

EMACO® R320

- Description:** One component, polymer-modified, thixotropic, chloride and carbonation-resistant surface renovation mortar.
- Application:** Vertical and overhead applications in interior and exterior environments.
- Packaging:** EMACO R320 is packaged in 55 lb (25 kg) moisture-resistant bags. The yield is approximately 0.47 ft³ (0.013 m³) per 55 lb (25 kg) bag.
- Storage Life:** EMACO R320 has a shelf life of approximately 12 months when stored in a cool, dry environment. The expiration date is printed on each bag.
- Coverage:** A 55 lb (25 kg) bag of EMACO R320 mortar will cover approximately 5.6 ft² (0.53 m²) at a 1 in. (25 mm) thickness.

IMPORTANT: READ THIS FIRST

Master Builders does not warrant the performance of this product unless the instructions of this document and other related Master Builders documents are adhered to in all respects.

DIRECTIONS:

Surface Preparation:

1. Square cut or undercut the perimeter of the area to be patched to a minimum depth of 1/4 in. (6mm). Do not cut the reinforcement.
2. Chip unsound concrete within the area to be repaired to a minimum depth of 1/4 in. (6 mm) or to whatever additional depth is necessary to reach sound concrete. Limit the size of chipping hammers to 15 lbs to reduce micro fractures. Hydrodemolition may be used.
3. Remove areas that have been saturated with oil or grease.
4. Thoroughly clean the roughened surface and exposed reinforcement of rust, dirt, loose chips and dust. High pressure water works well. The surface should remain damp. **(In preparing steel, sandblast or shotblast after chipping. Refer to the International Concrete Repair Institute publication entitled "Surface Preparation Guidelines for the Repair of Deteriorated Concrete Resulting from Reinforcing Steel Oxidation").**
5. Saturate the area thoroughly with water prior to placing the mortar.
6. Immediately prior to mixing, blow off or remove all excess water from repair area. Surface should be saturated, surface dry (SSD).

Mixing:

Mechanical mixing is recommended with use of a slow speed drill (400 to 600 rpm) and a Jiffier-type paddle, or in an appropriate size mortar mixer. Add approximately 0.75 to 1.0 gal (2.8 to 3.8 L) of clean water to the mixing container to obtain a consistency such as is required for vertical or overhead applications. Add the contents of the bag to the container while continuing to mix. Mix to a uniform consistency. Typical mixing time is 3 to 5 minutes.

Do not mix longer than 5 minutes.

Application and Finishing:

Hand Troweling Applications - For hand troweling apply a bond coat slurry to the prepared surface before application of EMACO R320. Thoroughly scrub mixed EMACO R320 into the saturated surface with a stiff bristle broom or brush. Do not apply more of this bond coat than can be covered with the mortar before the bond coat dries. Do not retemper this bond coat.

Spray Applications - When applying by low pressure spraying, use a Moyno, screw type or piston pump as would commonly be used for plastering. Spray applications do not require a bond coat slurry.

Vertical and Overhead Applications - EMACO R320 mortar can be applied by hand troweling or low pressure spraying on vertical and overhead surfaces in depths ranging from 1/4 in. to 1-1/2 in. (6 mm to 38 mm) in one lift.

Finishing - Before leveling surfaces, apply Master Builders CONFILM® Evaporation Reducer to facilitate finishing. To level the surface, a wooden float may be used. The final surface should be finished using a wood, plastic or synthetic sponge trowel.

Where rapid evaporation may occur, in hot, dry or windy conditions, apply Master Builders CONFILM® Evaporation Reducer after finishing the surface.

Curing:

EMACO R320 mortar must be cured properly. Apply MASTERKURE® 200W curing compound in accordance with label instructions as soon as the surface cannot be marred by the application. Do Not Use solvent-based curing compounds. Sheeting material, wet burlap, burleen or fog spray may be used in lieu of curing compounds. Minimum curing time for wet curing is two days.

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