

# FACADESXi Xi-FLASHFILL

## DESCRIPTION AND USAGE

Xi-FlashFill is a single-component, Silyl-Terminated-Polymer (STP) flashing sealant and a part of the WaterShield Family of air and water resistant barrier coating and accessories. When used in conjunction with the other WaterShield Products, it helps create a monolithic and watertight wall assembly.

Xi-FlashFill is an easy to gun, spreadable sealant that produces a highly durable, seamless, elastomeric flashing membrane.

## PACKAGING / COVERAGE

20 oz sausages

The estimated coverage area per pail is based on the condition of the substrate and method of application.

15–17 ft<sup>2</sup> per 20-oz sausage applied at 12–15 mils

A mockup using the exact materials for the project should be used to determine coverage.

## SHELF LIFE

12 months - stored off the ground, unopened, cool, protected from moisture, extreme heat 80°F (27°C), and direct sunlight. Do not stack double pallets.

Dispose of unused product and container in accordance with local, state and federal regulations.

## FEATURES / BENEFITS

- Vapor Permeable
- VOC Compliant
- Fast Drying for same day installation of wall assembly components and Xi-WaterShield installation
- Bonds to most common building materials without priming
- Bonds and cures in wet weather, and on damp substrates
- Solvent free. Isocyanate free. Phthalate free
- May be fully exposed to UV and weather for up to 12 months

## FOR USE WITH ALL FACADESXi SYSTEMS

For use with FACADESXi Xterior EIFS, Stucco, Masonry Veneer and Cement board systems.

Water & Air Barrier transition sealant used in conjunction with the WaterShield Assembly for use behind all FACADESXi Systems and for use under any Cladding.

Allowable Substrates:

- ASTM C1177 type sheathings: DensGlass® sheathing, GlasRoc® sheathing Weather Defense® sheathing, eXP® sheathing
- ASTM C1325 Type A Exterior cement-board: PermaBase
- Poured concrete/unit masonry/brick
- Untreated Exposure I or exterior plywood sheathing (grade C-D or better)
- Untreated Exposure I OSB
- Gypsum sheathing (ASTM C79/ ASTM C1396)
- Wood Framing
- Galvanized steel
- Stainless steel
- Vinyl
- Polyvinyl Chloride (PVC)
- Anodized Aluminum
- WaterShield SA Flashing Membrane

## CLEAN UP

Clean tools and equipment with mineral spirits or similar solvent immediately after use. Follow all safety precautions. Remove cured Xi-FlashFill using a sharp-edged tool.



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## APPLICATION

This application instruction must be used in conjunction with the Xi-WaterShield Product Datasheet. See System Details, WaterShield Details and Project Details for full installation.

Protect surrounding areas during application.

Apply using a professional caulking gun and spread with a DRY joint knife, trowel, or spatula. Do not use soapy water or solvent to help with the tooling process or to slick the surface profile

For best results, spread/tool Xi-FlashFill while still wet, within 2–3 minutes of gun application.

### Gaps, Joints, Seams, Cracks, Fastener Heads, Penetrations

1. Apply a bead of Xi-FlashFill to all sheathing joints, seams and cracks and strike smooth with a DRY tool.
  - a. Joint widths up to ¼ inch: No Backer Rod Required.
  - b. Joint widths up to ¼-1 inch: Install backer rod into the joint before installing Xi-FlashFill
2. Spot fastener heads and strike with a dry tool.
3. Allow to skin before installing other waterproofing or air barrier components.

### Rough Openings

1. Apply a bead of Xi-FlashFill in each corner of the rough opening and at the sheathing-to-stud transition, then strike smooth with a dry tool.
  - a. Joint widths up to ¼ inch: No Backer Rod Required.
  - b. Joint widths up to ¼-1 inch: Install backer rod into the joint before installing Xi-FlashFill
2. Apply Xi-FlashFill over the exterior inside framing of the rough opening and onto the exterior vertical wall surface 4–6 inches to create a 12–15 mil thick monolithic, pinhole-free flashing surface.
3. Allow treated surfaces to skin before installing windows, doors and Xi-WaterShield (WaterShield may be installed first, always ensuring positive drainage).

### Application over Flashings, Fins, casing beads, penetrations.

After flashings, window fins, penetrations are installed, install a ⅜" bead of Xi-FlashFill at the top edge of legs and strike with a dry joint tool per project details to create a waterproof connection and positive drainage.

### Transition between Water Resistive Barriers:

When there is a transition between Xi-FlashFill and Non-FACADESXi materials, consult FACADESXi Technical Services. The adhesion between products is not always known and testing may be necessary. Xi-FlashFill may have slight incompatibility with some asphaltic materials or butyl adhesives. Always test first.

If product skins between applications, remove skin and re-mix product before applying as recommended.

After application of Xi-FlashFill and Xi-WaterShield, flashings and sealants, additional Xi-FlashFill should be used to treat any area, crack, gap, etc. to make a monolithic water and air barrier.

## SURFACE PREPARATION / JOB CONDITION

Clean up surface area by removing dirt, dust, debris contaminants, chemical residues, surface oxidation, surface coatings or films prior to application.

### TEMPERATURE LIMITATIONS

- Substrate and exterior temperature must be between 32°F (0°C) and 110°F (43°C) during application and drying.
- Greater than 95°F (35°C): Apply product to the shady side of project and surfaces may be cooled with a mist of fresh water however, must dry before installation of the Xi-WaterShield.
- Less than 32°F (0°C): Product may be applied to frost-free substrates however it will not begin to cure until temperatures reach and stays above 32°F (0°C) until cured.

### SHEATHED CONSTRUCTION

1. Sheathings/Substrates must be installed in accordance with manufacturer's and building code requirements; flat, free of fins or irregularities greater than ¼" in 10'. Remove and replace damaged sheathing.
2. Although Xi-FlashFill may be applied on damp substrates, the substrate must be dry before application of Xi-WaterShield. Plywood and OSB moisture content must not exceed 19%.
3. Raw gypsum board edges: When installing into soffits, into rough openings or around corners, it is best to use the factory edge of gypsum products, a primer will be required if applying to raw gypsum. Contact FXI Technical.
4. Pressure-treated or fire-retardant wood and other contaminated surfaces should be cleaned with an isopropyl alcohol wipe and allowed to flash-off before application.

### CMU/MASONRY/CONCRETE/STUCCO

1. Surface must be dry, and free from all form release agents, dirt, efflorescence, or anything that would prohibit the bond.
2. Mortar joints must be flat and cured for 3 days.
3. Fill, repair and allow to dry per the manufacturer any voids or imperfections in the concrete.
4. Concrete must be in place for a minimum of 3 days and alkalinity must be less than 10.

- Large Gaps / Joints greater than 1 inch must be structurally repaired or treated with an appropriate joint treatment.
- Painted/loose/damaged substrates must have the paint removed by water/sand blasting and damage repaired so that 90% of the virgin substrate is exposed and adhesion tested prior to installation, Contact FACADESXi Technical Department.
- Window fins, metal flashings or other components: Test adhesion prior to application of any FXI Product. If adhesion is weak, wipe with isopropyl alcohol, allow to dry and re-test.
- Roofing systems must be capped and sealed or top of walls protected from water intrusion both before and after air barrier system installation.
- Unsatisfactory conditions shall be reported to the general contractor and corrected before application of Watershield.

For surface preparation questions or further information, contact the FACADESXi Technical team.



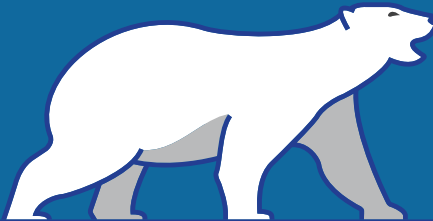
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## CAUTIONS / LIMITATIONS

- UV Stable however it should not be left exposed more than 12 months. The surface must be examined before installing any cladding and when using EIFS, if exposed more than 30 days, the surface must be cleaned and dry.
- Not a structural sealant.
- Not for use as through-wall flashing.
- When installing fasteners through Xi-FlashFill, ensure the fasteners penetrate framing members.
- A slip sheet is required when the cladding is a cement based stucco or mortar bed to prevent adhesion.
- Use clean materials and tools to prevent contamination of the material.
- Not for use in a negative pressure waterproofing, or in immersion.
- Wear protective eye-wear and clothing

## DRYING TIME

Xi-FlashFill will skin over within 30-60 minutes, and dry in approximately 4-6 hours, longer in low temperatures and humidity and shorter in high temperatures and humidity.



CONTACT FACADESXi TECHNICAL FOR SPECIFIC INSTRUCTIONS.

## PHYSICAL PROPERTIES / TESTING / TECHNICAL DATA

	METHOD	CRITERIA	RESULTS
Accelerated UV Aging & Peel Adhesion	ASTM G154, UVA cycle 1 / ASTM C794	≥ 5 pli	Pass
Adhesive Strength to Substrates	ASTM C794	≥ 5 pli	Pass
Crack Bridging after Cycling	ASTM C1305	550 millimeters for 24 hours after cycling	Pass
Damp Surfaces	ASTM C794	≥ 5 pli	Pass
Elevated Temperature Exposure	AAMA 711 / ASTM C794	≥ 5 pli	Level 3=176° F for 7 days
Flash Point			>200° F (>93° C)
Nail Sealability	Modified ASTM D1970	Shall pass 31 mm (1.2 in) of water	Pass
Solids Content			99%
Specific Gravity			1.40 – 1.55
Surface Burning Characteristics	ASTM E84	Flame Spread ≤ 25 Smoke Developed ≤ 450	Meets Class A Flame Spread: 15 Smoke Developed: 5
Thermal Cycling / Peel Adhesion	AAMA 711 / ASTM C794	≥ 5 pli after 10 cycles	Pass
Water Vapor Permeability	ASTM E96 Wet Cup		>10 perms
VOC Content			30 g/L maximum
Weight/Gallon			11.75 – 12.5 lbs

