

## PRODUCT DATA SHEET

# Sika® ViscoCrete® ACE 415

(formerly MasterGlenium® ACE 415)

A new generation high-performance polycarboxylic ether-based superplasticizer for the Precast industry

### DESCRIPTION

**Sika® ViscoCrete® ACE 415** (Admixture Controlled Energy) consists of a range of innovative superplasticizers based on newly developed polycarboxylate ether polymers. The particular molecular configuration of **Sika® ViscoCrete® ACE 415** accelerates the cement hydration by exposing increased surface of the cement grains to react with water. As a result, it is possible to obtain earlier development of the heat of hydration, rapid development of the hydration products and, therefore, higher strengths at very early age. The polymer structure of **Sika® ViscoCrete® ACE 415** is specially designed to improve the rheology of precast concrete, making it very flowable and low viscous even at very low water/cement ratios, without increasing stickiness. Robustness is a distinctive feature of the precast concrete produced with **Sika® ViscoCrete® ACE 415**.

### USES

Sika® ViscoCrete® ACE 415 is suitable for making precast concrete elements with highly-fluid concrete without segregation, but low water cement ratio and, Sika® ViscoCrete® ACE 415 may be used in combination with SikaStabilizer for producing advanced self-compacting concrete like Smart Dynamic Concrete (SDC, latest V- type SCC), without the aid of vibration, for economic, ecological and ergonomic precast production.

### CHARACTERISTICS / ADVANTAGES

Sika® ViscoCrete® ACE 415 offer the following benefits for the precast concrete industry:

- Production of highly flowable, robust selfcompacting concrete having a low water cement ratio along with an optimal rheology.
- Enhanced robustness and consistency in concrete quality with low stickiness.
- Environmentally friendly, CO2 reduced mix- design optimization.
- Elimination of heat curing.
- Improved surface appearance.
- Durable precast concrete elements as per EN 206-1.
- Elimination of the energy required for placing, compaction and curing.
- Optimization of the curing cycles by reducing curing time or curing temperature.
- Increased productivity.

### APPROVALS / STANDARDS

ASTM C494 Type A & F  
EN EN934-2

## PRODUCT INFORMATION

Packaging	Sika® ViscoCrete® ACE 415 is available in a 1000 litre IBC's or in bulk.
Shelf Life	The shelf life is 12 months from date of manufacture, if stored correctly.
Storage Conditions	Sika® ViscoCrete® ACE 415 must be stored in an unopened container, in a place where the temperature does not drop below 5°C. In case of freezing, warm up and homogenise the admixture solution before using.
Appearance / Colour	Whitish to Yellowish liquid
Density	1.040 -1.070
pH-Value	5.0 – 7.0
Total Chloride Ion Content	“Chloride-free” to EN 934-2
Equivalent Sodium Oxide	<3%

## SYSTEM INFORMATION

Compatibility	<p>Sika® ViscoCrete® ACE 415 is compatible and recommended for use with:</p> <ul style="list-style-type: none"><li>• <b>SikaStabilizer</b> to modify the viscosity of SCC.</li><li>• <b>SikaControl AER</b>, air-entraining admixture, to improve freeze-thaw resistance (exposure class XF1 to XF4, EN 206-1)</li><li>• <b>Sika Separol</b>, demoulding agent for easy formwork removal and improved finish.</li><li>• <b>Sika Antisol</b>, curing compound for highly efficient water retention and friendly use.</li></ul> <p>Sika® ViscoCrete® ACE 415 is not compatible with all admixtures of Sika-ment RB series.</p>
---------------	--

## APPLICATION INFORMATION

Recommended Dosage	<p>The recommended dosage rate is: <b>0.5 to 2.0 litres per 100 kg</b> of the binder. Other dosages may be used in special cases according to specific production conditions. In this case please consult our Technical Services Department.</p>
Dispensing	<p>Sika® ViscoCrete® ACE 415 is a liquid admixture to be added to the concrete during the mixing process. The best results are obtained when the admixture is added to the mixing water that is used for the concrete mix after all the other components are already in the mixer and after the addition of at least 80% of the total water. Avoid adding the admixture to the dry aggregates. After adding Sika® ViscoCrete® ACE 415 admixture provide enough mixing time to secure a homogenous dispersion. Continue mixing and adjust the water content to obtain the required workability.</p>

## BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## FURTHER DOCUMENTS

No special requirements must be observed while the product is used. Protection gloves and glasses are recommended. Do not eat, drink or smoke during the application. Sika® ViscoCrete® ACE 415 is not-flammable, non-toxic or irritant and are not subject to special transport requirements.

## ECOLOGY HEALTH AND SAFETY

### LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

### Sika South Africa (Pty) Ltd

9 Hocking Place,  
Westmead, 3608  
South Africa  
Phone +27 31 792 6500  
www.sika.co.za



### Product Data Sheet

Sika® ViscoCrete® ACE 415  
October 2023, Version 01.01  
021301000000002400

SikaViscoCreteACE415-en-ZA-(10-2023)-1-1.pdf