



KEY #780 JOINT FILLER

DESCRIPTION

KEY #780 is a 100% solids, flexible epoxy joint filler used to protect saw-cut joints (contraction/control joints) in concrete slabs on grade or to repair existing damaged joints. **KEY #780** absorbs the impact and shock of heavy loads and steel wheeled traffic, preventing erosion of control joint edges.

KEY ADVANTAGES

- Protects Concrete Joint Edges from Erosion Caused by Wheeled Traffic
- Easy 1 to 1 Mixing Ratio
- Ultimate Elongation of 100%
- Fast Cure and Super Fast Cure Formulations Available
- Zero VOC, Meets USGBC LEED Criteria
- Low Odor for Use in Occupied Areas
- Cures on Damp Surfaces
- USDA Approved

KEY CONSIDERATIONS

- Should not be installed on concrete that has been cured for less than 30 days.
- Excessive moisture in concrete requires moisture mitigation system.
- Substrate temperature must be a minimum of 50°F.
- Substrate must be free of dirt, waxes, curing agents, and other foreign materials.

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 COMPANY'S TECHNICAL BULLETIN #1**. Work must be performed by trained or experienced contractors or maintenance personnel.

MIXING & INSTALLATION

Mix one (1) part of **Part A** by volume with one (1) part of **Part B** by volume with a slow speed drill until liquids are completely blended. Mixed **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 your **Key Resin Sales/Technical Representative** or **Key Resin Technical Service**.

CLEAN UP

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

COMPOSITION

100% Solids Epoxy Resin and Aliphatic Amines.

COLOR SELECTION

KEY #780 is available in Light Gray or Dark Gray. Custom colors are available with additional lead time.

COVERAGE LINEAL FEET PER 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	25.7	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
2 1/2"	61.6	30.8	20.5	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

PERFORMANCE PROPERTIES, TECHNICAL DATA

Tensile Strength	ASTM D-638	600 psi
Ultimate Elongation	ASTM D-638	100%
Adhesion (unprimed)	ACI 503R, ASTM D7234	>300 psi (100% Concrete Failure, varies by concrete strength)
Bond Cohesion (after Water Immersion) Fed. Spec. MIL-TT-S—00227E		No Failure After 25% Total Movement
Tear Resistance	ASTM D-624-73	30 lb/in
Artificial Weathering	ASTM G23-75 Type D	10-15% Elastomeric Property Change After 1000 hours
Service Temperature		30-180°F
Hardness Shore A	ASTM D-2240	RC: 80-85 FC: 95-100
Mixed Viscosity		2200 cps
Mixing Ratio		1 Part A to 1 Part B by Volume
Solids Content		100%, by Volume
Volatile Organic Content (VOC)		-0-
Weight per Gallon		10.5 lbs. per gallon, mixed

CURE/DRY TIME (Regular Cure Formulation)

Pot Life (Regular Cure)	40 minutes @ 75°F
Cure Time, Tack Free	6-8 hours @ 75°F
Re-Coat Time	8-10 hours @ 75°F
Sanding Time	24 hours @ 75°F
Minimum Time for Wheeled Traffic	24-48 hours @ 75°F
Full Cure & Maximum Resistance	48-72 hours @ 75°F

CHEMICAL RESISTANCE

REAGENT	RATING	REAGENT	RATING
Acetic Acid-5%	L	JP-8 Jet Fuel	R
Acetone	L	Lactic Acid-15%*	L
Betadine	L	Methyl Ethyl Ketone	L
Beer	R	Motor Oil	R
Bleach-10% *	L	Nitric Acid-10%*	R
Citric Acid-30%, 40%	R, L	Skydrol	R
Crude Oil	R	Sodium Hydroxide-50%	R
Diesel Fuel	R	Spor-Klenz (concentrate)*	L-1 hour
Ethylene Glycol	R	Spor-Klenz (diluted)	L-8 hours
Fatty Acids	L	Sulfuric Acid-20%	L
Gasoline	R	Toluene	R
Fatty Acids	L	Urea	R
Hydrochloric Acid-10%	R	Vinegar	L
Hydrochloric Acid-15%	R	Xylene	L
Iodine	L		

R - Recommended for continuous service.

L - Limited recommendation for 8 hours or less exposure time, requires more frequent cleanup, occasional spills only.

* - May cause slight stain or discoloration.

AVAILABILITY

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

MAINTENANCE

After completing the application of **KEY #780** and the flooring system, the installer should provide the owner with maintenance instructions. If floors become slippery due to animal fats, oil, grease, or soap film, clean and rinse thoroughly.

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.