

## DARACEM® 65

### Mid-range water-reducing admixture

ASTM C494 Type A

#### Product Description

Daracem® 65 is a water reducer specifically formulated to produce concretes with dramatically enhanced finishing characteristics and normal setting times. Effective through a wide addition rate range, Daracem 65 combines the benefits of normal and high-range water reducers allowing for the ultimate control of the concretes placing and finishing properties. Daracem 65 has been approved as an ASTM C494 Type A admixture.

Daracem 65 is an aqueous solution of complex organic compounds, each of which contributes uniquely to the concrete's final properties. It is manufactured under rigid controls which provide uniform, predictable performance. Daracem 65 contains no calcium chloride. Supplied as a dark brown, low viscosity liquid, one gallon weighs approximately 9.5 lbs (1.14 kg/L).

#### Uses

Daracem 65 produces a concrete with lower water content, improved placement properties, and enhanced finishability. It yields a less permeable and more durable concrete. Daracem 65 is used in ready-mix, job site, and concrete paving plants for normal and lightweight concrete, in block and precast. It imparts a "slickness" to the surface of the concrete making it most appropriate for

concrete flatwork as well as slip form work. Daracem 65 is also particularly effective in lean or fly ash and slag compensated mixes.

#### Advantages

Daracem 65 offers significant advantages over conventional water reducers. Laboratory and field work has consistently demonstrated:

- **Ultimate workability and finishability**  
The exceptional water-reducing capabilities allow for concrete production at higher slumps with better water retention and internal cohesiveness, providing a less "sticky" concrete with improved placement properties. Formulated with proven finishing enhancing components, Daracem 65 controls bleeding while bringing the mortar to the surface. Finishers have stated that the concrete has improved trowelability. The influence of Daracem 65 on the finishability of lean mixes has been particularly noticeable. Floating and troweling, by machine or by hand, easily imparts a smooth, close tolerance surface with less machine time and labor.
- **Neutral setting times**  
Formulated with a set control agent, Daracem 65 provides normal setting characteristics throughout its addition rate

#### Product Advantages

- Ultimate workability and finishability
- Neutral setting times
- Superior strength performance



range. This allows for increased water reduction and increased slump without significantly extended setting times. It also allows the flexibility to vary addition based on specific job and weather requirements.

- **Superior strength performance**

The water reduction properties, up to 12%, and dispersion characteristics allow the production of lower water to cement ratio concretes and more complete hydration.

The combined effect is increased compressive and flexural strengths at all ages.

## Addition Rates

The addition rate range of Daracem 65 is 3 to 9 fl oz/100 lbs (190 to 590 mL/100 kg) of cement. Optimum addition depends on the other concrete mixture components, job conditions, and desired performance characteristics.

## Compatibility with Other Admixtures and Batch Sequencing

Daracem 65 is compatible with most Grace admixtures as long as they are added separately to the concrete mix. In general, it is recommended that Daracem 65 be added to the concrete mix near the beginning of the batch sequence but after the cement and water are combined for optimum performance. Different sequencing may be used if local testing shows better performance. Please see Grace Technical Bulletin TB-0110, *Admixture Dispenser Discharge Line Location and Sequencing for Concrete Batching Operations* for further recommendations. Daracem 65 should not come in contact with any other admixture before or during the batching process, even if diluted in mix water.

Pretesting of the concrete mix should be performed before use, and as conditions and materials change in order to assure compati-

bility, and to optimize dosage rates, addition times in the batch sequencing and concrete performance. For concrete that requires air entrainment, the use of an ASTM C260 air-entraining agent (such as Daravair® or Darex® product lines) is recommended to provide suitable air void parameters for freeze-thaw resistance.

## Packaging & Handling

Daracem 65 is available in bulk, delivered in metered tank trucks, and 55 gallon (210 L) drums. It will freeze at approximately 25°F (-4°C) but will return to full strength after thawing and thorough mechanical agitation.

## Dispensing Equipment

A complete line of accurate, automatic dispensing equipment is available. Daracem 65 may be added to the concrete mix on the sand or in the batch water.

## Specifications

Concrete shall be designed in accordance with *Standard Recommended Practice for Selecting Proportions for Concrete*, ACI 211.

The water-reducing admixture shall be a mid-range water-reducing admixture such as Daracem 65 as manufactured by Grace Construction Products, or its equivalent. The admixture shall not contain calcium chloride. It shall meet the requirements of *Specification for Chemical Admixtures for Concrete* ASTM Designation C494 as a Type A admixture. Certification of compliance shall be made available on request. The admixture shall be considered part of the total mixing water.

The admixture shall be delivered as a ready-to-use liquid product and shall require no mixing at the batching plant or job site.

[www.graceconstruction.com](http://www.graceconstruction.com)

**North American Customer Service: 1-877-4AD-MIX1 (1-877-423-6491)**

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