



STRUCTURAL CONCRETE[®]

Fast, High Early Strength Permanent Repair

PRODUCT DESCRIPTION

Five Star[®] Structural Concrete is a high early strength, single component, permanent concrete repair material. Containing migrating corrosion inhibitors, Five Star[®] Structural Concrete produces a repair which is dimensionally stable, develops an integral bond to existing concrete, and restores structural integrity within hours of placement. Application thickness can range from 1/4 inch to 12 inches (6 mm to 300 mm) in a single pour. Five Star[®] Structural Concrete provides increased corrosion protection of steel reinforced structures with migrating corrosion inhibitor technology and very low chloride ion permeability. Moisture sensitive coatings can be applied in 8 to 24 hours.

ADVANTAGES

- Single component for reliability and ease of use
- High three-hour strengths
- Very low chloride ion permeability
- Fast turnaround times with high 3-hour strengths
- High bond strength
- Coarse aggregate extension
- Very low shrinkage
- Excellent freeze/thaw resistance
- One product for thin and thick placements
- Outstanding corrosion resistance for protection and rehabilitation

USES

- Repair of concrete structures
- Rapid machinery foundation rebuilds
- Fast repairs for coatings
- Concrete floor repairs and overlays
- Construction joint repair
- Marine and hydraulic structure repairs
- Repair of tanks, sumps and curbs
- Available for Nuclear Safety Zone Applications¹

PACKAGING AND YIELD

Five Star[®] Structural Concrete is packaged in heavy-duty polyethylene lined bags or plastic pails and is available in 50 lb. (22.7 kg) units yielding approximately 0.42 cubic feet (11.9 liters) at maximum water, or 0.60 cubic feet (17.0 liters) with a 60% extension using 3/8" pea gravel.

SHELF LIFE

One year (packaged in bags) or two years (packaged in pails) in original unopened packaging when stored in dry conditions; high relative humidity will reduce shelf life.

TYPICAL PROPERTIES AT 70°F (21°C)

Compressive Strength, ASTM C 109

3 Hours	2,500 psi (17.2 MPa)
1 Day	5,000 psi (34.5 MPa)
7 Days	7,000 psi (48.3 MPa)
28 Days	8,000 psi (55.2 MPa)

Bond Strength, ASTM C 882

1 Day	2,000 psi (13.8 MPa)
7 Days	2,500 psi (17.3 MPa)

Length Change, ASTM C 157

28 Days Wet	+ 0.05%
28 Days Dry	- 0.09%

Freeze/Thaw Resistance, ASTM C 666A

Relative Durability Modulus	95%
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Chloride Ion Permeability, ASTM C 1202

28 Days	Very Low (<1,000 Coulombs)
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Working Time at 70°F (21°C)

15 minutes

**The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result. Test methods are modified where applicable.*

PLACEMENT GUIDELINES

1. **SURFACE PREPARATION:** All horizontal and vertical concrete surfaces in contact with Five Star Structural Concrete® shall be free of oil, grease, laitance, and other contaminants. All horizontal and vertical concrete surfaces must be clean, sound and rough to ensure a good bond. Remove all oxidation from exposed reinforcing steel. A perimeter edge and minimum depth of 1/4 inch (6 mm) should be provided for a durable repair. Featheredging is not desirable. Soak concrete surfaces prior to application with liberal quantities of potable water, leaving the concrete saturated and free of standing water, or use Five Star® Bonding Adhesive. Surfaces shall be conditioned to between 35°F and 90°F (2°C and 32°C) at time of placement.
2. **FORMWORK:** Formwork shall be constructed of rigid non-absorbent materials, securely anchored, liquid-tight and strong enough to resist forces developed during placement. Areas where bond is not desired must be treated with form oil, paste wax or similar material. Joints may be necessary depending on pour dimensions. Any existing joints within the repair area should be maintained. Contact the Five Star Products, Inc. Engineering and Technical Service Center for further information.
3. **MIXING:** Mix Five Star Structural Concrete® thoroughly for approximately three to four minutes to a uniform consistency with a mortar mixer (stationary barrel with moving blades). A drill and paddle mixer is acceptable for single bag mixes. With the mixer running add approximately 80% of the pre-measured potable water (total water content is 2 1/2 to 3 quarts potable water per 50 lb. unit) to the mixer. Adjust consistency if necessary, but do not exceed maximum water content stated on the package or an amount that will cause segregation. Addition of coarse aggregate, meeting ASTM C 33, should be used for pours greater than 2 inches (50 mm) in depth. Working time is approximately 15 minutes at 70°F (21°C). Follow printed instructions on the package.
4. **PLACEMENT PROCEDURES:** Whenever possible, place Five Star Structural Concrete® full depth from one side of the repair to the other. To ensure optimal bond development, firmly work material into substrate. Placement should be continuous to prevent cold joints between pours. Finish as necessary.
SPECIAL CONDITIONS: For use in cold temperatures, Five Star Structural Concrete® must be maintained at a temperature of at least 35°F (2°C). Protect from freezing until a compressive strength of at least 1,000 psi (6.9 MPa) is obtained. Faster strength gain will occur when the Five Star Structural Concrete® and mixing water have been conditioned to a higher temperature prior to placement. In hot temperatures, Five Star Structural Concrete® should be kept as cool as possible, but not exceeding 90°F (32°C). Ice cold water should be used for mixing to help maintain sufficient working time. Summerset® may also be used to provide more working time if necessary.
5. **POST-PLACEMENT PROCEDURES:** Five Star Structural Concrete® shall be continuously wet cured for one to four hours, depending on the volume and depth of the placement. Wet curing shall begin as soon as material reaches final set (surface changes from dark to light).

NOTE: PRIOR TO APPLICATION, READ ALL PRODUCT PACKAGING THOROUGHLY. For more detailed placement procedures, refer to Design-A-Spec™ installation guidelines or call the Five Star Products, Inc. Engineering and Technical Service Center at (800) 243-2206.

CONSIDERATIONS

- Temperature of surfaces must be between 35°F and 90°F (2°C and 32°C) at time of placement. For cold and hot weather placement, refer to Design-A-Spec™.
- For placements thicker than two inches (50 mm) and a volume exceeding two cubic feet (56.5 liters), contact the Five Star Products, Inc. Engineering and Technical Service Center at (800) 243-2206 for aggregate extension guidelines.

CAUTION

Contains cementitious material and crystalline silica. International Agency for Research on Cancer has determined that there is sufficient evidence for the carcinogenicity of inhaled crystalline silica to humans. Take appropriate measures to avoid breathing dust. Avoid contact with eyes and contact with skin. In case of contact with eyes, immediately flush with plenty of water for at least 15 minutes. Immediately call a physician. Wash skin thoroughly after handling. Keep product out of reach of children. **PRIOR TO USE, REFER TO MATERIAL SAFETY DATA SHEET.**

For worldwide availability, additional product information and technical support, contact your local Five Star® distributor, local sales representative, or you may call the Five Star Products, Inc. Engineering and Technical Service Center at (800) 243-2206.

SKU / PRODUCT CODE	DESCRIPTION	UNIT SIZE
29100	Structural Concrete®	50 lb. Bag
29000	Structural Concrete®	50 lb. Pail
29100N ¹	Structural Concrete® for Nuclear Safety Zone	50 lb. Bag
29000N ¹	Structural Concrete® for Nuclear Safety Zone	50 lb. Pail

¹Compliant with NRC 10CFR50 Appendix B and ASME NQA-1 Quality Programs

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