



We create chemistry

Technical Data Guide

3 | 03 63 00
Epoxy
Grouting

MasterFlow® 640

Grout accelerator for MasterFlow 648/649

FORMERLY MASTERFLOW® 648 CP ACCELERATOR

PACKAGING

1 quart can

YIELD

Order 1 quart can of MasterFlow 640 for each full-size (1.73cf) kit of MasterFlow 648 or MasterFlow 649.

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 or MasterFlow 649, 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 or MasterFlow 649 Part B and 1 can MasterFlow 640 to the pail of MasterFlow 648 or MasterFlow 649 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 or MasterFlow 649 Installation 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 master-builders-solutions.basf.us to verify the most current version.
- Proper application is the responsibility of the user. Field visits by BASF 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)

Tests conducted with MasterFlow 649.

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

| CURE TIME | | | RESULTS | | | CURE TIME | | | RESULTS | | | CURE TIME | | | RESULTS | | |
|--------------------------------|------------------------------|--------------------------|---------|------------------------------|--------------------------|--------------------------------|------------------------------|--------------------------|---------|------------------------------|--------------------------|---------------------------------|------------------------------|--------------------------|---------|------------------------------|--------------------------|
| Material cured at 40° F (4° C) | | | | | | Material cured at 50° F (4° C) | | | | | | Material cured at 60° F (16° C) | | | | | |
| Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) | Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) | Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) | Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) | Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) | Hours | Non-Accelerated psi (MPa) | Accelerated psi (MPa) |
| 16 | — | — | 16 | — | — | 16 | — | 6,800 (46.9) | 16 | — | 6,800 (46.9) | 16 | — | 6,800 (46.9) | 16 | — | 6,800 (46.9) |
| 24 | — | 100 (0.7) | 24 | — | 3,900 (26.9) | 24 | 2,600 (17.9) | 10,500 (72.4) | 24 | 2,600 (17.9) | 10,500 (72.4) | 24 | 2,600 (17.9) | 10,500 (72.4) | 24 | 2,600 (17.9) | 10,500 (72.4) |
| 48 | 800 (5.5) | 4,000 (27.6) | 48 | 4,900 (33.8) | 12,400 (85.5) | 48 | 9,000 (62.1) | 13,000 (89.6) | 48 | 9,000 (62.1) | 13,000 (89.6) | 48 | 9,000 (62.1) | 13,000 (89.6) | 48 | 9,000 (62.1) | 13,000 (89.6) |
| 72 | 3,900 (26.9) | 8,700 (60.0) | 72 | 9,200 (63.4) | 14,000 (96.5) | 72 | 13,500 (93.1) | 16,000 (110.3) | 72 | 13,500 (93.1) | 16,000 (110.3) | 72 | 13,500 (93.1) | 16,000 (110.3) | 72 | 13,500 (93.1) | 16,000 (110.3) |
| 96 | 5,000 (34.5) | 9,400 (64.8) | 96 | 11,500 (79.3) | 15,500 (106.9) | 96 | 16,500 (113.8) | 17,500 (120.7) | 96 | 16,500 (113.8) | 17,500 (120.7) | 96 | 16,500 (113.8) | 17,500 (120.7) | 96 | 16,500 (113.8) | 17,500 (120.7) |
| 120 | 6,800 (46.9) | 11,400 (78.6) | 120 | 12,800 (88.3) | 17,000 (117.2) | 120 | 17,200 (118.6) | 17,700 (122.0) | 120 | 17,200 (118.6) | 17,700 (122.0) | 120 | 17,200 (118.6) | 17,700 (122.0) | 120 | 17,200 (118.6) | 17,700 (122.0) |
| 144 | 7,100 (49.0) | 12,000 (82.7) | 144 | 14,500 (100.0) | 17,400 (120.0) | 144 | 17,400 (120.0) | 18,000 (124.1) | 144 | 17,400 (120.0) | 18,000 (124.1) | 144 | 17,400 (120.0) | 18,000 (124.1) | 144 | 17,400 (120.0) | 18,000 (124.1) |
| 168 | 8,000 (55.2) | 13,100 (90.3) | 168 | 14,800 (102.0) | 17,400 (120.0) | 168 | 17,400 (120.0) | 18,000 (124.1) | 168 | 17,400 (120.0) | 18,000 (124.1) | 168 | 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.basf.us, e-mailing your request to basfbscst@basf.com or calling 1(800)433-9517. Use only as directed.

**For medical emergencies only,
call ChemTrec® 1(800)424-9300.**

LIMITED WARRANTY NOTICE

BASF warrants this product to be free from manufacturing defects and to meet the technical properties on the current Technical Data Guide, if used as directed within shelf life. Satisfactory results depend not only on quality products but also upon many factors beyond our control. BASF MAKES NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE WITH RESPECT TO ITS PRODUCTS. The sole and exclusive remedy of Purchaser for any claim concerning this product, including but not limited to, claims alleging breach of warranty, negligence, strict liability or otherwise, is the replacement of product or refund of the purchase price, at the sole option of BASF. Any claims concerning this product must be received in writing within one (1) year from the date of shipment and any claims not presented within that period are waived by Purchaser. BASF WILL NOT BE RESPONSIBLE FOR ANY SPECIAL, INCIDENTAL, CONSEQUENTIAL (INCLUDING LOST PROFITS) OR PUNITIVE DAMAGES OF ANY KIND.

Purchaser must determine the suitability of the products for the intended use and assumes all risks and liabilities in connection therewith. This information and all further technical advice are based on BASF's present knowledge and experience. However, BASF assumes no liability for providing such information and advice including the extent to which such information and advice may relate to existing third party intellectual property rights, especially patent rights, nor shall any legal relationship be created by or arise from the provision of such information and advice. BASF reserves the right to make any changes according to technological progress or further developments. The Purchaser of the Product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with a full application of the product(s). Performance of the product described herein should be verified by testing and carried out by qualified experts.