



MATERIAL PROCESSING & HANDLING INFORMATION
BD Joint Adhesive

Material: BD Joint Adhesive
Material Type: Fast Set Elastomeric Coating
Application: Concrete or Metal Substrates
Application Process: High Pressure Heated Equipment with Impingement Gun

Process Equipment:	Pumps	Dispensing Gun
Graco:	EXP-2 (Electric) EXP-3 (Pneumatic) H-XP2 (Hydraulic) H-XP3 (Hydraulic)	Fusion AP (Air Purge) Fusion MP (Mechanical Purge) GX-7 Standard (Mechanical Purge) GX-8 (Mechanical Purge) Probler (Air Purge) Probler P2 (Air Purge)
Gusmer:	FF 2500 (Hydraulic) FF 3500 (Hydraulic) H-20/35 (Pro Hydraulic)	GX-7 Standard (Mechanical Purge) GX-7 400 (Mechanical Purge) GX-7 DI (Mechanical Purge) GX-8 (Mechanical Purge) Gap Pro (Air Purge)
GlasCraft:	MX, MXII (Pneumatic) MH, MHII, MHIII (Hydraulic) SuperMaxi, Guardian A Series	Probler (Air Purge) Probler P2 (Air Purge)
Gama:	Evolution G-250H	GDI (Mechanical)
PMC:	PMC GH-40 (Hydraulic)	PMC A-P2 (Air Purge)
Pentech USA:		PalmGun or MG Gun (low output)
WIWA:	DuoMix 460 (Pneumatic)	Pentech MG (Mechanical)
Material Supply Pumps	Pump Type	Continuous delivery/output at 70°F/25°C
Graco:	Standard 2:1 (T1)	Up to 1.75 gpm, 9.5 lpm
	Husky 515	Up to 5 gpm, 26 lpm
	Husky 716	Up to 11 gpm, 61 lpm
IPM/Gusmer:	2:1 (T2)	Up to 3.85 gpm, 21 lpm
IR/ARO	2:1 (for fluids <1,000 cps)	Up to 1.4 gpm, 7.6 lpm

Process Temperature:	160°F optimum, 170°F maximum
Process Pressure:	2,000-2,500 psi optimum, 3,500 psi maximum
Open to Traffic:	60 minutes after installation
Moisture Content in Concrete:	5% maximum when measured with Tramex-style moisture meter
Application Temperature:	Greater than -20°F <i>Note: If installing on concrete substrates when air and/or substrate temperature is less than or equal to 32°F, perform additional testing as outlined in the Bridge Preservation Testing Concrete Moisture Content – Cold Temperature Applications document. It is recommended that material and equipment ambient temperatures be kept at 60°F or above during application.</i>

Dew Point:	Substrate temperature must be 5°F above dew point and rising prior to application of coating materials.
Concrete Surface Preparation:	SSPC-SP13/NACE No. 6.
Metal Surface Preparation:	SSPC-SP10/NACE No. 2 with angular 3-5 mil profile.
Concrete Primer Requirements:	BD Concrete Primer (approx. 10 mils) BD Multi-Use Primer FAST or SLOW (approx. 10 mils)
Metal Primer Requirements	BD Multi-Use Primer FAST or SLOW (approx. 5 mils) BD Metal Primer (approx. 5 mils) BD Zinc Rich Primer (approx. 5 mils) <i>Note: On metal surfaces with proper surface preparation, primer is not required to achieve proper adhesion. Primer may be used to protect prepared surfaces from the formation of "flash rust".</i>

	Storage Temp	Storage	Special Handling
A-Side:	55°F minimum 70°F optimum 95°F maximum	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Use dry air desiccant for intake vent on drum.
B-Side:	55°F minimum 70°F optimum 95°F maximum	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Mix well with mixer to re-disperse any settled pigment.

Safety:	Please consult product SDS for full details. Safety glasses, rubber gloves, protective clothing, organic vapor or fresh air respirator.
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