

## QUICKSET POLYSULPHIDE JOINT SEALANT

- High resin content for flexibility
- Non-sag and non-tacky cured surface
- Suitable under continual wet conditions
- Long life performance
- Quick setting time
- Tough elastic seal

**PRODUCT DESCRIPTION:**

Pro-Struct 744/749 is a two-component manganese dioxide cured polysulphide sealant designed to through cure to a tack-free surface, even under adverse climatic conditions.

**USES:**

- Sealing vertical and horizontal concrete joints
- Exterior exposure, UV resistant
- Sealing window and door frames
- Trafficable sealant
- Water retaining structures
- Cladding in high rise structures

**JOINT DESIGN:**

It is recommended that joints be designed so that the movement does not exceed 25% of the joint width. The joint configuration should be such that the ratio of joint width to depth be 2:1, except in the case of smaller joints where the minimum recommended depth of 10mm is applicable. It is advisable to ensure that joints are parallel sided as departure from this could impair the service life of the sealant. It is essential that a bond breaking backup cord be inserted into the joint to support the sealant and to control the depth.

**PACKAGING & COVERAGE:**

2 Litre kit; Part A + B

The following table gives guidelines on theoretical material estimates in linear metres/litre:

JOINT WIDTH	JOINT DEPTH			
	5mm	10mm	12mm	15mm
5mm	40m/l	-	-	-
10mm	-	10m/l	-	-
12mm	-	8.3m/l	-	-
15mm	-	6.7m/l	-	-
20mm	-	5m/l	-	-
25mm	-	-	3.3m/l	-
30mm	-	-	-	2.2m/l

**SHELF LIFE:**

12 Months in original, unopened package and if stored in dry conditions between 15°C to 35°C.

TYPICAL PROPERTIES AT 25°C	
Pot Life	30 to 60 minutes
Shore A, ASTM D2440	25 ± 10
Adhesion in Tension	142N
Adhesion after Water Immersion	130N
Adhesion in Peel	180N
Cure Time	
Initial Set	4 to 6 Hours
Light Traffic	16 to 24 Hours
Service Temperature	-30°C to +50°C
VOC Content	8g/litre

# APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

## PLACEMENT GUIDELINES

### SCOPE OF WORK (BOQ):

Prepare joints, ensuring clean and dry before applying Pro-Struct 744 Pour Grade or Pro-Struct 749 Gun Grade Joint Sealant, inclusive of primer.

### SURFACE PREPARATION:

All joints to be filled must be clean and dry. All oil, dirt, debris, paint and any other material that may be a bond breaker must be removed. The final step in cleaning must be the complete removal of all residue with a vacuum cleaner and oil-free compressed air. All joint facings must possess an open surface texture with all curing compounds and sealers removed. For proper installation, all edges must be squared off.

### PRIMING:

Tape edges of joints with masking tape to ensure a clean and tidy joint. Prime the face of the joint with Stonprime 639. Allow primer to dry before application of the sealant.

### JOINT BACKING:

To provide proper joint movement, the width/depth ratio should be 2:1 subject to a minimum depth of 10mm. Install a smooth-faced closed cell polyurethane foamed backer cord under 20 to 30% compression to correct depth.

### MIXING:

Pre-mix each component prior to mixing together for 4 to 5 minutes mechanically using an impeller fitted to a variable speed drill. Make sure the sides and bottom of the container are scraped to ensure thorough mixing. For Pro-Struct 749, fill caulking gun fitted with desired nozzle width.

### PLACEMENT:

Pour Pro-Struct 744 or gun Pro-Struct 749 in a bead to correct depth, ensuring full contact with joint faces. Remove masking tape at initial set time to leave a neat joint line. Tool level, ensuring no entrapped bubbles.

Clean equipment immediately after use with Pro-Struct 105 Brush Cleaner and rinse with clean water.

### PRECAUTION/LIMITATIONS:

- Based on ACI 302 recommendations, joint sealant should be applied as late as possible after construction to allow for minimal additional slab shrinkage. Consult ACI 302 comments regarding concrete shrinkage, joint filling and user expectations.
- Pro-Struct 749 and 744 and all application equipment should be kept at ambient temperatures of 15°C or above.
- Contact surfaces must be clean and dry for best adhesion.
- Joint edges must be thoroughly cleaned prior to filling, particularly if a floor sealer or densifier has been applied.
- Product may slightly discolour if constantly exposed to exterior UV radiation.
- In all cases, consult the Material Safety data Sheet before use.

**CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS.** KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NON-FERROUS TOOLS AND TO WEAR CONDUCTIVE AND NON-SPARKING SHOES.



**StonCor Africa (Pty) Ltd**  
Co. Reg. No. 1996/001848/07  
Tel: +27 (0) 11 254 5500  
Website: [www.stoncor.co.za](http://www.stoncor.co.za)  
E-mail: [stoncorsa@stoncor.com](mailto:stoncorsa@stoncor.com)