified)	Pass
Softening Point (ASTM D 36)	170°F (77°C) minimum
Asphalt Compatibility (ASTM D 5329)	Pass
Minimum Application Temperature	380°F (193°C)
Maximum Heating Temperature	400°F (204°C)

Additional properties of Crafco Pavement Joint Adhesive are:

<u>Property</u>	<u>Typical Result</u>
Unit weight at 60°F (15.5°C)	9.3 pounds per gallon
Coverage on 2" overlay	3 – 4 feet per pound



*For details go to Crafco.com

INSTALLATION Prior to use, the user must read and follow Installation Instructions for Pavement Joint Adhesive to verify proper product selection, heating methods, application geometry and safety precautions. These instructions are provided on each pallet of adhesive.

PACKAGING Packaging consists of individual boxes of adhesive which are palletized into shipping units. Boxes contain a nonadherent film, which permits easy removal of the adhesive. Each pallet contains 72 boxes which are stacked in six layers of 12 boxes per layer. The weight of adhesive in each box does not exceed 40 lbs. (18kg) and pallet weights do not exceed 2,880 lbs. (1310 kg). Pallets are weighed and product is sold by the net weight. Boxes are manufactured from double wall kraft board producing a minimum bursting test certification of 350 psi (241 N/cm²) and using water resistant adhesives. Boxes use tape closure and do not contain any staples. Boxes are labeled with the product name, part number, lot number, specification conformance, application temperatures and safety instructions. Palletized units are protected from the weather using a three mil thick plastic bag, a weather and moisture resistant cap sheet and a minimum of two layers of six month u.v. protected stretch wrap. Pallets are labeled with the product part number, lot number and net weight. Installation Instructions are provided with each pallet in a weather resistant enclosure.

WARRANTY CRAFCO, Inc. warrants that CRAFCO products meet applicable ASTM, AASHTO, Federal or State specifications at time of shipment. Techniques used for the preparation of the cracks and joints prior to sealing or filling are beyond our control as are the use and application of the products; therefore, Crafco shall not be responsible for improperly applied or misused products. Remedies against Crafco, Inc., as agreed to by Crafco, are limited to replacing nonconforming product or refund (full or partial) of purchase price from Crafco, Inc. All claims for breach of this warranty must be made within three (3) months of the date of use or twelve (12) months from the date of delivery by Crafco, Inc. whichever is earlier. There shall be no other warranties expressed or implied. **For optimum performance, follow Crafco recommendations for product installation.**