



It is **HIGHLY RECOMMENDED THAT THE TECHNICAL DEPARTMENT BE CONTACTED PRIOR TO** the use of **MOXIE 1800 SUPER-ADMIX**. These procedures are related to mixes which include aggregates.

**RATE/USE:** 10 oz. per sack (**50 oz. minimum per cu. yd.**) per yard. Include any other cementitious materials such as flyash in the calculation. **Adequate aggregate and sand moisture must be maintained in order to control proper water/cement ratio.** Field and laboratory tests show maximum benefits have been achieved at a recommended slump range of **3" to 3½"** for standard concrete, **2" to 2½" for fly ash, do not exceed a .52-.54 water to cement ratio regardless of slump.** Higher slumps will result in lower performance and increased concrete hydration time resulting in an increase in the curing time required for the chemical reaction of MOXIE 1800 SUPER-ADMIX. Refer to the MOXIE International publications, "Moisture Migration Table" and "Water Vapor Flow Rates". Contact Technical Services for proper water to cement ratio and slump.

#### PROCEDURE:

- 1) Start with a clean mixer drum, clean as usual thereafter.
- 2) Add the proper dosage of MOXIE 1800 SUPER-ADMIX a minimum of **20%** of the amount of water to the mixer drum, or to all of the water if properly measured. Standard dosage rate is 10 oz per sack of cement, per cubic yard of concrete. Add after water/cement ratio adjustment to the mix design, then add the proper amount of MOXIE 1800 SUPER-ADMIX.  
Example: **5½ sk mix X 10 oz. sk/cy = 55 oz. per cubic yard.**

**NOTE: If polyfibers or coloring agents are specified they should be added at this time and mixed thoroughly.**

- 3) Rotate the drum for approximately 30 revolutions (2-3 min.) only to insure thorough mixing (ASTM. C94).
- 4) Add the remaining amount of water, (**minus the amount of MOXIE 1800 SUPER-ADMIX used**), and the dry cement, aggregate, and sand. MOXIE 1800 SUPER-ADMIX may be added to the entire weighed amount of water, **minus the amount of MOXIE 1800 SUPER-ADMIX used**, batch as usual.
- 5) Rotate the drum for approximately **15 minutes, 70-100 revolutions**, at no less than 4 rpm before discharging, as called for in standard ready mixed practices. **THIS TIME IS NOT IN ADDITION TO THE STANDARD MIXING TIME. REFER TO ASTM C94**
- 6) Wash out drum as usual thereafter.
- 7) **Should mix have to be transported or transit times of up to 1 ½ to 2 hours, mix for 10 minutes at mix speed thereafter for 1 rpm during transit. Mix an additional 5 minutes at mix speed on the jobsite prior to placement.**

It is **EXTREMELY IMPORTANT** that these directions are followed in **EXACT SEQUENCE** in order to obtain the maximum benefits and results. MOXIE 1800 SUPER-ADMIX is clear, odorless, non-toxic, and is not detrimental to the equipment, including the mixing drum. Clean-up of tools and equipment is easier. It is not recommended to use any accelerating, air-entraining, finishing, plasticizers, pumping-quality, dustproofing compounds or water reducing admixtures. If any other admixture is specified, mix separately and start with **HALF THE NORMAL DOSAGE of that admixture**. If ambient temperature exceeds 85°F a retarder may be used. **MOXIE 1800 SUPER-ADMIX will reduce the overall air content, either entrained or entrapped by approximately 1% - 2%, total volume will be reduced accordingly, adjust for total volume.**

#### OTHER CONDITIONS

- 1) **Do not use any curing compounds.** Fog only with water if necessary. Do not flood surface. Flooding will cause shrinkage cracking.
- 2) If ambient temperature drops below 50°F rotate mix drum an additional 4 -5 min. at mix speed, on-site, prior to discharging. MOXIE **Fastset50** Accelerator, a non-chloride, set accelerator may be used to reduce set time up to 50 percent at maximum dosage. Consult the **Fastset50** Accelerator cut sheet or MOXIE International for dosage.
- 3) Maximum benefits have been achieved maintaining a 3" to 3½" slump, 2" to 2½" for fly ash mix designs.
- 4) Concrete will appear to be dry, however it will have the workability and finishing characteristics of a slump that is 1½" to 2" higher. At the above water to cement ratio there will be virtually no bleed water, do not allow finishers to wait for it. If there is any bleed water the water to cement ratio is too high, reduce the amount of water.
- 5) Less line pressure is required for pumped concrete. Typical line pressure reduction would be approximately one-third.  
Example: 1500 psi would reduce to about 900-1000 psi.
- 6) If there are any additional requirements please contact Technical Services.

**NOTE: ASTM C94 SPECIFICATIONS FOR READY MIXED CONCRETE, ACI 304 MEASURING, MIXING, TRANSPORTING, AND PLACING CONCRETE, 305R HOT WEATHER CONCRETING, 306R COLD WEATHER CONCRETING, STANDARDS APPLY. TAKE NECESSARY SAFEGUARDS AND PRECAUTIONS, PROVIDE ADEQUATE PROTECTION FOR THE SLAB DURING THE FIRST 72 HOURS AGAINST FREEZING OR 7 DAYS IN HIGH TEMPERATURES.**