

14415 S 50th St, Suite #100, Phoenix, AZ 85044-6460
 +1 (602) 276-0406 • +1 (800) 528-8242 • FAX +1 (480) 961-0513

www.crafco.com

READ BEFORE USING THIS PRODUCT

GENERAL Crafcro 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 Crafcro 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 Crafcro Pavement Joint Adhesive.

Crafcro 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. Crafcro Pavement Joint Adhesive is supplied as a solid material which is placed in an appropriate melter, 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 Crafcro Pavement Joint Adhesive also creates a joint with improved resistance to thermal expansion and contraction.

Crafcro 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 Crafcro 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.

Crafcro Pavement Joint Adhesive has been a quality Crafcro product for over 25 years. Several states have adopted the joint adhesive method due to the excellent and consistent performance that has been provided by Crafcro Pavement Joint Adhesive. VOC = 0 g/l.

SPECIFICATION CONFORMANCE

Recommended specification limits for Pavement Joint Adhesive when sampled and heated according to ASTM D5167 are:

Test	Specification Limits
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, 1" Specimen, 24 hour dry blocks (ASTM D 5329)	500% minimum
Flexibility, 1/8" (3.2 mm) specimen, 90° bend, 10 sec, 1" (25 mm) mandrel (ASTM D3111 modified)	Pass at 0°F (-18°C)
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 Crafcro Pavement Joint Adhesive when sampled and heated according to ASTM D5167 are:

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

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

Product is supplied in either cardboard boxes, or in meltable, boxless PLEXI-melt packaging. Both package types are labeled in accordance with OSHA, GHS, and specification requirements; are sold by net weight; are interlock stacked on 48 x 40 in. (122 x102 cm) 4-way pallets; can be stored outside; and are covered with a weather resistant pallet cover and 2 layers of UV protected stretch wrap.

- o **BOX** packaging consists of cardboard boxes containing approximately 30 lb. (13.6 kg) of product with 75 boxes per pallet, weighing approximately 2250 lb. (1020 kg). Boxes contain a quick melting release film for easy removal and are taped closed, without any staples.
- o **PLEXI-melt** packaging consists of 30 lb. (13.6 kg) blocks of product with 70 packages per pallet, weighing 2100 lb. (952 kg). To use, the pallet wrap is removed, and individual blocks are placed in the melter. There are no cardboard boxes or other cardboard components to open, empty, handle, or dispose of. PLEXI-melt packaging quickly melts into the product without affecting specification conformance.

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, Crafcro shall not be responsible for improperly applied or misused products. Remedies against Crafcro, Inc., as agreed to by Crafcro, are limited to replacing nonconforming product or refund (full or partial) of purchase price from Crafcro, 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 Crafcro, Inc. whichever is earlier. There shall be no other warranties expressed or implied. **For optimum performance, follow Crafcro recommendations for product installation.**