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Epoxy
Grouting

MasterFlow® 640

Grout accelerator for MasterFlow 648/649/678

PACKAGING

1 quart can

YIELD

Order 1 quart can of MasterFlow 640 for each full-size kit of MasterFlow 648 (1.7 ft³), MasterFlow 649 (1.7 ft³) or MasterFlow 678 (1.8 ft³)

STORAGE

Store in unopened containers at 60–80 °F (16–27 °C) in clean, dry conditions.

SHELF LIFE

1 year when properly stored

VOC CONTENT

0 g/L less water and exempt solvents

DESCRIPTION

When MasterFlow 640 is added to MasterFlow 648, MasterFlow 649 or MasterFlow 678, it accelerates the cure rate at low temperatures. MasterFlow 640 should be used in temperatures below 60 °F (16 °C).

PRODUCT HIGHLIGHTS

- Accelerated cure rate enables cold-weather applications
- Early strength development facilitates early return to service

APPLICATIONS

- Where heating exterior spaces is impractical
- When temperatures fall below 60 °F (16 °C)
- Where high early strengths are required

HOW TO APPLY

MIXING

1. Add 1 can MasterFlow 648, MasterFlow 649 or MasterFlow 678 Part B and 1 can MasterFlow 640 to the pail of MasterFlow 648, MasterFlow 649 or MasterFlow 678 Part A, and stir for 3 minutes. Use immediately. Do not let stand for more than 2 minutes before placing.
2. Proceed with grouting according to directions in the MasterFlow 648, MasterFlow 649 or MasterFlow 678 Technical Data Guide.

FOR BEST PERFORMANCE

- Adding Accelerator does not improve the workability of grouts in cold-weather applications.
- For professional use only; not for sale to or use by the general public.
- Make certain the most current versions of product data sheet and SDS are being used; visit www.master-builders-solutions.com/en-us to verify the most current version.
- Proper application is the responsibility of the user. Field visits by Master Builders Solutions personnel are for the purpose of making technical recommendations only and are not for supervising or providing quality control on the jobsite.

Technical Data

Compressive Strength

(ASTM C 579, Method B, modified 2 by 2" cubes)

Before mixing, all materials were conditioned for 24 hours at the respective cure temperatures given below.

Tests Conducted with MasterFlow 648

CURE TIME	RESULTS	
Material cured at 50 °F (10 °C)		
	Non-Accelerated	Accelerated
Hours	psi (MPa)	psi (MPa)
24	750 (5)	6,400 (44)
72	10,500 (37)	12,000 (82)
168	12,300 (84)	13,300 (91)

Tests Conducted with MasterFlow 678

CURE TIME	RESULTS	
Material cured at 50 °F (10 °C)		
	Non-Accelerated	Accelerated
Hours	psi (MPa)	psi (MPa)
24	—	3,500 (24)
72	5,400 (37)	8,500 (58)
168	8,500 (58)	9,500 (65)

Tests conducted with MasterFlow 649.

CURE TIME	RESULTS	
Material cured at 40 °F (4 °C)		
	Non-Accelerated	Accelerated
Hours	psi (MPa)	psi (MPa)
16	—	—
24	—	100 (0.7)
48	800 (5.5)	4,000 (27.6)
72	3,900 (26.9)	8,700 (60.0)
96	5,000 (34.5)	9,400 (64.8)
120	6,800 (46.9)	11,400 (78.6)
144	7,100 (49.0)	12,000 (82.7)
168	8,000 (55.2)	13,100 (90.3)

CURE TIME	RESULTS	
Material cured at 50 °F (10 °C)		
	Non-Accelerated	Accelerated
Hours	psi (MPa)	psi (MPa)
16	—	—
24	—	3,900 (26.9)
48	4,900 (33.8)	12,400 (85.5)
72	9,200 (63.4)	14,000 (96.5)
96	11,500 (79.3)	15,500 (106.9)
120	12,800 (88.3)	17,000 (117.2)
144	14,500 (100.0)	17,400 (120.0)
168	14,800 (102.0)	17,400 (120.0)

CURE TIME	RESULTS	
Material cured at 60 °F (16 °C)		
	Non-Accelerated	Accelerated
Hours	psi (MPa)	psi (MPa)
16	—	6,800 (46.9)
24	2,600 (17.9)	10,500 (72.4)
48	9,000 (62.1)	13,000 (89.6)
72	13,500 (93.1)	16,000 (110.3)
96	16,500 (113.8)	17,500 (120.7)
120	17,200 (118.6)	17,700 (122.0)
144	17,400 (120.0)	18,000 (124.1)
168	17,400 (120.0)	18,000 (124.1)

Temperatures vary so radically (day vs. night, atmospheric vs. metal surface) that field judgment must still be used. When struck with a hammer, cured grout should have a solid, almost metallic feel.

HEALTH, SAFETY AND ENVIRONMENTAL

Read, understand and follow all Safety Data Sheets and product label information for this product prior to use. The SDS can be obtained by visiting www.master-builders-solutions.com/en-us, e-mailing your request to mbsbcst@mbcc-group.com or calling 1(800)433-9517. Use only as directed.

IN CASE OF EMERGENCY: Call CHEMTEL +1 (800) 255-3924 or if outside the US or Canada, +1 (813) 248-0585.

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