

KEY #780 EPOXY JOINT FILLER

Product Information Sheet



DESCRIPTION

KEY #780 is a 100% solids semi-rigid epoxy joint filler used to protect saw cut joints in concrete slabs or in repair of existing damaged joints. **KEY #780** absorbs the impact and shock of heavy loads and steel wheeled traffic, preventing erosion of control joint edges. **KEY #780** is available in Regular Cure (RC), Fast Cure (FC), and Super Fast Cure (SFC) formulations.

KEY ADVANTAGES

- Easy 1 to 1 mix ratio
- Ultimate elongation of 100%
- Low odor for use in occupied areas
- Meets USGBC LEED criteria for low VOC
- Cures on damp surfaces
- USDA approved

KEY CONSIDERATIONS

- Substrate temperature must be a minimum of 50°F
- Substrate must be free of dirt, waxes, curing agents, and other foreign materials
- Follow ACI guidelines, should not be installed on new concrete cured <30 days

COLOR SELECTION

Gray. Custom colors available subject to lab approval, additional lead time and cost.

COMPOSITION

100% solids epoxy resin with aliphatic amines.

CURE/DRY TIME

Working Life	RC	40-45 minutes @ 75°F
	FC	20-25 minutes @ 75°F
	SFC	15-20 minutes @ 75°F
Dry to Touch	RC	8 hours @ 75°F
	FC	3 hours @ 75°F
	SFC	2.5 hours @ 75°F
Recoat	RC	8-10 hours @ 75°F
	FC	3-4 hours @ 75°F
	SFC	2-3 hours @ 75°F
Sanding Time, Wheeled Traffic	RC	24-48 hours @ 75°F
	FC	12-24 hours @ 75°F
	SFC	10-20 hours @ 75°F
Full Cure & Maximum Resistance		7 days

APPLICATION

SURFACE PREPARATION

Surface Preparation is the most critical portion of any successful resinous flooring system application. All substrates must be properly prepared as outlined in **Key Resin Technical Bulletin #1**. Work must be performed by trained or experienced contractors or maintenance personnel. The **Key Resin Technical Service Department** is available to answer any questions.

MIXING and INSTALLATION

KEY #780 is mixed by combining equal parts by volume of Part A and Part B. Pre-mix each component prior to combining. Mix combination with a low speed drill for a minimum of three minutes.

KEY #780 can be poured from a suitable container or applied with a caulking gun. Two passes may be required as pourable materials have a tendency to “dish out”. The filled joint **MUST** be flush with the floor. For complete installation instructions, contact **Key Resin Technical Service**.

COVERAGE Linear Feet / Gallon

Width→							
Depth↓	1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	1"
1/4"	616.0	308.0	205.3	154.0	123.2	102.7	77.0
1/2"	308.0	154.0	102.7	77.0	61.6	51.3	38.5
3/4"	205.3	102.7	68.4	51.3	41.1	34.2	25.7
1"	154.0	77.0	51.3	38.5	30.8	25.8	19.3
1 1/4"	123.2	61.6	41.1	30.8	24.6	20.5	15.4
1 1/2"	102.7	51.3	34.2	25.7	20.5	17.1	12.8
1 3/4"	88.0	44.0	29.3	22.0	17.6	14.7	11.0
2"	77.0	38.5	25.7	19.3	15.4	12.8	9.6
1 1/2"	61.6	30.8	10.5	14.7	12.3	10.3	7.7
2 3/4"	51.3	25.7	17.6	12.8	10.3	8.6	6.4

CLEAN UP

Clean skin with soap and water. Tools and equipment should be cleaned with xylene or lacquer thinner before **KEY #780** gels. Consult Safety Data Sheet (SDS) for safety and health precautions.

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TECHNICAL DATA

Mixing Ratio	1 Part A to 1 Part B by Volume
Volatile Organic Content (VOC) (EPA Method 24)	0 g/L, compliant to low VOC Rule 1113 in all 50 states
Solids Content	100% Solids by Volume
Weight	10.50 lbs/gal, mixed
Viscosity	2,200 cps

PHYSICAL PROPERTIES

Artificial Weathering	ASTM G23-75 Type D	10-15% elastomer property change after 1,000 hrs
Bond Cohesion after Water Immersion	Fed Spec TT-S-00227E	No failure after 25% total movement
Bond Strength to Concrete	ASTM D7243	300+ psi Concrete failure, varies by concrete strength
Service Temperature		30-180°F
Tear Resistance	ASTM D624-73	30 lb/in
Tensile Strength	ASTM D638	600 psi
Ultimate Elongation <small>This property provided only for comparison with other fillers. Elongation does not directly correlate to lateral expansion capability.</small>	ASTM D638	100%
Hardness	ASTM D2240	RC: 80-85 Shore A 30-40 Shore D FC: 95-100 Shore A 45-55 Shore D SFC: 90-95 Shore A 40-50 Shore D

MAINTENANCE

KEY #780 is typically installed as a joint material for **Key Resin Flooring Systems**. However, if needed **KEY #780** can be cleaned with neutral soaps and detergents.

AVAILABILITY

Key Resin materials are available throughout the United States, Canada, and a number of other countries. Contact the **Key Resin Representative** in your area for details.

TECHNICAL SERVICE

Key Resin Company provides services and consultations on material selection, specification, troubleshooting, and other information on the proper repair and protection of concrete surfaces. **Key Resin Sales/Technical Representatives** are available to assist you. Telephone 888.943.4532 or visit www.keyresin.com.

WARRANTY

Key Resin Company ("Key") warrants for a period of one (1) year that its products will be free of manufacturing defects and will be in conformity with published specifications when handled, stored, mixed, and applied in accordance with recommendations of Key. If any product fails to meet this warranty, the liability of Key will be limited to replacement of any non-conforming material if notice of such non-conformity is given to Key within (1) one year of delivery of materials. Key may in its discretion refund the price received by Key in lieu of replacing the material. No customer, distributor, or representative of Key is authorized to change or modify the published specifications of this warranty in any way. No one is authorized to make oral warranties on behalf of Key. In order to obtain replacement or refund the customer must provide written notice containing full details of the non-conformity. Key reserves the right to inspect the non-conforming material prior to replacement. EXCEPT FOR THE EXPRESSED WARRANTY STATED ABOVE, THERE ARE NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE. KEY'S OBLIGATION SHALL NOT EXTEND BEYOND THE OBLIGATIONS EXPRESSLY UNDERTAKEN ABOVE AND KEY SHALL HAVE NO LIABILITY OR RESPONSIBILITY TO THE PURCHASER OR ANY THIRD PARTY FOR ANY LOSS, COST, EXPENSE, DAMAGE OR LIABILITY, WHETHER DIRECT OR INDIRECT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.