

HITCHINS

TECHNICAL DATASPEC

FORMFIL 660

Flexible Acrylic Filling Compound

March 2014

NO.1418 v5

Description

Formfil 660 is a one component waterborne flexible acrylic compound for filling cracks and joints or flushing out substrate imperfections

Recommended Uses

Formfil 660 can be used over suitably prepared and primed substrates to fill fine pin holes, cracks, chases or joints and flush out imperfections in concrete, block, cement plaster, fibre cement sheets, timber and timber composites.

- General fine flushing compound.
- Filling fine to medium size cracks in substrates.
- Filling junctions between two different surfaces.
- Sealing cracks around joinery.
- Sealing gaps around protrusions through walls.
- Flushing of bandages to a fine edge.
- Filling pin holes in pre-cast panels.
- Joint sealant in non critical, low movement applications.

Formfil 660 is used to bed-in fiberglass mesh or Flexi-tape, then Formflush 665 to fill and flush tapered joints in Recessed Fibre Cement Sheets.

Properties/Features

Formfil 660 is a flexible acrylic compound with good elastomeric properties to accommodate minor structural movement

Formfil 660 is a one component ready to use compound.

Formfil 660 will fill fine to medium cracks

Formfil 660 is easy to apply with a broad knife, flushing blade or trowel to fill pin holes or surface imperfections.

Formfil 660 is easy to knife fill cracks at joinery surrounds.

Formfil 660 can be over-coated with a wide range of Hitchins hi-build coatings and textures.

Limitations

Do not apply at temperatures below 10C or in suspect weather conditions

Do not use under water, or areas subject to ponding.

Do not use in expansion joints or large movement cracks. Refer to Formrok 28P Polyurethane Sealant

Minimal shrinkage will occur

Will not sand to smooth edge but can be finished to a feathered edge.

To prevent in-can drying and skinning keep lids on containers when not in use.

Technical Data

Classification	Waterborne, acrylic flexible sealant.		
Colour	Pink	Specific Gravity (kg/l)	1.2
Application Method	Trowel	Solids Content	77%
Packaging	Available in 10L pails	Clean up	Water
Shelf Life	2 years in unopened container	Flash Point	Not applicable
Application Range	Minimum : 10°C, Maximum : 35°C	V.O.C.	0.5 grams/litre
Top-coating	16 -48 hours depending on depth and drying conditions		
Drying times (25C/50%rH)	Touch dry : 2-3 hours, Thoroughly dry: Depending on build, 16-24 hours minimum.		

Hitchins New Zealand Limited

7 Masfield Street, PO Box 40749, Upper Hutt, Wellington, New Zealand, Ph: 64 4 527 7248

300 Richmond Road, PO Box 46018, Herne Bay, Auckland, New Zealand, Ph: 64 9 360 3246

Freefax: 0800 448 622, Web: www.hitchins.co.nz, Email: office@hitchins.co.nz



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Surface Preparation

To existing substrate, apply Hitchins Mosskill, leave for 3 days and waterblast clean,
All loose substrates, dirt, mould etc should be removed completely
Make sure the surface is clean, dry and fully cured.
New concrete to be minimum 28 days old, free of form release or curing agents, dirt, dust, oil, grease, bond breaker chemicals and any other contaminants, including efflorescence.
Dense concrete should be etched or abraded.
Absorbent surfaces must be pre-sealed before filling with **Formfil 660**
Fibre reinforced cement sheets recessed joints sealed with Formbond

Recommended Primers

Substrate	Primer
Concrete / Cement Plaster	Hitchins Sealflex Primer G
Dense concrete	Hitchins Formstik
Concrete block	Hitchins Sealflex Primer Filler
Brick unglazed/glazed	Hitchins Formstik
Fibre cement sheet	Hitchins Formbond / Formstik
Gypsum Plaster	Hitchins Pre-seal Primer
Timber	Hitchins Pre-seal Primer
Metal	Hitchins Formear Speed Spray 10 or Jotamastic 87

On very porous substrates, two coats of primer may be necessary as the first coat is absorbed by the substrate.

Application

Application can be by putty knife, broad knife, flushing blade or trowel.
Make sure there are no voids and no air is entrapped as this will cause weak spots and cracks.
To achieve the required depth install the correct size foam rod.
Use slip release material at bottom of shallow chase.

Top-coating

Formfil 660 can be top-coated with Hitchins hi-build acrylic smooth coatings and various textured finishes.
Refer to the appropriate dataspec, application procedures and specification sheets.

Drying and curing

The following times are at 25°C and 50%rH. Allow more time for lower temperatures and high humidity conditions.

Touch Dry	1-2 hours
Thorough Dry	Minimum 16 hours (depends on depth and drying conditions)
Recoat Time	16 hours
Full Mechanical and Adhesive Strength	14 days

Clean Up

Clean up equipment with warm soapy water

Health and Safety

As **Formfil 660** is non-flammable and low toxicity. Once dry, this product is no longer water soluble. Remove from skin immediately. In confined areas provide adequate ventilation.
Refer to the Safety Data Sheet N° 1418 for more information.

Non Compliance Warning

Do not apply or install any Hitchins product or process to building structures that do not comply with the Building Code.

Warranty

Formfil 660, as part of a process, is covered under the Hitchins Product Performance Warranty Document for “**that**” products process, as per our Warranty Schedule.