



# TECHNICAL DATA SHEET

## SPEED CRETE® BLUE LINE

### Fast Setting Underwater Cement Based Patching Material

03930

CONCRETE REHABILITATION  
CONCRETE

TAMMS INDUSTRIES  
NOVEMBER 2003 (Replaces 1/00)

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- DESCRIPTION:** SPEEDCRETE BLUE LINE is a fast setting, cement based concrete and masonry patching compound formulated for underwater use.

#### FEATURES AND BENEFITS

*Rapid set, initial set in 3-5 minutes*

- *Underwater cure*
- *High strength*
- *Durable*
- *Used, without forming, at no slump consistency*
- *Can be "shaved" to desired contour*

#### APPLICATIONS

- *Underwater and below grade repairs*
- *Vertical, overhead and horizontal restoration*
- *Outstanding material for repair of dams, piers, reservoirs, pilings, seawalls, tunnels, sewer pipe and other underwater surfaces*

- COMPOSITION AND MATERIAL:** SPEEDCRETE BLUE LINE is proprietary formulation of blended portland cements, finely processed selected aggregates, and specific chemical additives. SPEEDCRETE BLUE

#### MATERIAL PROPERTIES AT 75°F

<b>ASTM C109</b>			
Compressive Strength, PSI	24 Hour	3,500	
	7 Day	5,460	
	28 Day	6,015	
<b>ASTM C266</b>			
Set Time, Gilmore	Initial	3-5 Min	
	Final	20 Min	
<b>ASTM C190</b>			
Tensile Strength, PSI	7 Day Avg.	315	
	28 Day Avg.	410	
<b>ASTM C78</b>			
Flexural Strength, PSI	28 Day Avg.	964	
<b>ASTM C1042</b>			
Shear Bond Strength, PSI	24 Hour Avg.	921	
	7 Day Avg.	1,268	
<b>ASTM C666</b>			
Freeze Thaw Durability Factor	300 Cycles	98.05%	
<b>ASTM C157</b>			
Shrinkage Initial	7 Day	-0.053%	
	28 Day	-0.160%	
Expansion Initial	7 Day	0.047%	
	28 Day	0.104%	
<b>ASTM C672</b>			
Scaling Resistance	25 Cycles	0% loss	
<b>ASTM D1411</b>			
Chlorides		<0.01%	

LINE undergoes a chemical "hyper hydration" and produces a very stable, low permeable, cementitious matrix, when combined with the correct amount of water.

- SURFACE PREPARATION:** Surface must be structurally sound, clean, free of loose or deteriorated concrete, rust, marine growth, oily materials, and other contaminants. Undercut edges of the area to be patched to a minimum depth of 3/4 inch (19.1 mm). Clean exposed steel and reinforcing. When substrate is not absorptive, abrade as necessary to ensure proper bonding. Surface must be damp to achieve proper bond.
- MIXING INSTRUCTIONS:** SPEEDCRETE BLUE LINE will require approximately 5 to 5.5 quarts (4.7 - 5.261) of potable water per 50 lb (22.68 kg) bag or pail to achieve the proper mix consistency. Pour the measured amount of water into a clean container. Add the measured amount of SPEEDCRETE BLUE LINE, and thoroughly mix for no more than 60 seconds to a stiff, no slump, putty-like consistency. Because of fast initial set time, do not mix more than 50 pounds at a time. Mix small quantities of SPEEDCRETE BLUE LINE in a clean pail with a hand trowel.
- APPLICATION TECHNIQUES:** To ensure complete bond with the entire surface, force the SPEEDCRETE BLUE LINE firmly into the predampened area by hand or with a trowel. Underwater applications may be smoothed or finished by hand. For out-of-water applications, slightly overfill the patch, and following initial set, shave the material to conform to the contour of the surrounding surface. Always shave SPEEDCRETE BLUE LINE toward the common bonding edge between the patching material and the existing surface. Cure the material using standard curing practices. For additional information, contact TAMMS Technical Service Center.
- COVERAGE:** One 50 lb bag of SPEEDCRETE BLUE LINE will yield approximately 0.5 cu ft.
- CLEAN-UP INSTRUCTIONS:** Clean application tools and mixing equipment with water immediately following use. Hardened SPEEDCRETE is difficult to remove.

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8. **CAUTIONS:** Mix no more than 60 seconds. Use only potable water with SPEEDCRETE BLUE LINE. Mix to a stiff, putty-like, no slump consistency. Do not retemper or add sand to SPEEDCRETE BLUE LINE. Do not overwork or overtrowel patching material. Do not featheredge SPEEDCRETE BLUE LINE. Clean mixing equipment between batches.

9. **ENVIRONMENTAL AND SAFETY PRECAUTIONS:** Product contains portland cement which is alkaline on contact with water. Do not breathe dust. May cause delayed lung injury (Silicosis). IARC reports Crystalline silica may cause cancer in humans. Irritating to eyes and skin. Avoid splashing into eyes or contact with skin. In case of eye contact, flood eyes repeatedly with potable water and call a physician. **DO NOT RUB EYES.** Wash skin thoroughly after handling and before smoking or eating. Use adequate ventilation.

10. **PACKAGING:** 50 lb poly-lined bags, and 50 lb. Pails.  
**Storage:** Covered storage away from all moisture.  
**Shelf Life:** Minimum 1 year in protected storage.  
**Freight Class:** Class 55

11. **TECHNICAL SERVICE:** For application procedures or surface conditions not specified above, please contact:

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