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Non-Metallic  
Non-Shrink Grouting

# MasterFlow<sup>®</sup> 928

Low dust, high-precision mineral-aggregate grout with extended working time

## PACKAGING

55 lb (25 kg) polyethylene-lined bags  
600 lb (272 kg) bulk bag  
3,300 lb (1,500 kg) bulk bags

## YIELD

One 55 lb (25 kg) bag of MasterFlow 928 grout mixed with 10.5 lbs (4.8 kg) or 1.26 gallons (4.8 L) of water (fluid consistency) provides approximately 0.50 ft<sup>3</sup> (0.014 m<sup>3</sup>) of grout.

Note: The water requirement may vary due to mixing efficiency, temperature, and other variables.

## STORAGE

Store in unopened containers in cool, clean, dry conditions

## SHELF LIFE

55 LB BAG: 1 year when properly stored  
600 LB BULK BAG: 3 months when properly stored.  
3,300 LB BULK BAG: 3 months when properly stored

## VOC CONTENT

0 g/L less water and exempt solvents

## DESCRIPTION

MasterFlow 928 grout is a hydraulic cement-based mineral aggregate non-shrink grout with extended working time. It is ideally suited for grouting machines or plates requiring precision load-bearing support. It can be placed from fluid to damp pack over a temperature range of 45 to 90 °F (7 to 32 °C).

## PRODUCT HIGHLIGHTS

- Meets the requirements of ASTM C1107 and US Army Corps of Engineers CRD C621 (Grades B and C), at a fluid consistency over a 30-minute working time
- 50% reduction of airborne dust for added worker comfort and safety
- NSF/ANSI 61 Std for use with potable water
- Pumpable
- Extended working time
- Can be mixed at a wide range of consistencies
- Freeze/thaw resistant making it suitable for exterior applications
- Hardens free of bleeding, segregation, or settlement shrinkage to provide maximum effective bearing area for optimum load transfer
- Contains high-quality, well-graded quartz aggregate for optimum strength and workability
- Sulfate resistant for marine, wastewater and other sulfate-containing environments

## APPLICATIONS

- Grouting of equipment, such as compressors and generators, pump bases and drive motors, tank bases, conveyors, etc.
- Grouting anchor bolts, rebar and dowel rods
- Grouting of precast wall panels, beams, columns, curtain walls, concrete systems and other structural and non-structural building components
- Repairing concrete, including grouting voids and rock pockets
- Applications requiring a pump-able grout

## SUBSTRATES

- Concrete

**Technical Data**

**Composition**

MasterFlow 928 is a hydraulic cement-based mineral-aggregate grout.

**Compliances**

- ASTM C 1107 and CRD 621, Grades B and C, requirements at a fluid consistency over a temperature range of 40–90 °F (4–32 °C)
- NSF/ANSI 61 Std for use with potable water

**Test Data**

PROPERTY	RESULTS			TEST METHOD
<b>Compressive strengths, psi (MPa)</b>				ASTM C 942, according to ASTM C 1107 of ASTM C 109
	<b>Plastic<sup>1</sup></b>	<b>Consistency Flowable<sup>2</sup></b>	<b>Fluid<sup>3</sup></b>	
1 day	4,500 (31)	4,000 (28)	3,500 (24)	
3 days	6,000 (41)	5,000 (34)	4,500 (31)	
7 days	7,500 (52)	6,700 (46)	6,500 (45)	
28 days	9,000 (62)	8,000 (55)	7,500 (52)	
<b>Volume change</b>	<b>% Change</b>	<b>% Requirement of ASTM C 1107</b>		ASTM C 1090
1 day	> 0	0.0 – 0.30		
3 days	0.04	0.0 – 0.30		
14 days	0.05	0.0 – 0.30		
28 days	0.06	0.0 – 0.30		
<b>Setting time, hr:min</b>	<b>Plastic<sup>1</sup></b>	<b>Consistency Flowable<sup>2</sup></b>	<b>Fluid<sup>3</sup></b>	ASTM C 191
Initial set	2:30	3:00	4:30	
Final set	4:00	5:00	6:00	
<b>Flexural strength,* psi (MPa)</b>				ASTM C 78
3 days	1,000 (6.9)			
7 days	1,050 (7.2)			
28 days	1,150 (7.9)			
<b>Modulus of elasticity,* psi (MPa)</b>				ASTM C 469, modified
3 days	2.82 x 10 <sup>6</sup> (1.94 x 10 <sup>4</sup> )			
7 days	3.02 x 10 <sup>6</sup> (2.08 x 10 <sup>4</sup> )			
28 days	3.24 x 10 <sup>6</sup> (2.23 x 10 <sup>4</sup> )			
<b>Coefficient of thermal expansion,* in/in/°F (cm/cm/°C)</b>	6.5 x 10 <sup>-6</sup> (11.7 x 10 <sup>-6</sup> )			ASTM C 531
<b>Split tensile and tensile strength,* psi (MPa)</b>				ASTM C 496 (splitting tensile) ASTM C 190 (tensile)
	<b>Splitting Tensile</b>		<b>Tensile</b>	
3 days	575 (4.0)		490 (3.4)	
7 days	630 (4.3)		500 (3.4)	
28 days	675 (4.7)		500 (3.4)	
<b>Resistance to rapid freezing and thawing, 300 Cycles</b>	Durability Factor > 90%			ASTM C 666, Procedure A
<b>Dust Reduction, %</b> MasterFlow 928 vs. Control	50%			DIN55992-2

<sup>1</sup>100–125% flow on flow table per ASTM C 230

<sup>2</sup>125–145% flow on flow table per ASTM C 230

<sup>3</sup>25 to 30 seconds through flow cone per ASTM C 939

\*Test conducted at a fluid consistency

This data was developed under controlled laboratory conditions. Expect reasonable variations

**Test Data (continued)**

PROPERTY		RESULTS		TEST METHOD
<b>Ultimate tensile strength and bond stress</b>				ASTM E 488, tests*
<b>Diameter</b> in (mm)	<b>Depth</b> in (mm)	<b>Tensile strength</b> lbs (kg)	<b>Bond stress</b> psi (MPa)	
5/8 (15.9)	4 (101.6)	23,500 (10,575)	2,991 (20.3)	
3/4 (19.1)	5 (127.0)	30,900 (13,905)	2,623 (18.1)	
1 (25.4)	6.75 (171.5)	65,500 (29,475)	3,090 (21.3)	

\*Average of 5 tests in ≥ 4,000 psi (27.6 MPa) concrete, using 125 ksi threaded rod in 2" (51 mm) diameter, damp, core-drilled holes.

**Notes**

1. Grout was mixed to a fluid consistency.
2. Recommended design stress: 2,275 psi (15.7 MPa).
3. For more detailed information regarding anchor bolt applications, contact Technical Service.
4. Tensile tests with headed fasteners were governed by concrete failure.

**Jobsite Testing**

If strength tests must be made at the jobsite, use 2" (51 mm) metal cube molds as specified by ASTM C 942 and the ASTM C 1107 modification of ASTM C 109. DO NOT use cylinder molds. Control field and laboratory tests on the basis of desired placement consistency rather than strictly on water content.

**HOW TO APPLY**

**SURFACE PREPARATION**

1. Steel surfaces must be free of dirt, oil, grease, or other contaminants.
2. Cure the foundation until design strength of the concrete is achieved and foundation is dry. Cure the foundation until design strength of the concrete is achieved and foundation is dry.
3. The surface to be grouted must be clean, SSD, strong, and roughened to a CSP of 5–10 following ICRI Guideline 310.2 to permit proper bond.
4. When dynamic, shear or tensile forces are anticipated, concrete surfaces should be chipped with a "chisel-point" hammer, to a roughness of (plus or minus) 3/8" (10 mm). Verify the absence of bruising following ICRI Guideline 210.3.
5. In lieu of mechanical surface preparation, MasterFinish EA 48 Deep surface retarder may be used on freshly placed concrete. Remove surface retarder after 24 hours by use of pressure washing to achieve an exposed aggregate finish. After pressure washing, regular curing practices should continue until design strength is reached.
6. Concrete surfaces should be saturated (ponded) with clean water for 8 hours or more depending on site conditions, prior to grouting.
7. All freestanding water must be removed from the foundation and bolt holes immediately before grouting.

8. Anchor bolt holes must be grouted and sufficiently set before the major portion of the grout is placed.
9. Shade the foundation from sunlight 24 hours before and 24 hours after grouting.

**FORMING**

1. Forms should be constructed to include a 1" chamfer strip at the top of the forms, be watertight, and non-absorbent. Seal forms with putty, sealant, caulk or polyurethane foam. Use sufficient bracing to prevent the grout from leaking or moving.
2. Moderately sized equipment should utilize a head box to enhance the grout placement.
3. Side and end forms should be a minimum 1" (25 mm) distant horizontally from the equipment to be grouted to permit expulsion of air and any remaining saturation water as the grout is placed.
4. Leave a minimum of 2" between the bearing plate and the form to allow for ease of placement.
5. Eliminate large, non-supported grout areas wherever possible.
6. Extend forms a minimum of 1" (25 mm) higher than the bottom of the equipment being grouted.
7. Expansion joints may be necessary. Consult your local Master Builders Solutions field representative for suggestions and recommendations.

**TEMPERATURE**

1. The ambient and initial temperature of the grout should be in the range of 45 to 90 °F (7 to 32 °C) for both mixing and placing. For precision grouting, store and mix grout to produce the desired mixed-grout temperature. If bagged material is hot, use cold water, and if bagged material is cold, use warm water to achieve a mixed-product temperature as close to 70 °F (21 °C) as possible.
2. If temperature extremes are anticipated or special placement procedures are planned, contact your local Master Builders Solutions representative for assistance.
3. When grouting at minimum temperatures, see that the foundation, plate, and grout temperatures do not fall below 40 °F (7 °C) until after final set. Protect the grout from freezing (32 °F or 0 °C) until it has attained a compressive strength of 3,000 psi (21 MPa) in accordance with ASTM C 109.

**Recommended Temperature Guidelines for Precision Grouting**

	MINIMUM °F (°C)	PREFERRED °F (°C)	MAXIMUM °F (°C)
Foundation and plates	45 (7)	50–80 (10–27)	90 (32)
Mixing water	45 (7)	50–80 (10–27)	90 (32)
Grout at mixed and placed temp.	45 (7)	50–90 (10–27)	90 (32)

## MIXING

By using the minimum amount of water to provide the desired workability, maximum strength will be achieved. Mix the grout with a mortar mixer or an electric drill with a paddle such as ICRI 320.5 type A, D, E, F, G or H. Put the measured amount of potable water into the mixer, add grout, then mix till a uniform consistency is attained. Do not use water in an amount or a temperature that will cause bleeding or segregation. Note: The water requirement may vary due to mixing efficiency, temperature, and other variables.

1. Place estimated water (use potable water only) into the mixer, then slowly add the grout. For a fluid consistency, start with 9 lbs (4 kg) (1.1 gallon [4.2L]) per 55 lb bag.
2. The water demand will depend on mixing efficiency, material, and ambient-temperature conditions. Adjust the water to achieve the desired flow. Recommended flow is 25–30 seconds using the ASTM C 939 Flow-Cone Method. Use the minimum amount of water required to achieve the necessary placement consistency.
3. Moderately sized batches of grout are best mixed in one or more clean mortar mixers. For large batches, use ready-mix trucks and 3,300 lb (1,500 kg) bags for maximum efficiency and economy.
4. Mix grout between 3 and 5 minutes after all material and water is in the mixer until a homogenous consistency is achieved. Use mechanical mixer only.
5. Do not mix more grout than can be placed in approximately 30 minutes.
6. Transport by wheelbarrow or buckets or pump to the equipment being grouted. Minimize the transporting distance.
7. Do not retemper grout by adding water and remixing after it stiffens.
8. Do not add plasticizers, accelerators, retarders, or other additives.
9. For placements greater than 6" (152 mm) in depth, product should be extended with aggregate. Aggregate extension is dependent upon the grout type, placement, application requirements, and is typically required for placement depths beyond the limitation of the neat material. The aggregate should be washed, graded, saturated, surface-dry (SSD),

high-density, free from deleterious materials, and comply with the requirements of ASTM C 33. Consult Master Builders Solutions Technical Service for additional guidance.

## PLACEMENT

1. Always place grout from only one side of the equipment to prevent air or water entrapment beneath the equipment. Place MasterFlow 928 in a continuous pour by use of a headbox or grouting pump. Discard grout that becomes unworkable. Make sure that the material fills the entire space being grouted and that it remains in contact with plate throughout the grouting process..
2. Immediately after placement, trim the surfaces with a trowel and cover the exposed grout with clean wet rags (not burlap). Keep rags moist until grout surface is ready for finishing or until final set.
3. The grout should offer stiff resistance to penetration with a pointed mason's trowel before the grout forms are removed or excessive grout is cut back. After removing the damp rags, immediately coat with a recommended curing compound compliant with ASTM C 309 or preferably ASTM C 1315.
4. Do not vibrate grout. Use steel straps inserted under the plate to help move the grout.
5. Minimum placement thickness is 1" (25 mm). Consult your Master Builders Solutions representative before placing lifts more than 6" (152 mm) in depth.

## CURING

Cure all exposed grout with an approved membrane curing compound compliant with ASTM C 309 or preferably ASTM C 1315. Apply curing compound immediately after the wet rags are removed to minimize potential moisture loss.

## WASTE DISPOSAL METHOD

This product when discarded or disposed of, is not listed as a hazardous waste in federal regulations. Dispose of in a landfill in accordance with local regulations. For additional information on personal protective equipment, first aid, and emergency procedures, refer to the product Safety Data Sheet (SDS) on the job site or contact the company at the address or phone numbers given below.

## 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](http://www.master-builders-solutions.com/en-us), e-mailing your request to [mbsbscst@mbcc-group.com](mailto:mbsbscst@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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