



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

**PRODUCT DATA SHEET**  
**HOT-APPLIED BITUMINOUS**  
**MARKER ADHESIVE**

PART NO. 34269

JANUARY 2004

**READ BEFORE USING THIS PRODUCT**

**GENERAL** CRAFCO Hot-applied Bituminous Marker Adhesive is a hot-applied bituminous material which, when properly used and applied, bonds markers and reflectors to both asphalt and concrete pavement surfaces. The adhesive is supplied as an easy to use single component material which is easily melted and poured or pumped onto pavement surfaces. Since it is a hot melt composition, the adhesive sets up on cooling and is ready for traffic in less than 5 minutes. Heating can be performed in either directly or indirectly heated melting units. The adhesive contains no rubber polymers which can degrade at application temperature.

**SPECIFICATION CONFORMANCE** Hot-applied Bituminous Marker Adhesive meets requirements for bituminous adhesive for pavement markers specified in ASTM D4280 and D4383. After melting, using gentle heating supplied by a hot plate or flame and stirring while heating to 425°F (219°C) the adhesive meets the following requirements:

<b><u>Adhesive Properties</u></b>		<b>ASTM D4280 and D4383</b>	
		<b><u>Specification Limits</u></b>	
Softening Point (ASTM D36)	34269 Softening Point (ASTM D36)	200-260°F (93-127°C)	210-230°F (99-110°C)
Penetration, 77°F (25°C) (ASTM D5)	Penetration, 140°F (60°C) (ASTM D5)	10-18	45-65
Flow, 158°F (70°C), 5hr (ASTM D 5329 modified)	Heat Stability Flow	0.2 inch (5mm) max.	0.2 inch (5mm) max.
Viscosity 400°F (204°C) (ASTM D2669)	Flash Point, C.O.C. (ASTM D92)	30-75 poise	550°F (288°C) min.
Recommended Pour Temperature	Shelf Life	375-400°F (191-204°C)	2 year min.
<b><u>Filler Free Material</u></b>		<b><u>Properties</u></b>	
Penetration, 100g, 5s, 77°F(25°C) (ASTM D5)	Viscosity, 275°F (135°C) (ASTM D2171)	25 min.	12-100 poise
Viscosity ratio, 275°F (135°C)		2.2 max.	
<b><u>Filler</u></b>		<b><u>Properties</u></b>	
Filler content, % by weight	Filler fineness, No. 100 sieve	65-75%	100% min.
	No. 200 sieve		95% min.
	No. 325 sieve		75% min.

**APPLICATION** The specific gravity of the adhesive is 1.8 at 60°F (15.5°C). Prior to use, the user must read and follow the Application Instructions for Hot-applied Bituminous Marker Adhesive (January 2002) to verify proper product selection, heating methods, pavement preparation procedures, application geometry, usage precautions and safety procedures. These instructions are provided with each pallet of adhesive.

**PACKAGING** Standard Marker Adhesive is supplied in self-release 3 compartment disposable boxes which contain approximately 50 lbs. (22.7 kg) of material. The boxes are palletized into shipping units weighing approximately 2400 lbs. (1091 kg). Material is sold by the net pallet weight.

**WARRANTY** CRAFCO, Inc. warrants that CRAFCO products meet applicable ASTM, AASHTO, Federal or State specifications at time of shipment. Techniques used for the preparation of the cracks and joints prior to sealing or filling are beyond our control as are the use and application of the products; therefore, CrafcO shall not be responsible for improperly applied or misused products. Remedies against CrafcO, Inc., as agreed to by CrafcO, are limited to replacing nonconforming product or refund (full or partial) of purchase price from CrafcO, Inc. All claims for breach of this warranty must be made within three (3) months of the date of use or twelve (12) months from the date of delivery by CrafcO, Inc. whichever is earlier. There shall be no other warranties expressed or implied. **For optimum performance, follow CrafcO recommendations for product installation**