



american coating technologies
www.amcoating.com

AM 254 Novolac (Semi Clear) Crack Filler

Product Description

AM 254 is a two component 100% solids novolac crack filler (gel) designed for shallow repairs on either vertical or horizontal surfaces. Because AM254 is a 100% solids formulation, it can be applied thicker on horizontal surfaces when required.

Solids By Weight:

100%

Solids By Volume:

100%

Volatile Organic Content:

Zero pounds per gallon

Colors Available:

Amber clear (when mixed)

Recommended Film Thickness:

1/8" cracks or thin build repairs

Coverage Per Gallon:

0.20 cubic feet or 1,842 lineal feet 1/8" x 1/8" for the 1 1/2 gallon kit.

Mix Ratio:

2 parts A to 1 part B by volume

Packaging

Cubic Feet

254/kit (1 1/2 gallon)	.20 (approx)
254/kit (15 gallon)	1.0 (approx)
1 1/2 gallon kit= 9.25# part A per gallon and 4.5# part B per half gallon (volumes approximate)	

Shelf Life:

1 year in unopened containers

Heat Deflection Temp.:

45 degrees C (125.6 degrees F)

Flexural Strength:

8,000 psi @ ASTM D790

Compressive Strength:

10,000 psi @ ASTM D695- 1/2" x 1/2" bars

Tensile Strength:

5,800 psi @ ASTM D638

Ultimate Elongation:

3.4%

Gardner Variable Impactor:

50 inch pounds direct – passed

Abrasion Resistance:

Taber abraser CS-17 calibrase wheel with 1000 gram total load and 500 cycles= 38 mg loss

Adhesion:

430 psi @ elcometer (concrete failure, no delamination)

Hardness:

Shore D= 60

Viscosity:

Mixed= 3,000,000-4,000,000 cps (typical)

Dot Classification:

Part A "not regulated"
Part B "CORROSIVE LIQUID N.O.S, 8, UN1760, PGIII"

Cure Schedule: (70° F)

Pot life (1 1/2 gallon volume)	1-2 hours
tack free (dry to touch)	7-11 hours
Recoat or topcoat	8-12 hours
Light foot traffic	12-18 hours
Full cure (heavy traffic)	2-7 days

Application Temperature:

60-90 degrees F.

Chemical Resistance:

Reagent	Rating
Butanol	D
Xylene	D
1,1,1 trichloroethane	C
MEK	A
Methanol	B
Ethyl alcohol	C
Skydrol	C
10% sodium hydroxide	E
50% sodium hydroxide	E
10% sulfuric acid	D

Recommended For

Recommended for repairing cracks and defects in concrete or masonry

70% sulfuric acid	A
10% HC1 (aq)	D
5% acetic acid	D

Rating key: A - not recommended, B - 2 hour term splash spill, C - 8 hour term splash spill, D - 72 hour immersion, E - long term immersion. NOTE: extensive chemical resistance information is available through your sales representative.

Primer:

None necessary

Topcoat:

Optional: This product can be over coated with many suitable epoxy and urethane products.

Limitations:

Color clarity may be affected by environmental conditions such as high humidity, chemical exposure or exposure to lighting such as sodium vapor lights.

Colors may vary from batch to batch.

This product is not UV color stable and may discolor when exposed.

Substrate temperature must be 5°F above dew point.

All new concrete must be cured for at least 30 days prior to application.

Allow the novolac crack filler to become tack free prior to topcoating.

Physical properties are typical values and not specifications.

See reverse side for application instructions.

See reverse side for limitations of our liability and warranty.

AM 254 Instructions:

- 1) PRODUCT STORAGE:** Store product at normal room temperature before using. Continuous storage should be between 60 and 90 degrees F. Low temperatures or temperature fluctuations may cause crystallization.
- 2) SURFACE PREPARATION:** All dirt, foreign contaminants, oil, and laitance must be removed to assure a trouble free bond to the substrate. A test should be made to determine that the concrete is dry; this can be done by placing a 4'x4' plastic sheet on the substrate and taping down the edges. If after 24 hours, the substrate is still dry below the plastic sheet, then the substrate is dry enough to start repair work. This product is intended for hairline cracks and other fractures up to an 1/8 inch in width. Remove all unsound concrete from within the crack to be repaired and thoroughly vacuum all debris and dust from within the crack opening.
- 3) PRODUCT MIXING:** This product has a mix ratio of 9.25# part A to 4.5# part B by weight and 2:1 by volume. To mix, simply measure out two parts by volume for part A with one part by volume for the part B. Mix the two components together thoroughly with slow speed mixing equipment such as a jiffy mixer, putty knife or spatula until the material is thoroughly mixed and uniform in color. Mix only an amount of material that can be used in the allotted pot life period. Improper mixing may result in product failure.
- 4) PRIMING:** No priming is necessary.
- 5) PRODUCT APPLICATION:** The mixed material can be applied by marginal trowel, putty knife or any other suitable equipment. Make sure that all unsound concrete is removed prior to repairing the area.
- 6) RECOAT OR TOPCOATING:** Allow the crack filler to cure (tack free) prior to coating over the applied material. If excessive amounts are spread well beyond the crack repair or in areas where surface repairs have been implemented, it is best to check the cured areas for any possible amine blush (a whitish, greasy film, or deglossing) prior to coating over this material. If a blush is present, it can be removed by any standard type detergent cleaner prior to topcoating or recoating. Many epoxy coatings and urethanes are compatible for use over this product as well as multiple coats of this product.
- 7) CLEANUP:** Use xylol
- 8) FLOOR CLEANING:** Caution! Some cleaners may affect the color of the fast set gel installed. Test each cleaner in a small area, utilizing your cleaning technique. If no ill effects are noted, you can continue to clean with the product and process tested.
- 9) RESTRICTIONS:** Restrict the use of the floor to light traffic and non-harsh chemicals until the coating is fully cured (see technical data under full cure). It is best to let the floor remain dry for the full cure cycle.

NOTICE TO BUYER: DISCLAIMER OF WARRANTIES AND LIMITATIONS ON OUR LIABILITY

We warrant that our products are manufactured to strict quality assurance specifications and that the information supplied by us is accurate to the best of our knowledge. Such information supplied about our products is not a representation or a warranty. It is supplied on the condition that you shall make your own tests to determine the suitability of our product for your particular purpose. Listed physical properties are typical and should not be construed as specifications.

NO WARRANTY IS MADE, EXPRESSED OR IMPLIED, REGARDING SUCH OTHER INFORMATION, THE DATA ON WHICH IT IS BASED, OR THE RESULTS YOU WILL OBTAIN FROM ITS USE. NO WARRANTY IS MADE, EXPRESSED OR IMPLIED, THAT OUR PRODUCT SHALL BE MERCHANTABILITY OR THAT OUR PRODUCT SHALL BE FIT FOR ANY PARTICULAR PURPOSE. NO WARRANTY IS MADE THAT THE USE OF SUCH INFORMATION OR OUR PRODUCT WILL NOT INFRINGE UPON ANY PATENT. We shall have no liability for incidental or consequential damages, direct or indirect. Our liability is limited to the net selling price of our product or the replacement of our product, at our option. Acceptance of delivery of our product means that you have accepted the terms of this warranty whether or not purchase orders or other documents state terms that vary from this warranty. No representative is authorized to make any representation or warranty or assume any other liability on our behalf with any sale of our products. Our products contain chemicals that may **CAUSE SERIOUS PHYSICAL INJURY. BEFORE USING, READ THE MATERIAL SAFETY DATA SHEET AND FOLLOW ALL PRECAUTIONS TO PREVENT BODILY HARM.**