



# Silicoflex Preformed Silicone Joint Sealing System

## Data Sheet

### Description

The work shall consist of furnishing and placing the Silicoflex Preformed Silicone Joint Sealing System as detailed and as shown on the plans.

All necessary components, materials and equipment required for the installation shall be obtained through an approved supplier. Components of the joint system shall come from the same manufacturer and may not be substituted for others.

The approved supplier shall furnish a qualified, experienced technical representative to advise the engineer and contractor concerning proper installation procedures.

### Definitions

The following definitions shall apply:

**Joint Seal** - The Silicoflex preformed silicone joint seal.

**Locking Adhesive** - A non-sag, one-part, medium-modulus, moisture curing silicone adhesive.

**Primer** - A two-part component to enhance adhesion of joint seal to concrete and steel surface

### Materials

Silicoflex Joint Seal - The material shall be made of silicone, pre-formed by extrusion, and shall meet or exceed the following physical requirements.

Test Property	Value	Test Procedure
Durometer (Shore A)	55 ± 5	ASTM D2240
Tensile (PSI)	1,000 min. (6.89 MPa)	ASTM D412
Elongation (%)	400% min.	ASTM D412
Tear (die B ppi)	100 min. (17 kN/m)	ASTM D624
Compression Set (212°F, 70hrs)	30% max.	ASTM D395
Durometer	5 max. points loss	
Tensile Strength, max, % loss	10 max. % loss	
Elongation, max, % loss	10 max. % loss	





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### Silicoflex Locking Adhesive

Silicoflex Locking Adhesive – The material shall consist of a non-sag, one-part, medium-modulus, moisture curing silicone adhesive that cures quickly. It shall adhere to concrete, elastomeric concrete, polymer concrete, steel and Joint Seal and shall meet the following physical requirements.

Test Property	Value	Test Procedure
Tensile Strength (PSI)	225	ASTM D412
Elongation (%)	550	ASTM D412
Tack Free Time (minutes)	5-20	ASTM C679
Cure Time (1/4" bead) (hours)	<24	ASTM C679
Color	Charcoal	
VOC (g/L)	50	ASTM D3960
Hardness Shore A	27	ASTM D661
Modulus, 100% Elongation (PSI)	55	ASTM D412
Dynamic Joint Movement (%)	±50	ASTM C719
Resistance to UV	No cracking, Ozone Chalking, or Degradation	ASTM C793

### Primer P-200

The material shall consist of two components, part A and part B (1:1) ratio thoroughly mixed together to be effective. Neither component is a primer by itself.

Test Property	Value	Test Procedure
Viscosity (centipoises)	44	ASTM D2196
Color	Light Amber	
Specific Gravity	0.92	ASTM D1217
Flash Point (°F, T.C.C.)	48	ASTM D56
Solids (%)	41	ASTM D4209
Cleaning	Mineral Spirits	
VOC (g/L)	520*	ASTM D3960

Not for use on non-porous surfaces in areas requiring VOC levels less than those listed. Always consult local VOC regulations before use.





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### Cyclic Loading Test

The Joint Seal shall be pre-qualified by undergoing and passing a Cyclic Loading Test. The device shall be a joint testing machine that is owned and operated by a State DOT and has been used for similar tests in the past. It shall allow a 2-foot sample of the joint seal to be fully installed with adhesive on a steel or concrete surface, simulating a bridge joint. It shall be installed at the median opening which is halfway between the claimed minimum and maximum opening. The minimum and maximum opening shall be at least 50% lower than the median and 50% higher than the median, respectively. The device shall be hydraulically powered with an actuator which cycles the joint seal to minimum and maximum opening at a 45° skew angle. After completing and passing the test at room temperature, the same sample shall be stored at -20°F for 24 hours. It shall be removed and within 60 minutes subjected to an additional 200 cycles at a 45° skew angle.

Test Properties	Value
Test Sample Length	2 Feet Minimum
Joint Skew	45°
Number of Cycles	200 Minimum
Joint Opening	Median Opening
Minimum Opening	Min. 50% lower than Median Opening
Maximum Opening	Min. 50% higher than Median Opening
Movement	Min. to Max. Opening
Temperature	Room Temperature (60-70°F) and -20°F

Any rips, tears, or bond failure will be cause for rejection. Manufacturer must provide documentation signed by 3rd party to verify testing.

### Previous Experience

Manufacturer must provide documentation of at least 5 years experience with preformed silicone joint seals and at least 10 installations.





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### **Basis of Acceptance**

**Joint Seal** - Acceptance shall be by manufacturer certifications.

**Cyclic Loading Test** - Must have document signed by 3rd party to verify testing.

**Previous Experience** - Must provide project names, bridge owner/authority, contractor/installer name, contact and phone number of contractor/installer.

### **Construction Details**

Do not start installing the Joint Seal on the project until a trained factory representative is on the job site to provide direction and assistance throughout the installation work. Notify the Joint Seal manufacturer of the scheduled installation a minimum of 2 weeks in advance. The factory representative must be present for the installation of the first Joint Seal and succeeding Joint Seals until the Contractor becomes proficient in the work.

The minimum temperature in which you can install the Joint Seal is 40° F and rising ambient air temperature. The joint surface must be completely dry before installing the Joint Seal. The Joint Seal cannot be installed immediately after precipitation or if precipitation is forecasted for the day. Joint preparation and installation of Joint Seal must be done during the same day. Traffic must not be allowed to pass over a joint after sandblasting has occurred.

For new primed steel joint installations, wipe vertical faces of joint clean with a rag saturated in denatured alcohol - no sandblasting is necessary.

For Galvanized steel joint installations, do not sandblast. Using a clean rag saturated in denatured alcohol, wipe down both sides of the vertical face of the open joint to properly clean the bonding surface. This should be done two times to make sure that the galvanized surface is clear of any white rust.

For new concrete joint installations, roughen concrete surface and wipe vertical faces of joint clean with a rag saturated in denatured alcohol. Roughening can be done by sandblasting, wire brushing, or other mechanical methods approved by R.J. Watson.

For joint seal replacements to existing joints, sandblast the vertical faces of the joint and wipe clean with a rag saturated in denatured alcohol. Using oil and water-free compressed air, blow joint area clean to remove all debris. Wipe clean armor plate with a cloth saturated in De-Natured Alcohol. Mix A and B components of Primer and then apply to the vertical joint interfaces. Allow primer 30 minutes





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to dry. Unroll joint seal and place adjacent to joint opening. Clean the seal with a cloth saturated with De-Natured Alcohol, focusing on each side of the seal (top and bottom) where the adhesive will be bonded. Joint preparation, priming and installation of Joint Seal must all be done the same day. Traffic shall not be allowed to pass over a primed joint surface.

Using a standard caulking gun, a 3/8" diameter bead of Locking Adhesive shall be applied to both sides of the vertical face of the joint. This bead of adhesive shall be applied in accordance to chosen model (see installation instructions). Tool adhesive to ensure contact with header prior to inserting joint seal.

Insert the Joint Seal into the joint opening in an inverted "V" shape by folding it by hand. The Joint Seal shall be inserted above the 3/8" bead of locking adhesive. Gently push the Joint Seal downward while maintaining contact of the sides of the joint seal to the joint header. Position the Joint Seal to the proper depth which is when the top of the Joint Seal is between 1/2" and 1" below top of the road surface. Apply a second bead of locking adhesive along each side of the Joint Seal to the top of the serrations, and no higher. This second bead of adhesive should be in contact with the seal and the armor plate. The Locking Adhesive must be 'tooled' at least twice with a tongue depressor to ensure complete contact with the vertical edge. The second bead of adhesive should look smooth with no air voids or bubbles. In the event of a visible air void, more adhesive must be applied. Allow 60 minutes before allowing traffic over a newly installed Joint Seal, unless directed otherwise by an approved representative.

Vertical curbs, directional changes and field splices require the Locking Adhesive as a bonding agent.

## **Storage**

The Joint Seal, Adhesive and Primer must be stored indoors and kept away from moisture. Do not allow Adhesive or Primer to freeze.

## **Method of Measurement**

The work shall be measured as the total linear feet of Joint Seal incorporated into the completed work.

## **Basis of Payment**

The unit price bid per linear foot of Joint Seal shall include the cost of furnishing all labor, materials, and equipment necessary to complete the work in accordance with the Joint Seal manufacturer's recommendations.

