



# BAYCOFLEX-DD6030

(Former: INDUFLEX-TM-D)

## Polysulfide joint sealant – medium viscosity

### Description:

BAYCOFLEX-DD6030 is a polysulfide based, two component joint sealant with medium viscosity. Two types are available: Fluid and thixotropic.

### Areas of Application:

BAYCOFLEX-DD6030 is used in interior and exterior areas as a joint filler for the elastic sealing of floor and wall joints between foot and vehicular trafficked construction elements.

- In interior and exterior areas between foot and vehicular trafficked construction elements, e.g. industrial and commercial floors, road construction, car parks, airports etc.
- Suitable for horizontal joints and joints up to a 10% fall.
- For tramway track construction between the tracks and the adjoining flooring, amongst others granite pavers or cut / abraded asphalt. Suitable for joint widths up to 65 mm.

### Properties/Advantages:

- Medium viscosity
- Elastic
- Stable under compressive, tensile and shear loads
- Secure adhesive bond to concrete, cement-based screed, granite pavers, asphalt and steel
- Impermeable to liquids, under permanent deformation
- High resistance to chemicals
- Resistant to fuels (including aviation fuel and bio-diesel)
- Free from solvents
- Secure adhesive bond to cured polysulfide sealants

### Technical Data:

|                          |  |
|--------------------------|--|
| Basis:                   | polysulfide                              |
| Colour:                  | grey                                     |
| Mixed density:           | approx. 1,60 g/cm <sup>3</sup>           |
| Solids content:          | 100%                                     |
| Solvent:                 | None                                     |
| Application temperature: | +5°C to +35°C                            |
| Pot life:                | approx. 1,5-2,0 hours<br>at +23°C/75% RH |

|                              |  |
|------------------------------|--|
| Through cure time:           | approx. 24-48 hours at<br>+23°C/75% RH<br>(dependent on temperature)     |
| Shore-A hardness:            | approx. 25   |
| Permitted total deformation: | approx. 25% of the joint<br>width at a substrate<br>temperature of +10°C |
| Tensile modulus:             | approx. 0,24 N/mm <sup>2</sup>   |
| Elongation at break:         | approx. 400 %  |
| Breaking strain:             | approx. 0,5 N/mm <sup>2</sup>  |
| Modulus at 100% elongation:  | approx. 0,21 N/mm <sup>2</sup>   |
| Resilience:                  | approx. 90%  |
| Temperature resistance:      | from -40°C to +120°C   |
| Volume change:               | 0  |

### Packaging:

For vertical applications: 4,0 kg set  
For horizontal applications: 3,5 kg set

### Storage:

Cool and dry above +10°C, 12 months in the original unopened packaging.

### Substrate:

#### Cement-based surfaces:

- Concrete quality: min. C20/25
- Screed quality: min. EN 13813 CT-C25-F4
- Age: min. 7 days (or min. 70% of the 28 day final strength)
- Tensile adhesion strength: > 1,5 N/mm<sup>2</sup>

#### Natural stone pavers:

- Stone quality in accordance with TL Min-StB +  
DIN EN 1342

#### Poured mastic asphalt:

- O11S/PMB 45A
- Rolled asphalt

#### Steel:

- Blast cleaned track body
- Steel rails/profiles
- Steel channels

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# BAYCOFLEX-DD6030

## Substrate Preparation:

The contact surface to be treated must be:

- Dry, sound, load bearing and have a good key
- Free from separating and adhesion inhibiting substances such as e.g. dust, laitance, grease, oil, plasticizers, rubber marks, rust, paint residues and similar.

Dependent on the particular substrate the following measures are to be carried out to prepare the substrate:

### Cement-based surfaces:

- Grit blasting, scabbling, planing, vacuuming
- Before applying BAYCOFLEX-DD6030 priming the joint edges with BAYCOFLEX-PR230 is recommended. If the surfaces are clean priming is not necessary.

### Steel surfaces:

- Grit blasting, shiny metal

## Product Preparation:

Component A (resin) and component B (hardener) are delivered in a pre-determined mixing ratio. Tip component-B into component-A. Ensure that the hardener drains completely from its container. Mixing of the components is to be carried out with a suitable stirrer (e.g. drill with a paddle mixer). It is important to ensure that the product is also stirred from the sides and the bottom so that the hardener is evenly dispersed. Mix until homogenous (free from striations). Mix time approx. 8 minutes. It is particularly necessary to ensure that no air is entrained. The minimum temperature of the material during the mixing process and application may not drop below +5°C. The substrate temperature may not drop below +5°C or exceed +35°C.

## Method of Application/Consumption:

1. Back-fill the prepared joint with a closed cell backing strip. Ensure that the backing strip is not damaged. When applied in tramway track construction the existing rail side elements from the base of the joint. Prevent a three edge bond by placing a polythene strip in the base of the joint.
2. Before extruding the sealant, mask off the edges of the joints to protect against contamination.
3. Applying the sealant: Taking care not to entrain air, fill out the mixed sealant into the joint using a flowgun or spatula. Smooth the sealant surface. Air bubbles are to be removed within the working time by running over lightly with a smoothing stick or smooth flat brush.

## Consumption:

|                          |    |     |     |      |      |      |
|--------------------------|----|-----|-----|------|------|------|
| Joint width (mm)         | 10 | 20  | 30  | 40   | 50   | 60   |
| Joint depth (mm)         | 8  | 17  | 24  | 32   | 40   | 48   |
| Approx. Consumption (ml) | 80 | 340 | 720 | 1280 | 2000 | 2880 |

The consumption of BAYCOFLEX-DD6030 is calculated with the formula:

Joint width (mm) x fill depth of the sealant (mm) = ml/m of joint.

## Important advice:

- Higher temperatures shorten the working time. Lower temperatures extend the working time and setting time.
- The bond between individual coatings can be heavily impeded through the influence of dampness or contamination between the applied materials.
- When longer waiting times occur after application of the primer, the existing surface must be well cleaned and thoroughly abraded. The primer should then be re-applied.
- Seek separate advice for contact surfaces in areas with low temperature asphalt.
- Applications that are not clearly explained in this technical data sheet may only be carried out after consultation with and written confirmation from the AB-SCHOMBURG Technical Services Department.
- Cured product residues are household waste. The single components A and B are to be disposed of under waste disposal code 08 04 09 (adhesives and sealants containing no halogenated solvents).
- Thoroughly emptied containers can be disposed of via recycling.

## Health & Safety:

Component-A of BAYCOFLEX-DD6030 can be handled without any particular safety measures. Direct contact with the skin should simply be avoided as is usual when handling chemicals.

Please observe a valid Health & Safety Data Sheet!