



The Chemical Company

MASTERFLOW[®] 626

Heavy duty, epoxy resin based grout

DESCRIPTION

MASTERFLOW 626 is a modified epoxy resin based system, which on mixing yields a rapid hardening, high strength, high flow, chemical resistant grout. It comprises 3 components - resin, hardener and specially blended inert aggregates. The product is designed to have a high flow property but for applications that do not require a high flow, it is also available in a normal flow version.

FIELDS OF APPLICATION

MASTERFLOW 626 is recommended for use as a precision, heavy duty polymer grout. It is suitable for engineering applications such as grouting of machinery that exerts high static and dynamic loads (both compressive and tensile) on the foundation, or where the grouted area is prone to spillage of corrosive chemicals. Also it is ideal for grouting production line equipment to reduce down time before recommissioning after maintenance.

Examples of **MASTERFLOW 626** applications are :

- grouting of reverberating machinery such as forging hammers, heavy duty compressors and diesel generating sets.
- grouting of elements bearing heavy loads such as bridge bearings and crane rails.
- grouting of pumps and motors prone to chemical spillage in fertilisers, paper and chemical industries
- grouting of rolling mills, plate mills, etc., after maintenance for rapid recommissioning.

Being a flowable grout, **MASTERFLOW 626** is not suitable for overhead and horizontal anchoring.

FEATURES AND BENEFITS

High tensile and flexural strengths	Efficient transfer of operational loads to foundation. Withstands dynamic loads.
High bond strength	Ensures efficient vibration dampening.
High flow	Allows complete filling of space below the base plate providing total support to bearing area.
Excellent chemical resistance	Durability unaffected when exposed to chemicals such as mineral acids, oils, fats, fuels and strong alkalis.
High early strengths	Early load transfer and rapid commissioning of machines.

Pre packed

No batching or blending errors. Consistent performance from every pack.

Fast curing

Faster serviceability of the repaired area.

TYPICAL PERFORMANCE DATA

(Strengths in N/mm²)

Age	Compressive	Flexural	Tensile
16 hrs	60	22	12
24 hrs	70	25	13
7 days	90	35	15

PROPERTIES

	Comp A	Comp B	Comp C
Supply form	Liquid	Liquid	Aggregate
Colour	Turbid White	Amber	Grey

Mixed

Density	with high flow aggregate	: 2.06 kg/L
	with standard aggregate	: 2.15 kg/L
Pot life @ 23°C		: 30 - 45 mins.
Application temperature		: 5°C - 35°C
Application temperature range		: 5°C to 35°C

Curing properties

Initial cure @ 23°C	: 4 - 6 hrs
Final cure @ 23°C	: 7 days

APPLICATION

Surface Preparation

Correct preparation of concrete substrate is critical for optimum performance.

Surfaces should be structurally sound, clean, dry, rough and free from loose particles, oil, grease, or any other contaminant. Cement laitence, loose particles, mould release agent, curing membrane, and other contaminants must be removed from the surface using an appropriate method followed by vacuum cleaning. Clean the bottom of base plates free of rust, mill scale, oil, grease and other such contaminants.

Formwork

Grouting of base plates and crane rails require formwork but holding down bolts and anchor rods do not.

Proper design of formwork based on the geometry of

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MASTERFLOW[®] 626

the space being grouted is essential for effective grouting. The formwork can be made from timber, steel, or any other suitable material depending on the circumstances. It must be grout tight, strong, and well braced to withstand the fluid pressure of the grout until it sets. Before erecting it coat the inner surfaces with grease for easy release.

Ensure that the distance between perimeter formwork and the base plate edge is 100 mm to 150 mm at the pouring side, 20 mm to 50 mm at the opposite (grout emerging) side and the minimum possible at the remaining sides (flush to base plate edge possible). Provide a header box of at least 200 mm height, along the entire pouring side, to allow for sufficient build up of head while grouting. Seal all the gaps in formwork and those between formwork and concrete surface, with a suitable rapid setting material.

Before commencing the grouting operation, blow clean the grouting area with oil-free compressed air.

Mixing

Mechanical mixing is necessary. A slow speed (600 rpm) drill fitted with a grout stirrer is recommended.

Empty Component B completely into Component A container and stir until the two components are fully mixed. Pour the mixture into a clean dry pail and keeping the mixer running, add Component C slowly. Mix for a further 3-4 minutes or until a lump free homogeneous mix is obtained.

It is important to ensure that the rate of mixing is adequate to cater for grouting continuously to completion, since interruptions in grout placing can cause air entrapment or difficulties in complete filling of the void.

Placing

Place the mixed grout within 30 minutes after mixing.

Base plate grouting : Pour continuously from only one side to ensure complete filling without air pockets.

MASTERFLOW 626 can be placed to a thickness of 10 mm to 40 mm in a single pour. Grouting to higher thicknesses can be achieved in multiple layers but every subsequent layer should be placed after the previous one has set hard. It is important to control the thickness of each layer, so that the final layer is at least 10 mm thick.

Bolt and anchor rod grouting : Holding down bolts should be hooked at the bottom (J - bolt) or fitted with an anchor plate. Anchor rods must be rough for optimum pull out strength and the diameter of holes should be at least 20 mm more than that of anchor rods.

While anchoring, place the required quantity of grout first in the hole and then introduce the anchor rod by pushing it gently, so that the displaced grout fills the annulus around the rod.

CURING

MASTERFLOW 626 is self curing and does not need any additional curing system.

EQUIPMENT

Mixing : Heavy duty slow speed drill fitted with a grout stirrer.

CLEANING

Clean the tools and equipment first with rags, then wipe off using a solvent such as acetone, or methylene chloride before the grout hardens.

ESTIMATING DATA

Each pack of 26.9 kg yields 13.06 L on mixing. However, In case of the normal flow version, the three components together weigh 29.9 kg and yield 14.5 L on mixing.

PACKAGING

MASTERFLOW 626 is available in a set of 3 components as below.

Component	Description	Packaging
A	Resin	3.56 kg pail
B	Hardener	1.34 kg can
C	High flow aggregate	22.0 kg bag

For normal flow version, use the alternative Component C available as **MASTERFLOW 626** Standard Aggregate in 25 kg bags.

SHELF LIFE

MASTERFLOW 626 can be stored in unopened original packing for 12 months, if kept dry and at moderate temperatures.

PRECAUTIONS

For detailed Health, Safety and Environmental recommendations, please refer and follow all instructions on the product Material Safety Data Sheet.

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STATEMENT OF RESPONSIBILITY

The technical information and application advice given in this **BASF Construction Chemicals** publication are based on the present state of our best scientific and practical knowledge. As the information herein is of a general nature, no assumption can be made as to a product's suitability for a particular use or application and no warranty as to its accuracy, reliability or completeness either expressed or implied is given other than those required by law. The user is responsible for checking the suitability of products for their intended use.

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