



420 N. Roosevelt Ave. • Chandler AZ 85226
1-800-528-8242 • (602) 276-0406 • FAX (480) 961-0513
www.crafco.com

APPLICATION INSTRUCTIONS

HOT-APPLIED FLEXIBLE PAVEMENT MARKER ADHESIVE

JANUARY 2004

READ BEFORE USING THIS PRODUCT

GENERAL: Crafco Hot Applied Flexible Pavement Marker Adhesive is a hot melt thermoplastic material which when properly used and applied bonds markers and reflectors to both asphalt and concrete pavement surfaces. Being a hot melt composition, Crafco Marker Adhesive sets up on cooling and is ready for traffic in less than 5 minutes. For detailed product data and specifications, refer to the Crafco Product Data Sheet for Flexible Pavement Marker Adhesive.

MELTING: Crafco Marker Adhesive should be melted and heated in either thermostatically controlled double boiler type units utilizing heat transfer oil or thermostatically controlled electric heating pots. Direct flame melting units must not be used. Contact Crafco for recommendations regarding other types of melters. Marker Adhesive should be heated to between 375°F and 425°F (190°C – 218°C) for application. For best results, use a Crafco melter/appliator to melt and apply product.

PAVEMENT TEMPERATURES: To achieve best performance, pavement surface temperature during application is recommended to be at least 50°F (10°C). If markers are to be applied in cooler temperatures, the pavement surface may be gently heated with an open flame or other approved method immediately prior to marker application.

PAVEMENT CLEANING PROCEDURES: The pavement on which markers or reflectors are being applied should be clean, free from dust, oil, dirt or other contaminants and dry. Air blowing, wire brushing or sandblasting may be required to adequately prepare the pavement surface.

APPLICATION OF MARKERS: Hot-Applied Flexible Marker Adhesive should be applied to the pavement surface in a puddle approximately two-thirds to three-fourth the diameter of the marker. Markers should be applied to the adhesive immediately (within 10 seconds) to assure bonding. Markers should be pressed down to force the adhesive out beyond the perimeter of the marker and to limit the thickness of the adhesive between the pavement and the marker.

APPLICATION LIFE: Application life at application temperatures is approximately 12 to 15 hours in indirectly heated type melters. Application life may be extended by adding fresh blocks of adhesive as quantity in the kettle decreases. The adhesive should be agitated while being applied. The adhesive may be reheated to application temperature once, after the initial heat up. Additional reheating of the material may result in degradation of properties. When the application life has been exceeded, the adhesive will begin to thicken, become "stringy" and may then gel. If this should occur, the adhesive should immediately be removed from the kettle and discarded.

CLEAN OUT: If the equipment being used is a type that requires clean out of pumps and plumbing, follow the manufacturer's clean out procedure instructions. If solvent is used for clean out, insure that the solvent does not contaminate the adhesive because adhesive dilution and flash problems may occur.

STORAGE: Pallets of boxed product are protected with a weather resistant covering. During storage, the protective wrap must be kept on the pallets to prevent boxes from getting wet. If boxes are subjected to moisture, they may lose strength and crush resulting in pallet leaning. If rips in the pallet covering occur during handling, they should be repaired to help maintain packaging integrity. Pallets should be stored on a level surface which is dry and has good drainage. Product material properties are not affected by packaging deterioration.

SAFETY AND USAGE PRECAUTIONS: Since Hot-Applied Flexible Marker Adhesive must be heated to elevated temperatures to prepare for use, it is essential that operations be conducted in manners which assure safety of the application personnel and others. All personnel associated with use of the material need to be aware of the hazards of using hot-applied materials and safety precautions. Before use, the crew should read and understand product and safety information in on the box and all sections of the product Material Safety Data Sheet. This sheet which is supplied with each shipment, describes the characteristics of the product as well as any potential health hazards and precautions for safe handling and use. User should check D.O.T. requirements for transportation of adhesive at elevated temperatures above 212°F (100°C).

HAZARDS ASSOCIATED WITH HOT-APPLIED MATERIALS: Skin contact with hot-applied materials causes burns. Over exposure to fumes may cause respiratory tract irritation, nausea, or headaches. Appropriate precautions need to be taken to prevent contact with the hot material and to avoid inhalation of fumes for everyone in the vicinity of the work area. Safety precautions should include: 1. Protective clothing to prevent skin contact with hot material. 2. Care when adding blocks of product to melters to reduce splashing. 3. Careful operation and control of wands or pour pots which are used to apply product. 4. Traffic and pedestrian control measures which meet or exceed local requirements to prevent access to work areas while product is still in a molten state. 5. Avoidance of material fumes. 6. Proper application configurations with a minimum amount of excesses of material. 7. Appropriate clean up of excessive applications or product spills.

ADDITIONAL INFORMATION: Additional information is available by contacting your distributor or Crafco, Inc. This information includes 1) Product Data Sheets, 2) Material Safety Data Sheets, 3) Safety Manual.