ACTFLEX 75FC.



Technical Data Sheet | Multi-Purpose Fast-Cure Polyurethane Adhesive Joint Sealant | Issue date: 12 August 2026

Description

ACTFLEX 75FC is a fast-curing, single-component polyurethane joint sealant and construction adhesive engineered for movement joints, junctions, penetrations and bonding across the building envelope. Its moisture-cure chemistry develops a permanently elastic, high-recovery seal with excellent tear resistance, accommodating differential movement between materials with disparate coefficients of expansion. It guns cleanly without sag on vertical and horizontal joints, tools to a smooth finish, and bonds to concrete, masonry, fibre cement, metal, timber and primed PVC. Within FORSPEC waterproofing systems, ACTFLEX 75FC is the specified joint sealant for sealed crack and junction details in accordance with the relevant membrane TDS.

Advantages

- One-part, ready to use — guns straight from the pack with no mixing.
- Fast moisture cure — approximately 3.5 mm per 24 hours at 25°C and 50% RH, to a permanently elastic consistency.
- High recovery and excellent tear resistance — engineered for sealing moving joints.
- Non-sag — holds profile in vertical and overhead joints.
- Very good adhesion across concrete, masonry, fibre cement, metal, timber and primed PVC.
- Low odour, non-staining and non-corrosive.
- Shock resistance and vibration damping in bonded assemblies.
- Over-paintable after full cure (preliminary trials recommended).
- Weather and ageing resistant — high long-term durability.

Uses

- Elastic joint sealing of vertical and horizontal movement and control joints in concrete and masonry.
- Sealed crack and junction details within FORSPEC waterproofing systems, per the relevant membrane TDS.
- Joint sealing beneath and adjoining solvent-based waterproofing applications.
- Sealing penetrations in walls and floors — pipes, services and fixings.
- Bonding: metal angles to concrete, fibre cement sheeting, timber, and PVC (with the specified primer).
- Industrial and transport assembly — vehicle bodies, panels, underbody components, and waterproofing of exterior lap seams (truck trailers, metal roofs, window perimeters).

Compliance Status

No Australian Standard prescribes performance classes for single-component polyurethane construction sealants of this type; ACTFLEX 75FC publishes typical Forspec R&D characteristics against the international test methods cited in the Technical Data. Within FORSPEC waterproofing systems, joints and details incorporating ACTFLEX 75FC are designed and installed in accordance with the relevant membrane TDS, AS 3740 for internal wet areas and AS 4654.2 for external above-ground applications. Hazard classification: refer to the current SDS.

Technical Data

PROPERTY	VALUE	BASIS
Chemical base	Single-component polyurethane	—
Cure mechanism	Moisture-curing	—

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Technical Data (continued)

PROPERTY	VALUE	BASIS
Colour	Grey	—
Packaging	600 mL sausage	—
Density	1.40 ± 0.05 kg/L	DIN 53479 *
Shore A hardness	Approx. 38	DIN 53505 *
Tensile strength	Approx. 2 N/mm²	DIN 53504 *
Elongation at break	550%	GB/T 528 *
Tear propagation resistance	≥ 6 N/mm	*
Movement accommodation factor (MAF)	12.5%	*
Shrinkage	Approx. 5%	*
Sag	≤ 1 mm (20 mm profile at 25°C)	*
Skin time (at 25°C, 50% RH)	Approx. 65 minutes	*
Cure rate (at 25°C, 50% RH)	Approx. 3.5 mm per 24 hours	*
Water-immersion service	Only after a minimum 5 days cure (at 25°C, 50% RH)	*
Application temperature	10–26°C (ambient and substrate)	—
Service temperature	-10°C to +65°C	*
Shelf life	12 months, unopened, stored as specified	—

* Typical characteristic values determined by Forspec R&D on standard production material at 25°C and 50% relative humidity. Values are not to be relied upon for engineering design without written confirmation from FORSPEC Technical Services.

Joint Design

- Minimum joint size: 6 mm x 6 mm. Sealant depth: 6–15 mm.
- Joints wider than 12 mm: proportion at a 2:1 width-to-depth ratio.
- Movement joints: size the joint so expected movement does not exceed the 12.5% movement accommodation factor — total joint width at least 8 times the calculated movement at the joint.
- Install closed-cell polyethylene backing rod approximately 25% larger than the joint width, compressed to the design depth, so the sealant bonds to two sides only. Over rigid backing or where depth cannot accept a rod, install bond-breaker tape — three-sided adhesion causes premature failure and is never permitted.
- The substrate must possess sufficient strength to withstand the stresses imposed by the sealant during movement.
- Confirm project-specific joint design, spacing and dimensions with FORSPEC Technical Services where movement is engineered or unknown.

Coverage and Yield

JOINT SIZE (WIDTH X DEPTH)	SEALANT DEMAND	APPROX. METRES PER 600 ML SAUSAGE
6 mm x 6 mm	36 mL/m	Approx. 16.5 m
10 mm x 6 mm	60 mL/m	Approx. 10.0 m
12 mm x 6 mm	72 mL/m	Approx. 8.3 m

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Coverage and Yield (continued)

JOINT SIZE (WIDTH X DEPTH)	SEALANT DEMAND	APPROX. METRES PER 600 ML SAUSAGE
10 mm x 10 mm	100 mL/m	Approx. 6.0 m
20 mm x 10 mm	200 mL/m	Approx. 3.0 m

Basis: joint width x depth in millimetres equals sealant demand in millilitres per metre (1 mm^2 cross-section over 1 m ≡ 1 mL). Allow approximately 10% additionally for tooling and wastage. Yields are theoretical and reduce with irregular joint faces.

Limitations

- Apply only between 10–26°C (ambient and substrate), to completely dry, sound substrates — never to damp, frosted or contaminated surfaces.
- Never permit three-sided adhesion — always install backing rod or bond-breaker tape per the Joint Design section.
- Movement at the joint must not exceed the 12.5% movement accommodation factor.
- Water-immersion service only after a minimum of 5 days cure at 25°C and 50% RH.
- Cure rate depends on atmospheric humidity — moisture cure slows significantly in cool or dry air and at depth.
- Over-painting only after full cure, with preliminary compatibility trials — some paint systems remain tacky or crack over elastic sealants.
- Not for structural glazing, and not for continuous chlorinated-water immersion (pools).
- Compatibility with bituminous surfaces, plasticised materials and existing sealants must be confirmed before application.
- Complete a trial area where substrate, primer or over-coating compatibility is uncertain.

Surface Preparation

- All joint faces must be structurally sound, clean, completely dry and free of oils, grease, paint, laitance, efflorescence, curing compounds and any bond-inhibiting contaminant.
- Remove protrusions that could puncture the sealant; repair imperfections, voids and blowholes with a high-strength, non-shrink mortar and allow to cure.
- Confirm all surfaces, including screeds, are solid and not friable — the joint faces carry the movement stresses.
- Where detergent-assisted cleaning is used, rinse the detergent off completely with clean water and allow to dry before priming.
- Insert backing rod to the required depth after priming, per the Joint Design section.

Priming

- ACTFLEX 700 PU PRIMER — completely dry internal surfaces, including where the joint will be over-coated with a solvent-based waterproofing product.
- ACTFLEX SUPERBOND 007 — non-porous surfaces including metal, wood and PVC.
- ACTFLEX EP250 — external or uneven cementitious surfaces.
- Allow every primer to dry fully per its TDS before sealing — correct priming governs the long-term adhesion of the sealed joint.
- Never over-apply primer — pooling at the joint base impairs adhesion.

Application

- **Gunning**
  Open the 600 mL sausage, load it into a barrel-type sealant gun, and trim the nozzle to the bead size required by the joint. Extrude ACTFLEX 75FC firmly into the joint in a continuous pass, keeping the nozzle deep in the joint so the sealant wets both faces fully and no air is entrained. Wider joints take multiple passes to fill against the backing rod and both joint faces completely. For clean lines, mask both edges and strip the tape while the sealant is still pliable.

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Application (continued)

- **Tooling**
  Tool immediately after gunning, pressing the sealant firmly against both joint faces with a curved spatula to consolidate adhesion and finish the surface. A 20% household detergent solution on the tool prevents pick-up — keep the solution off the joint faces ahead of the sealant, and never let it pool in the joint.
- **Curing and following works**
  ACTFLEX 75FC skins in approximately 65 minutes and cures at approximately 3.5 mm per 24 hours, at 25°C and 50% RH — slower in cool or dry conditions and at depth. Membranes may be applied over the sealed joint once the sealant is fully skinned and tack-free — a minimum of 24 hours at 25°C and 50% RH, and longer for deep fills — in accordance with the relevant FORSPEC membrane TDS. Water-immersion service only after a minimum of 5 days cure. Over-paint only after full cure, following a compatibility trial.

Drying, Curing and Testing Times

All times below are measured at 25°C and 50% RH. Low temperature, high humidity, poor ventilation and increased thickness extend every stage — verify on site before proceeding.

STAGE (AT 25°C, 50% RH)	TIME
Tooling window	Before skin formation *
Skin time	Approx. 65 minutes *
Cure rate	Approx. 3.5 mm per 24 hours *
Membrane overcoating	Once the sealant is skinned, firm and tack-free *
Water-immersion service	Minimum 5 days cure *

Cure is slower in cool or dry conditions and at depth. * Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Clean Up

Remove excess uncured sealant immediately with a dry cloth, and clean tools with a suitable solvent wipe before the sealant skins. Cured ACTFLEX 75FC can only be removed mechanically. Do not allow wash water or cleaning residues to enter drains, sewers or waterways.

Container and Waste Disposal

Allow residues to fully cure before disposal as construction waste, in accordance with local council requirements. Do not seal or stopper drums or containers being decontaminated — the moisture-curing reaction generates CO_2 gas and may pressurise sealed containers. Refer to Section 13 of the SDS for detailed disposal requirements.

Quality Records

Record the batch numbers of all ACTFLEX 75FC and primers used, joint dimensions and backing rod sizes, primer system applied, application dates and conditions, and cure times before over-coating or immersion, as part of the project quality assurance records.

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Storage

Store in original, unopened packaging in cool, dry conditions between 10°C and 25°C, protected from moisture, direct sunlight and frost — the product cures on atmospheric moisture and opened packs must be used promptly. Shelf life: 12 months from the date of manufacture when stored as specified.

Safety Precautions and First Aid

ACTFLEX 75FC is classified per its current Safety Data Sheet. Use in well-ventilated areas, keep ignition sources away from the uncured product, and wear chemical-resistant gloves, protective clothing and eye protection. Change soiled work clothing immediately and wash hands before breaks and after work. Prevent release to drains, soil and waterways.

First aid — Eyes: rinse immediately with plenty of water for at least 15 minutes and seek medical attention. Skin: wash with soap and water; remove contaminated clothing. Inhaled: move to fresh air; seek medical attention if discomfort persists or breathing difficulty occurs. Swallowed: do not induce vomiting; seek medical advice. POISONS INFORMATION CENTRE: 13 11 26 (Australia-wide, 24 hours). In an emergency, dial 000. KEEP OUT OF REACH OF CHILDREN. Read the Safety Data Sheet (SDS) before use — available at www.forspec.com.au.

Warranty

Standard Product and Performance Warranty: Forspec Protective Coatings Pty Ltd as Trustee for Forspec Protective Coatings (ABN 11 204 033 631) warrants that ACTFLEX 75FC will be free from manufacturing defects and will not fail under normal usage for a period of ten (10) years from the date of purchase, when installed and used strictly in accordance with this Technical Data Sheet and Forspec's written instructions. This warranty covers the supply of the product only; it does not cover installation, application or workmanship. Remedies are limited, at Forspec's discretion, to replacement of the defective product (or defective portion) or a refund of the purchase price. The full terms, conditions and exclusions are set out in the Forspec Standard Product and Performance Warranty, available at www.forspec.com.au — key conditions include application by a suitably qualified and, where required by law, licensed applicator; use within shelf life; and installation as part of a Forspec approved system without non-approved third-party products.

Project and system warranties: extended project-specific warranties are available at the request of the applicator and must be applied for using the Forspec Warranty Request Form prior to commencement of works. Issue is subject to Forspec approval and is conditional on the use of the complete specified FORSPEC system, application in strict accordance with the current TDS by suitably qualified applicators, and completion of the project quality records described above. The warranty period and terms are as stated in the issued warranty certificate.

Claims: notify Forspec in writing within thirty (30) days of discovery of the alleged defect and within the warranty period, by post to 22/872 Canterbury Road, Roselands NSW 2196 or by email to info@forspec.com.au, including proof of purchase, installation details (date, location, installer), a description of the defect with supporting evidence, and your contact details. Forspec may inspect the site, perform testing and collect samples before determining a claim.

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Data Sheet Currency

This Technical Data Sheet (TDS) and the corresponding Safety Data Sheet (SDS) are subject to revision as necessary to ensure compliance with relevant Australian Standards and to incorporate technological advancement. Read the most current versions before use, as application and performance data may be updated. For the latest technical information, contact Forspec Protective Coatings on (02) 8021 3517 or info@forspec.com.au. The information provided is representative and does not serve as a comprehensive specification. For specific projects, consult directly with Forspec Protective Coatings for tailored specifications. This data sheet was issued on 12/08/2026 and is valid for three years from the date of issue unless superseded by a later revision — always confirm the current version at www.forspec.com.au before use.

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