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## APPLICATION INSTRUCTIONS

### MASTIC ONE

PART NO. 33339

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#### READ BEFORE USING THIS PRODUCT

**GENERAL:** These application instructions pertain to Crafco Mastic One, which is a hot applied, single component, pourable, aggregate filled, polymer modified asphalt pavement repair mastic. Mastic One is used for filling and repairing many distresses in both asphalt concrete and Portland cement concrete that are larger than those typically repaired by crack or joint sealing, but smaller than repairs requiring remove and replace patching procedures. Typical uses include filling and leveling of wide transverse or longitudinal cracks and joints, filling potholes and utility cuts, localized skin patch repairs and leveling bridge approaches or faulted areas. When properly applied, Mastic One forms a well bonded, flexible, durable, traffic resistant repair. To use, Mastic One is removed from the box, mixed and heated in an appropriate melter until application temperature is reached, then poured into the prepared repair area and then leveled. Mastic One is formulated to provide neat feathered edge installation. Mastic One is then ready for traffic when it has cooled to solidify.

**MELTING, HEATING AND AGITATING:** Mastic One is supplied in solid form in a meltable plastic bag contained in a cardboard box. The aggregate and polymer modified binder are pre-measured and packaged in the plastic bag, but are not pre-mixed. To use, the bag of Mastic One is removed from the box and then placed in a Crafco Patcher II or other approved melter to heat and mix the product. The melter must be equipped with an effective horizontal agitator system that is able to maintain a uniformly mixed product, have a thermostatically controlled hot oil jacketed heating system, and have an effective means of dispensing product. During heating, the heat transfer oil should be heated to between 450 and 525°F (323 - 274°C). Agitation should begin as soon as the Mastic One has melted sufficiently for the agitator shaft to turn. Additional Mastic One can then be added to the melter. Heating and agitation should continue until all added material has been thoroughly mixed and the product application temperature range of 375 - 410°F (190 - 210°C) has been reached. At application temperature, Mastic One is a thick, grainy appearing mastic. Additional Mastic One can be added as product is used and quantity in the melter decreases. When adding additional Mastic One, the agitator must be stopped. After the additional Mastic One is added, agitation is to be immediately resumed and application should not resume until required temperatures are reached and all added material has melted, becoming well mixed into the product with no uncoated aggregate present. During application and while product is hot, agitation should be continuous, except for when additional product is being added to guard against aggregate settlement. If aggregate settles in the melter, it may be difficult to agitate product. For best performance, it is recommended that the melter be emptied, or only small amounts of Mastic One be left in the melter at the end of each work day.

#### RECOMMENDED APPLICATION PROCEDURES:

1. Only apply Mastic One to clean, sound, dry surfaces.  
**Avoid highly distressed areas in need of reconstruction.** All areas must be clean from dust and debris. All areas to be repaired shall be blown with dry, oil free compressed air. If compressed air does not sufficiently prepare the

surface, additional cleaning procedures such as sweeping with a stiff or wire bristle broom, sandblasting or routing are recommended. **(If sealant won't adhere, neither will Mastic One).** PCCP shall be abrasive cleaned to achieve maximum adhesion performance.

2. The minimum pavement temperature for installation of Mastic One is 40°F (4°C). If the pavement temperature is less than 40°F (4°C), it can be warmed by heating with a heat lance. Asphalt concrete pavement should be heated so a slight bleeding effect occurs. This bleeding brings some of the asphalt binder from the pavement to the surface, which will enhance the adhesive bond between the Mastic One and road surface. However, caution should be taken to prevent overheating/oxidizing the asphalt brought to the surface as this could be detrimental to adhesion performance. Heating the pavement will of course also remove moisture assuring a dry surface. Mastic One should be applied within 10 minutes of warming the pavement area.
3. For improved adhesion, Crafco Asphalt Primer, part number 33140, can be applied to the cleaned surface. Primer should be brush, roll or spray applied at approximately 200 to 400 ft<sup>2</sup> per gallon (0.025 to 0.05 gsy), depending on pavement texture and porosity. Application should result in a completely wetted surface without puddling. Primer must completely cure prior to Mastic One application. Curing time required depends on weather conditions, including temperature, cloud cover, wind and humidity. At 70°F (21°C) on a sunny day curing will generally take from 30 minutes to 2 hours. At temperatures below 55°F (13°C) primer should be allowed to cure for at least 16 hours or overnight. Minimum temperature for primer applications is 45°F (7°C). Primer is cured sufficiently when it reaches a tacky condition when touched with no transfer to one's finger. All areas of the primed surface must reach this state of curing prior to membrane application. Mastic One should be applied the same day as when the primer becomes fully cured.
4. Mastic One that has been mixed and heated to the application temperature range is then dispensed from the melter and immediately applied to the prepared pavement area.
5. Immediately following application to the pavement surface, the Mastic One shall be leveled and smoothed to the desired level using a straight metal or rubber squeegee. If necessary for deep installations, to limit settling and to produce a level finished surface, Mastic One can be applied in layers with a cooling and solidifying time period between applications. Minimum installed thickness is 3/8" (1 cm). The aggregate portion of Mastic One is selected to allow feathered edge type installations when required. The finished Mastic One installation should be applied smooth and level with the pavement surface.
6. When installing over a distressed pavement surface, Mastic One should be applied at least 6" beyond the distressed area onto sound pavement surfaces.

7. Mastic One cools quickly after installation and is ready for traffic when it has solidified sufficiently to support loads. Apply Crafcro Detack to reduce surface tack and allow quicker opening of the area to traffic.

**APPLICATION CONFIGURATIONS FOR MASTIC ONE:** The general use of Mastic One is to repair pavement deficiencies which are larger than those that can be appropriately filled with pavement sealants, but smaller than those where conventional remove and replace patching procedures are used. Suggested uses include (but are not limited to): 1) pavement cracks or joints over 2 in (5 cm) wide, 2) small potholes up to 4 in. (10 cm) deep and 12 in. (25 cm) in diameter, 3) pavement depressions up to 2 in. (5 cm) deep and 6 in. (60 cm) wide, 4) skin patching alligator cracked and other distressed areas (avoid deteriorated areas in need of reconstruction), 5) leveling recessed transverse thermal cracks, and 6) capping settled utility cuts. Mastic One shall not be used for surface skin patch repairs near intersections.

When applied, the modified asphalt binder is self-adhesive and develops a strong bond to the desired work area. Shrinkage of approximately 5% will occur as Mastic One cools from application temperature to ambient conditions. No compaction is required. After application, sufficient time must be given for the product to cool before opening the area to vehicular or pedestrian traffic. Cooling time will vary depending on the size of the application and ambient temperature. Generally allow approximately 30 to 60 minutes of cooling for each 1 in. (2.5cm) of material depth.

For deep applications Mastic One should be applied in two separate lifts. The first application should fill the work area to within 1/2 in. (12 mm) – 1 in. (25 mm) of the desired height. After the first lift has cooled, a second lift should be applied level with the surrounding pavement. This technique will reduce the amount of material shrinkage when cooled.

Roofing felt paper can be used along the work area boundaries to create a neat, well defined edge. The paper should be removed immediately after application before material cools.

**APPLICATION LIFE:** Application life at application temperatures is approximately 12 to 15 hours. Application life may be extended by adding fresh material as quantity in the applicator decreases. Mastic One must be agitated while being applied. The material 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, Mastic One will begin to thicken, become “stringy” and may then gel. If this should occur, the material should immediately be removed from the applicator and discarded.

**PRECAUTIONS:** Mastic One will soften, become sticky, and track if exposed to fuel or oil spillage, therefore, it should not be used in areas subject to fuel or oils.

**STORAGE:** Pallets of packaged 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. Pallets should not be stacked because crushing of bottom layers may occur. Mastic One material properties are not affected by packaging deterioration.

**SAFETY PRECAUTIONS:** Since Mastic One is heated to elevated temperatures, it is essential that operations be conducted in manners which assure safety of personnel. All 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 use, safety information and the product MSDS. 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 product 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 operation. Safety precautions should include: 1. Protective clothing to prevent skin contact with hot material. 2. Care when adding product to melters to reduce splashing. 3. Careful operation and control of tools 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 regarding these products is available by contacting your distributor or Crafcro, Inc. This information includes 1) Product Data Sheets, 2) Material Safety Data Sheets, 3) Safety Manual.