

# MasterFlow<sup>®</sup> 410

Low Exotherm, High Strength, Flowable Epoxy Resin Grout

## DESCRIPTION

**Masterflow 410** is a solvent-free low exotherm, filler extended grout, based on modified epoxy resin and is designed for use as a precision, heavy duty chocking grout for engineering applications. It is supplied as a three component system consisting of epoxy resin, combined with inert fillers and the hardener, to produce a high viscosity flowable liquid grout suitable to fill gaps or voids.

## RECOMMENDED USES

- Machinery with high dynamic loads and vibration.
- Backing of steel liners of ore crushing machinery in mines and quarries.
- In corrosive environments where chemicals, oils and solvents make cementitious grouts unsuitable.
- Production line equipment that must resume operations with minimum downtime.
- Machinery base plates, crane rails, anchor bolts, hold down bolts and heavy equipment where tensile strength greater than cementitious systems can provide are required.

## FEATURES AND BENEFITS

- **Resistance to vibration and impact** – Particularly applicable where cycles of compression/ tension make cementitious grouts unsuitable
- **Minimum shutdown** – Low exotherm allows for thick single pours especially for a shutdown.
- **Excellent chemical resistance** – Maximum protection against attack from mineral acids, oils, fats, fuels, and strong alkali and salt solutions and lubricating and hydraulic oils
- **High bond strength** – Tenacious adhesion to prepared surfaces and requires no priming.
- **Supplied in pre-measured kits** – Eliminates the need for complicated on-site measuring and ensured product performance

## PROPERTIES

Unfilled Grout (w/o Part C)	
Pot life @ 20°C	90 minutes
@ 30°C	60 minutes
@ 40°C	40 minutes
Density (Kg/L)	1.05 - 1.1
Compressive Strength @ 25°C (ASTM C579)	40 MPa @ 1 days 60 MPa @ 3 days 80 MPa @ 7 days
Flexural strength @ 25°C, (ISO 178)	40 MPa @ 7 days
Tensile Strength @ 25°C, (ASTM C 638)	11 MPa @ 7 days
Application Area	0.25 – 10mm gap grouting

Filled Grout (With Part C)	
Pot life @ 20°C	120 minutes
@ 30°C	90 minutes
@ 40°C	50 minutes
Compressive Strength @ 25°C (ASTM C579)	40 MPa @ 1 days 90 MPa @ 3 days 100 MPa @ 7 days
Flexural strength @ 25°C (ASTM C 580)	27.5 MPa @ 7 days
Tensile Strength @ 25°C (ASTM C 307)	11 MPa @ 7 days
Bond strength	>2. MPa (concrete failure)

The performance data is typical and based upon controlled laboratory conditions. Actual performance on the job site may vary from these values based on actual site conditions. If application temperature is less, then the strength development of epoxy grout will be slower.

## APPLICATION

For information about application, please obtain a copy of the BASF "Application Guide for Masterflow Epoxy Grouts" from your local representative.

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As per depth or thickness of pour, use below recommended table as guide for mixing

For Thickness of 10 - 80mm			
Pack Type	Part A	Part B	Filler F1
Bulk	1 x 10Kg	1 x 4Kg	4 x 14Kg
Small	1 x 2.5Kg	1 x 1Kg	1 x 14Kg
For Thickness of 60 - 150mm			
Pack Type	Part A	Part B	Filler F2
Bulk	1 x 10Kg	1 x 4Kg	4 x 17.5Kg
Small	1 x 2.5Kg	1 x 1Kg	1 x 17.5Kg
For Thickness of 150mm – 300mm			
Pack Type	Part A	Part B	Filler F3
Bulk	1 x 10Kg	1 x 4Kg	4 x 21Kg
Small	1 x 2.5Kg	1 x 1Kg	1 x 21Kg

## PACKAGING

**Masterflow 410** is available as a three component system. While Part A & Part B are common the third component is available in three pack sizes for different application thicknesses. Filler F1 for 10 to 80mm, Filler F2 for 60 to 150mm and Filler F3 for 150 to 300mm thicknesses.

Component	Small Pack	Bulk Pack
MasterFlow 410 Part A	2.5 Kg	10 Kg
MasterFlow 410 Part B	1 Kg	4 Kg
MasterFlow 410 Part C	14 Kg	
MasterFlow 410 Part C	17.5 Kg	
MasterFlow 410 Part C	21 Kg	

## SHELF LIFE

**Masterflow 410** has a shelf life of 12 months if stored unopened in original containers at moderate temperatures.

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## ESTIMATING DATA

Bulk Packing			
	A+B+ 4 x Part C	Mixed Density (Kg / L)	Yield (L)
With 14 Kg Pk	70Kg	2.0 - 2.1	35L
With 17.5 Kg Pk	84Kg	2.1 - 2.2	40L
With 21 Kg Pk	98Kg	2.2 - 2.3	44L
Small Packing			
	A+ B+ Part C	Mixed Density (Kg / L)	Yield (L)
With 14 Kg Pk	17.5 Kg	2.0 - 2.1	8.75L
With 17.5 Kg Pk	21 Kg	2.1 - 2.2	10L
With 21 Kg Pk	24.5 Kg	2.2 - 2.3	11L

## CURING

No damp curing or special curing compounds are required. Cure time will vary depending on quantity mixed and placed and ambient temperature. Initial set at 25°C will be in 4-6 hours. **Masterflow 410** will be fully cured with maximum physical strength and chemical resistance at 7 days at 25°C. Do not install equipment before full cure has been attained or creep may occur.

Note: Curing rates and strength gain are retarded at lower temperatures - curing will not occur below 5°C

## PRECAUTIONS

For the full health and safety hazard information and how to safely handle and use this product, please make sure that you obtain a copy of the BASF Material Safety Data Sheet (MSDS) from our office or our website.  
**MasterFlow 410/01/111**

