MasterFlow® 640
Grout accelerator for MasterFlow 648/649/678

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

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.

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.
HEALTH, SAFETY AND ENVIRONMENTAL

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### 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.

<table>
<thead>
<tr>
<th>Tests Conducted with MasterFlow 648</th>
<th>Tests Conducted with MasterFlow 678</th>
<th>Tests conducted with MasterFlow 649</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>CURE TIME</strong></td>
<td><strong>RESULTS</strong></td>
<td><strong>CURE TIME</strong></td>
</tr>
<tr>
<td>Material cured at 50 °F (10 °C)</td>
<td></td>
<td>Material cured at 50 °F (10 °C)</td>
</tr>
<tr>
<td>Hours</td>
<td>Non-Accelerated psi (MPa)</td>
<td>Accelerated psi (MPa)</td>
</tr>
<tr>
<td>24</td>
<td>750 (5)</td>
<td>6,400 (44)</td>
</tr>
<tr>
<td>72</td>
<td>10,500 (72)</td>
<td>12,000 (82)</td>
</tr>
<tr>
<td>168</td>
<td>12,300 (84)</td>
<td>13,300 (91)</td>
</tr>
</tbody>
</table>

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.

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