



# EDGE-FLEX 645

Maximum performance edge sealer specifically formulated with added release agent for use on concrete form panels.

## HOW IT WORKS

EDGE-FLEX 645 prevents the absorption of highly alkaline concrete bleed water into the edges of plywood and oriented strand board (OSB) concrete form panels by penetrating the edges and sealing off the wood fibers with an extremely durable, yet very elastic, film which expands and contracts with the substrate.

## APPLICATIONS

- ◆ Use in sealing the edges of all types of manufactured wood form panels, including plywood and oriented strand board (OSB) to be used in concrete forming applications.
- ◆ Use to seal all field-cut panel edges and snap-tie holes.
- ◆ For reapplication over poor performing mill applied edge sealants.
- ◆ Essential for use on all manufactured wood form panels to be used in the production of architectural concrete.

## ADVANTAGES

- ◆ Contains release agent to prevent concrete bonding.
- ◆ Completely resistant to the higher alkalinity of many modern concrete mix designs.
- ◆ Reduces alkaline water absorption through panel edges by up to 95 percent.
- ◆ By minimizing water absorption into the panel edges, wood sugar and tannin migration is simultaneously minimized, reducing concrete color variations, staining and concrete surface dusting.
- ◆ Significantly reduces panel edge swelling and the related elevation variations from panel to panel that are commonly seen in gang forming applications. Panel elevation variations yield unsightly concrete surface elevation variations that are often unacceptable to owners and are costly to repair.
- ◆ Panel life is greatly increased. This is especially true with higher performance overlaid panels (HDO, PSF and CBF) where panel failure almost always originates at the edges.
- ◆ Provides excellent resistance to ultra-violet radiation from the sun.

- ◆ Exceptional resistance to commonly used form oils and form release agents.
- ◆ DOT classified as non-flammable and non-combustible and is considered safe to apply under most manufacturing or field conditions.
- ◆ Unlike competitive edge sealers, EDGE-FLEX 645 645 is not only available to plywood and OSB producers, but is also available to concrete forming contractors through local concrete form and accessory distributors throughout North America.
- ◆ Green Engineered™ – better for health and the environment.
- ◆ Meets all federal and state VOC requirements.

## ▲ PRECAUTIONS ▲

- ◆ Do not apply to wet substrates.
- ◆ Do not apply to substrates that have been covered with a form oil or other coating/surface treatment that could interfere with the proper penetration and adhesion of EDGE-FLEX 645.
- ◆ Do not over apply. Excess application of EDGE-FLEX 645 that results in runs, drips or excess on offset panel edges can glue stacked panels together unless excess is removed from the face and back of panels before drying.
- ◆ Protect from freezing. If allowed to freeze, product packaging may rupture and the emulsion stability of this product may be affected, making it difficult to keep product mixed during application. Product which is suspected of freezing should not be used.
- ◆ Verify that product is within the “USE BY” date stated on product packaging. Do not use expired product. The use of expired product may result in poor product performance or failure.
- ◆ Treated substrates should be protected from exposure to water and freezing temperatures until the EDGE-FLEX 645 application has completely dried. Product dry time will vary depending on the ambient temperature and relative humidity at the time of application. The dry time at 70° F (21° C) and 50% relative humidity is approximately 1 hour.

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Form Treatments



chemical solutions to concrete problems

## USE INSTRUCTIONS

- ◆ Request current product literature, labels and material safety data sheets from manufacturer and read thoroughly before product use.
- ◆ Site environmental conditions, substrate conditions and construction have a major impact on product selection, application methods, procedures and rates, appearance and performance. Product literature provides general information applicable to some conditions. However, an adequate site test application by the purchaser or installer in advance of field scale use is mandatory (irrespective of any other verbal or written representations) to verify that product and quantities purchased can be satisfactorily applied and will achieve desired appearance and performance under intended use conditions.
- ◆ Ambient air and substrate temperatures must be in excess of 40° F (5° C).
- ◆ Mix thoroughly before using and intermittently during use.
- ◆ Apply to panel edges using a brush, roller or airless spray equipment in two successive coats, applying the second coat immediately after applying the first coat (wet on wet).
- ◆ Avoid runs or drips in both coats.
- ◆ The application rate of EDGE-FLEX 645 varies with the substrate porosity and saw cut roughness. Typical combined effective application rate for both coats is 100-150 sf/gal (2.5-3.75 sm/L) for optimum masking properties and performance.
- ◆ Application equipment should be cleaned with water immediately after use. EDGE-FLEX 645 develops a skin within a few minutes after application. Once this skin develops, water will no longer remove the coating and an aromatic solvent such as xylene must be used.

## TECHNICAL DATA

Bulk Density	8.4 lbs/gal (1.01 kg/l)
Freeze Point	32° F (0° C)
pH	9
Brookfield Viscosity	5,000 cp
Freeze/Thaw Stability	Poor

### EDGE-FLEX 645 TEST RESULTS

AVERAGE IMPROVEMENT IN WATER WEIGHT GAIN  
COMPARED TO UNSEALED CONTROL

	3.5 Hours	10 Hours	24 Hours
Percent Improvement	414%	368%	261%

## PACKAGING

Packaged in 1 gal (3.8 L) jugs, 5 gal (19 L) pails, 55 gal (208 L) drums and 275 gal (1,041 L) bulk totes.

## SHELF LIFE

Shelf life is twelve months. Use before the "USE BY" date stated on product packaging.

## HANDLING/STORAGE

Store in a dry location within a temperature range between 40° F (4° C) and 100° F (38° C).

## AVAILABILITY & TECHNICAL SERVICES

In addition to corporate offices in Omaha, Nebraska, NOX-CRETE Products Group also maintains regional offices and distribution centers in principal markets throughout the world. For source or technical information, phone (800) 669-2738 or (402) 341-1976.

## LIMITED WARRANTY

### NOTICE-READ CAREFULLY

#### CONDITIONS OF SALE

NOX-CRETE offers this product for sale subject to, and Buyer and all users are deemed to have accepted, the following conditions of sale and limited warranty which may only be varied by written agreement of a duly authorized corporate officer of NOX-CRETE. No other representative of or for NOX-CRETE is authorized to grant any warranty or to waive limitation of liability set forth below.

#### WARRANTY LIMITATION

NOX-CRETE warrants this product to be free of manufacturing defects. If the product when purchased was defective and was within use period indicated on container or carton, when used, NOX-CRETE will replace the defective product with new product without charge to the purchaser.

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