

### Expansion Joint Systems

## Delcrete<sup>®</sup> m (5.6 CF)

**Delcrete<sup>®</sup> is available in various unit sizes that require different mixing ratios. Please refer to your actual Delcrete<sup>®</sup> packaging to confirm these installation instructions are applicable to your product.**

### UNIT MAKEUP

**Part A** - 1500 ML Clear

**Part B** - 3000 ML Black

Two 24 lb. bags of aggregate. One batch is equal to 3.5 mixed gallons. 12 batches per unit is equal to 42 mixed gallons. 42 gallons is equal to 5.6 cubic feet per unit.

### MISCELLANEOUS

- A. Parts A & B may be stored outdoors, but must be protected from freezing weather. The aggregate must be protected from the elements. Store indoors or in a storage container. If stored outdoors, it must be off the ground and covered with a waterproof tarp.

### EQUIPMENT

The D.S. Brown Company recommends the following equipment and materials:

- A. 3/4" heavy duty, slow speed, high torque drill or 3/4" hp mixer with mixing with mixing paddle. D.S. Brown recommends the [Eibenstock Model EHR 18.1 S Mixer](#) or equivalent.
- B. 5 gallon bucket (2)
- C. Plastic measuring beakers (min. capacity 5000 ml)
- D. Notched trowels for finishing and scrapers (margin or brick trowels) for buckets
- E. Personal protective equipment (safety glasses, gloves, safety vests, etc.) See SDS.

- F. Silicone mold release and spray paint (to facilitate cleanup)
- G. Duct tape
- H. Pump-up sprayer or paint brushes for primer
- I. Poly film (in case of rain)
- J. Bung wrench (for opening pails)

### THE BLOCKOUT

- A. Minimum application depth is two inches.
- B. The entire application area must be sandblasted, including one inch outside the repair area. Secondary blasting may be needed if contamination or dampness occurs.
- C. Blow area (including a wide portion of roadway surface area) with high-pressure air that is free of oil and moisture.
- D. It is good practice not to get too far ahead with sandblasting and air blowing or else they may need to be repeated.
- E. Duct tape edge of repair area.

### PRIMING CONCRETE

- A. Primer is best applied with a pump-up spray tank (stainless steel preferred) or plastic spray bottle.
  - Spray nozzles, valves, etc., can be cleaned by immersing in denatured alcohol.
- B. The primer may also be applied by brushing:
  - Use clean brushes at all times.
  - Use smaller "working" can large enough to hold sufficient primer to coat the blockout.
- C. Fresh primer must always be used.
- D. Avoid puddles as this increases drying time.
- E. It is good practice not to return excess primer to the main one-gallon can.

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- F. Primer must cure 30 minutes prior to placement of Delcrete®.
- G. Primer must be re-applied after six hours or if a drenching rain occurs.
- H. **USE GREAT CARE IN APPLYING PRIMER. IMPROPER PROCEDURES WILL AFFECT BOND STRENGTH.**

### MIXING

- A. Use a D.S. Brown approved heavy-duty drill and high viscosity round spiral mixing paddle that will mix the bottom edge of a 5-gallon pail.
- B. Mix 1,500 ml of Part A and 3,000 ml of Part B for 20 seconds. Premixing must be done before adding the aggregate.
- C. Add two bags of aggregate at a steady rate while continuing to mix for no less than 1 minute. The mix should be evenly wet throughout. A dry mix is a bad mix and should not be poured into the repair area.
- D. Take material to blackout.

### PLACEMENT AND FINISHING

- A. Delcrete® is initially self-leveling, but rapidly becomes thicker. Be sure to have an area ready for placement prior to mixing.
- B. Pouring - Delcrete® m (5.6 CF) is semi-self-leveling. Trowel material in place. Fill entire area to grade as you go. As it cures, use a trowel to achieve a grooved or textured finish. For repairs along existing joints, joints should be maintained by the use of forming materials or saw cutting after the Delcrete® has fully cured.
- C. Start at the low end of the repair area. Delcrete® will flow for several minutes; use trowel to push excess "uphill". After Delcrete® has taken its initial set, use notched trowel to finish to final grade. Avoid "smearing" the excess outside the repair area.
- D. Never leave a partially filled blackout at lunch breaks, etc.
- E. Total working time with Delcrete® from adding Parts

A & B to initial set is approximately five to ten minutes, depending on temperature.

- F. It is good practice to use a notched trowel that is long enough to span the repair area.
- G. If edges are masked with duct tape, remove immediately after final troweling.

### SPECIAL COMMENTS

- A. On hot, sunny days, keep kits under cover or in the shade.
- B. Open pails only as needed. To ensure future quality of Delcrete® parts A & B, tightly close partial containers for reuse.
- C. Use empty aggregate boxes under measuring and mixing operations to catch drips and spills.

### ACCEPTING TRAFFIC

- A. Traffic can usually be accepted within one hour after the final pour. Experience will indicate when Delcrete® has cured sufficiently to accept traffic. Two hour maximum.

### CLEANUP

- A. Before starting, spray buckets with mold release and spray paint. After final mix, do not scrape out excess, but allow the film to cure, and then peel out.
- B. Paddles should be scraped between mixes to reduce buildup.
- C. Residue in Part A beaker will set up and can be stripped out.
- D. Residue in Part B beakers can be drained into an empty Part B can. Final dregs can be wiped away with paper towels.
- E. Paddles, tools, scrapers, trowels, etc. can be immersed in denatured alcohol or solvent and cleaned later.

### RESTRICTIONS

- A. Delcrete® must not be installed when air and concrete temperatures are colder than 45°F.
- B. Delcrete® should not be poured in the rain, however slight.
- C. Delcrete® should not be used in combination with any fast-setting concrete without checking with The D.S. Brown Company Customer Service for compatibility.