



Aggregate Extension Guidelines

The following instructions apply to these Five Star® products:

- Structural Concrete®
- Structural Concrete® ES
- Structural Concrete® ES-60
- Structural Concrete® S300
- Structural Concrete® UW PG
- Highway Patch

For placements greater than 2 inches (50 mm) in depth, these products should be extended with a clean, washed, coarse aggregate meeting the requirements of ASTM C 33. Coarse aggregate size typically should not exceed 1/3 the depth of the repair.

Mortar Mixer: When mixing in a mortar mixer, add coarse aggregate after initial mixing of concrete repair material with mix water for 2-3 minutes. Continue mixing until coarse aggregate is uniformly wetted with repair material. Ensure larger size aggregates can be mixed properly in mortar mixer.

Concrete Mixer: When mixing in a concrete mixer (rotating drum mixer), add water and coarse aggregate to mixer first with mixer running followed by repair material. Concrete mixers are acceptable when extending repair material with coarse aggregate.

Depth of Pour	% By Weight Aggregate Extension (per 50 lb (22.7 kg) bag of repair material)	Actual Weight Aggregate Extension (per 50 lb (22.7 kg) bag of repair material)
Up to 2 inches (50 mm)	0%	0 lb/kg
2 to 6 inches (50-150 mm)	50%	25 lb (11.3 kg)
6 to 9 inches (150-225 mm)	60%	30 lb (13.6 kg)
9 to 12 inches (225-300 mm)	80%	40 lb (18.1 kg)
Over 12 inches (over 300 mm)	Contact Five Star Technical Support	

Repair material yield will increase with coarse aggregate extension depending upon aggregate size, extension level, air content and specific gravity of aggregate. Typically a 50% by weight extension (by weight) will increase yield by approximately 35%. Actual yield attained in the field will vary and should be verified where greater accuracy is required.

For information 1-800-243-2206 ▪ FiveStarProducts.com

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