

MasterFlux™ ER 402 FC

Fast Setting, Epoxy Based Ultra High Strength Grout and Repair Mortar

Material Description

MasterFlux™ ER 402 FC is epoxy based fast setting grout and repair mortar with three parts including well graded quartz aggregate.

Complies with EN 1504-3/R4 and EN 1504-6

Areas of Application

- Repair of runways and tracks in airports,
- Repair of concrete pavements,
- Fixing of prefabricated beams in bridge joints,
- Mounting heavy machines to the foundations,
- Machine foundations under heavy dynamic loads,
- Repair of crane runways and high strength required mountings,
- Column-beam connections in the reinforced concrete bridge structures.

- Mounting the steel columns to the reinforced concrete foundations.
- Repair and maintenance of reinforced concrete marine structures,
- Repair of underground reinforced concrete structures,
- Repair and insulating of wide cracks on vertical structural elements, beams and ceilings.

Characteristics and Benefits

- Can be opened to service in 2 hours.
- Can be applied without primer.
- Resists to chemicals.
- High mechanical strengths.
- High abrasion and impact resistance.
- High bonding strength to the concrete and steel.
- Non-shrink.
- Solvent free.

Technical Properties

Structure of the Material					
MasterFlux™ ER 402 FC Part A	Epoxy Resin				
MasterFlux™ ER 402 FC Part B	Epoxy Hardener				
MasterFlux™ ER 402 FC Part C	Quartz Aggregate				
Color	Grey				
Mixed Density	1,90 ± 0,1 kg/litre				
Compressive Strength TS EN 196	2 hours	> 20 N/mm ²			
	7 hours	> 50 N/mm ²			
	24 hours	> 90 N/mm ²			
Flexural Strength (TS EN 196)	>20 N/mm ²				
Bondingl Strength (7 days)	To concrete To steel	>2,0 N/mm ² >3,0 N/mm ²			
Application Thickness	Min. 4 mm Max. 50 mm				
Application Temperature	+5°C +35°C				
Service Temperature	-15°C +80°C				
Pot Life	30 minutes				
Open Time for Vehicular Traffic (20°C)	2 hours				
Fully Cured at 20°C	24 hours				

Typical values are obtained from the test results in 23°C and 50% relative humidity conditions. High temperatures shortens the curing and working time, lower temperatures extends the durations.

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Processing Method

(A) Preparation of Substrate

The concrete surfaces must be sound, clean and dry. It shouldn't be weakened by overtroweling and lack of curing. The concrete should be free of frost, curing membranes, waterproofing treatments, oil stains, laitance, friable material and dust. If there is a water leakage it must be drained or properly plugged. Steel surfaces should be cleaned from rust by sand blasting and if needed new reinforcement should be installed. The edges of the broken surfaces should be saw cut.

Preparation of Machine Foundation

Before the mounting of the machine the loose particles should be removed from the surface and concrete surfaces should be roughened before grouting. Steel base plates of the machine should be dry and cleaned from oil, grease, rust and dust, which cause de-bonding of the grout. Proper holes should be drilled on to the steel base plates for draining the air under the machine during grouting. After these steps machine should be mounted and fixed to the foundation. Apply proper release agent to the shims before application.

Formwork

Forms should be made of tough materials and well mounted for resisting to fresh grout pressures. There should be min. 5 cm between the formwork and machine base plate in the grouting direction for casting the material into the form. For ensuring the filling of the spaces under machine base plate, forms should be elevated in the casting side and enough hydrostatic pressure obtained. In some cases, forms should be elevated up to 1.5m in the casting side, using custom shaped pipes etc. Should be required for grouting under huge plates. For preventing the leakage and loose of hydrostatic pressure the formwork should be done properly.

(B) Mixing

MasterFlux™ ER 402 FC has three parts in two pails and in one bag, produced according to right mixing

ratio. Material temperature should be between 15-25°C before mixing. Part B should be added into the Part A without any remaining material in the pail. It should be mixed with using a proper mixer (400-600 rpm) for polymer mixing. Mix the parts at least 3 minutes to have a homogenous mixture. Then the mixture should be put in to a clean, dry, mixing bucket and the Part C should be added into the bucket. Mix the parts at least 3 minutes to have a homogenous mixture.

Mixing Ratio

MasterFlux™ ER 402 FC	Part A	Part B	Part C
Quantity	2,00 kg	1.125 kg	12,50 kg
Mixed Density		1,90 kg/litre	

(C) Processing

Repair

MasterFlux™ ER 402 FC should be applied to the prepared surface by using a steel spatula or steel trowel. Application thickness should be between 4-50 mm. Open areas should be protected from the rain, wind, and similar aggressive weather conditions during the first 2 hours after finishing repair.

Grouting

The vibration caused by the surrounding machines should be observed and if necessary all the machines shut down until the grout sets (2 hours in +20°C).

Grout should be cast in only one side of the form continuously and the grout thickness should be between 4-50mm in single layer. For preventing air gaps do not cast material in two side of the machine. Do not use vibrator. For compacting the grout a steel or plastic hooked bar should be used. Do not release the formwork before 2 hours (in +20°C). Open areas should be protected from the rain, wind and similar aggressive weather conditions during the first 2 hours after finishing repair.

In the case of unneeded excessive mortar outside of the machine plate, the grout can be broken after removing the formwork. Don't move the shims in two hours after grouting. After starting the machine all the bolts should be checked and refixed if needed.

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Consumption

2.0 kg/m² for obtaining 1 mm thick layer.

Point to Consider

- Be sure that the material has been mixed in right mixing ratio.
- During the application the substrate and environment temperature should be between 5-35°C.
- Resinous materials' pot life and curing times vary depending on the relative humidity, substrate and environment temperature. Reaction gets slow in low temperatures and it causes extension on pot life and working time. On the other hand high temperatures speed up the reaction, which results to short pot life and working time. For full curing of material, both the substrate and environment temperature shouldn't be under allowed application temperature.
- **MasterFlux™ ER 402 FC** is provided in ready to mix pails. Do not add any solvent etc. into the mixture during the application.
- Mixing should be made with proper mixers and do not allow mixing by hand.
- Open areas should be protected from the rain, wind, etc. Aggressive weather conditions during the first 2 hours after finishing repair.
- Do not use vibrator for compacting the grout.

Cleaning of Tools

All the tools and equipments must be cleaned by solvent after the application. After **MasterFlux™ ER 402 FC** is hardened, it can only be removed from the surface mechanically.

Packaging

15.625 kg set
Part A: 2.00 kg pail
Part B: 1.125 kg pail
Part C: 12.50 kg bag

Shelf Life

18 months after the production date under appropriate storing conditions. Opened packages have to be stored by tightly sealing the bag/cover and must be used in one week.

Storage

Must be stored in unopened original packing, and in cool (+5 - +25°C) and dry environment protected from freezing. In short-term storing, maximum 3 palettes can be stowed on top of each other and delivery has to be according to first in first out system. In long-term storing, the palettes must not be stowed on top of each other.

Health and Safety

It is dangerous to approach the application sites. During the application, a protective apparel, protective gloves, goggles and masks which comply with the Occupational Health and Safety Rules should be used. Due to the irritation effect of the uncured materials, the mixture should not come into contact with skin and eyes; in case of a contact, the affected area should be washed with plenty of water and soap; in case of swallowing, a physician should be consulted immediately. No food or beverages should be brought to the application area. The product should be stored and kept out of reach of children. For detailed information please consult the Material Safety Data Sheet.

Disclaimer

The technical information given in this publication is based on the present state of our best scientific and practical knowledge. **MBT Teknik Yapı Kimyasalları Sanayi ve Ticaret A.Ş.** is only responsible for the quality of the product. **MBT Teknik Yapı Kimyasalları Sanayi ve Ticaret A.Ş.** is not responsible for results that may occur because the product is used other than advised and/or out of instructions regarding the place and the method of use. This technical form is valid only till a new version is implemented and nullifies the old ones.

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