

DURA-FILL® PF4

Polymer Modified Polyester Fiber Sealant

Description: Dura-Fill PF4 is a premium quality crack and joint sealant. It is a blend of polymer modified crack sealant and polyester fibers. It is a hot applied, one part material that eliminates the problems associated with field blending. With its improved elasticity, adhesion, and low temperature flexibility, Dura-Fill PF4 is well suited for moderate to cold climates.

Recommended Uses: Dura-Fill PF4 is recommended for sealing cracks and joints in portland cement and asphaltic pavements. It is designed to seal expansion / contraction joints, longitudinal and transverse cracks, and random cracks.

Surface Preparation: Proper surface preparation facilitates adhesion and consequently the maximum service life of the sealant. In order for proper adhesion, the crack/joint must be free of moisture, dust, loose aggregate, and other contaminants. The substrate and air temperatures must be 40° F or above. Sawing, routing, and/or sandblasting are the preferred methods of preparation. Use oil-free compressed air and heat to clean and dry the crack/joint immediately prior to sealing. Cracks/joints should be sized so that the maximum extension and compression do not exceed 50% of the width. Best results are obtained when the cracks/joints are opened at least ½ inch wide.

Melting and Application: Melt Dura-Fill PF4 using a conventional **oil jacketed kettle** equipped with agitator and temperature control devices for both the material and heat transfer oil. Carefully insert small quantities of Dura-Fill and the plastic bag into the melting equipment while the agitator is turned off. Load material slowly to avoid splash back. After the initial load has reached the recommended pour temperature, fresh material may be added to the melter. Melt only the material that will be used during that day. Purge material remaining in the kettle lines at the end of each sealing operation. The material must be applied using a pressure feed wand system.

Note: The temperature of the heat transfer oil should not exceed 525° F. Do not heat Dura-Fill above the maximum heating temperature and do not maintain it at that temperature for prolonged periods of time. This could cause the material to gel in the equipment or fail in the joints. A significant viscosity increase accompanied by stringiness signals the approach of gelation. If this occurs, immediately remove the material from the melter and dispose of it.

For further details read and follow the Dura-Fill MSDS, Installation Instructions for Oil Jacketed Dura-Fill Products, and P&T Products' Warranty.

Product Specifications

when tested in accordance with ASTM D 5329, 36, modified 3111, & 4402.

	Dura-Fill PF4	Modified Binder
Heating Temp	410 F Max.	410 F Max.
Application Temp	370-390 F	370-390 F
Heating Time	12 Hours Max.	12 Hours Max.
Penetration @ 77 F	25-45 dmm	90 dmm Max.
Flow @ 140 F	0 mm Max.	5 mm Max.
Bond: 0 F / 100 % Extension	NA	5 Cycles Passed
Softening Point	190 F Min.	176 F Min.
Low Temperature Flexibility	- 20 F Pass	NA
Viscosity @ 375 F	100+ Poise	20 Poise Max.
Ductility @ 77 F	NA	40 cm Min.
Specific Gravity	1.21 Approximately	NA
Polyester Fiber Content	2% Min.	NA
Asphalt Compatibility	Pass	Pass
Flash Point	400 F Min.	400 F Min.
Optimum Climate (Average Temperatures)	-29 / 32 C Or -20 / 90 F	

- ◆ **Economical**
- ◆ **Excellent Adhesion**
- ◆ **Not Self Leveling**

Coverage

Width	Depth	Pounds/100
3/8"	3/8"	7.4
3/8"	1/2"	9.8
1/2"	1/2"	13.1
1/2"	1"	26.2
3/4"	1/2"	19.7
3/4"	3/4"	29.5

Specifications

P & T Products' Specifications
Ohio DOT, Type IV

Packaging

Dura-Fill is packaged in 2-25 lb. poly-bags in a 50 lb. high strength corrugated box. Each pallet contains 48 boxes or 2,400 pounds of Dura-Fill.

Fiber Properties

Type	Polyester
Denier	3-6
Length	0.25" ± 0.02"
Specific Gravity	1.32-1.40
Melting Temp.	480 F
Tensile Strength	70,000 psi Min.
Elongation at Break	33% ± 9%

P&T Products, Inc.

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