ARDEX K 523™
Self-Leveling Concrete Topping with Aggregate Surface

A blend of Portland cement, hydraulic cements and specialty aggregate
Resurface indoor concrete
Walk on in 2 - 3 hours, polish in as little as 24 hours
Use for interior floors only

TESTED IN ACCORDANCE WITH ASTM C 1708
ARDEX K 523™
Self-Leveling Concrete Topping with Aggregate Surface

Description and Usage
ARDEX K 523™ is a pourable, polishable, self-leveling topping for fast-track resurfacing of indoor concrete. ARDEX K 523 can be installed from a minimum thickness of 3/8" (9 mm) up to a maximum thickness of 2" (5 cm). With black and white aggregates, ARDEX K 523 provides a polished, "aggregate-exposed" surface. Polishing can proceed in as little as 24 hours.

Suitable Substrates
Interior concrete only

Substrate Preparation (Proper Prep™)
Acid etching, adhesive removers, solvents and sweeping compounds are not acceptable means of cleaning the substrate. Mechanical preparation methods must comply with OSHA Silica Standard for Construction CFR §1926.1153. After mechanical preparation is completed and prior to priming, ensure that all dust and debris is removed from the substrate by vacuuming thoroughly. The vacuum filter must comply with OSHA Silica Standard for Construction CFR §1926.1153.

Substrates must be dry and properly primed for a successful installation. Substrate and air temperatures must be a minimum of 50°F (10°C). For further information, please refer to the ARDEX Substrate Preparation Technical Data Sheet.

All concrete substrates must be solid, thoroughly clean and free of oil, wax, grease, asphalt, latex and gypsum compounds, curing compounds, sealers and any contaminant that might act as a bond breaker. Sanding is not an effective method to remove contaminants from concrete.

Mechanically clean down to sound, solid concrete by shot blasting, scarifying or similar. Overwatered, frozen or otherwise weak concrete surfaces must also be cleaned down to sound, solid concrete by mechanical methods. The concrete surface must have a minimum ICRI Concrete Surface Profile of 3 (CSP #3). Any additional preparation required to achieve this must likewise be mechanical.

Note on Asbestos-Containing Materials: Please note that when removing existing flooring, any asbestos-containing materials should be handled and disposed of in accordance with applicable federal, state and local regulations.

Joints and Moving Cracks
Under no circumstances should ARDEX K 523 be installed over any joints or any moving cracks. All existing expansion joints, isolation joints, construction joints and dormant control joints (saw cuts), as well as all moving cracks, must be handled and disposed of in accordance with applicable federal, state and local regulations.

Dormant Cracks
Before proceeding with the installation, all dormant cracks greater than 1/32" (0.75 mm) wide that will not be honored must be prefilled with a fully rigid, high-modulus, 100% solids material, such as ARDEX ARDIFIX™. Please note that the repair material must be sand broadcast to refusal while still fresh and allowed to cure fully prior to removing all excess sand and proceeding with the installation.

The filling of dormant cracks as described above is recommended to help prevent the cracks from showing through the topping. However, should movement occur, cracks will reappear. See the “Cracking” section below for more details.

Priming / Moisture Control
Moisture Control: ARDEX K 523 is intended for interior use over dry substrates only. Do not use in areas of constant water exposure or in areas exposed to permanent or intermittent substrate moisture, as this may jeopardize the performance of the topping. This product is not a vapor barrier and will allow free passage of moisture. Test the substrate using the relative humidity test method in accordance with ASTM F2170 prior to installing. If the test results are greater than 85%, ARDEX MC RAPID must be installed with a sand broadcast in accordance with the ARDEX MC RAPID technical data sheet. Where ARDEX MC RAPID and sand broadcast are installed, no further priming is required prior to installing ARDEX K 523.

Priming: For all applications where ARDEX MC RAPID has not been installed, prime with ARDEX EP 2000™ Substrate Preparation Epoxy Primer. Follow the general recommendations for substrate preparation above, and apply the ARDEX EP 2000 with sand broadcast, carefully following the instructions in the ARDEX EP 2000 technical data sheet.

Primer Dry Times: ARDEX MC RAPID and/or ARDEX EP 2000 may need longer drying times with low surface temperatures and/or high ambient humidity. Do not install ARDEX K 523 before the selected primer has dried thoroughly.

Recommended Tools
ARDEX T-1 Mixing Paddle; ARDEX T-10 Mixing Drum; ARDEX T-4 Spreader; ARDEX T-5 Smoother; ARDEX MB-3.75 Measuring Bucket (3.25 or 3.75 quarts (3.07 or 3.55 L) per 50 lb. (22.7 kg) bag); 1/2" (12 mm) heavy-duty drill (min. 650 rpm); Mix thoroughly for approximately 2 - 3 minutes to obtain a lump-free mix.

Mixing and Application
Manual Mixing
ARDEX K 523 is mixed two bags at a time. Mix each 50 lb. (22.7 kg) bag with 3.25 or 3.75 quarts (3.07 or 3.55 L) of clean water (lower water level allows aggregates to be suspended higher in the mix, requiring less processing to achieve aggregate reveal).

Pour the water in the mixing drum first, and then add each bag of ARDEX K 523 while mixing with an ARDEX T-1 Paddle and a 1/2" (12 mm) heavy-duty drill (min. 650 rpm). Mix thoroughly for approximately 2 - 3 minutes to obtain a lump-free mix. Do not overwater! Yellowish foam while mixing or settling of the sand aggregate while placing indicates overwatering.

When installing ARDEX K 523 in high-stress areas subject to rolling loads such as rubber-wheeled forklift traffic or similar use, the addition of ARDEX E 25™ Resilient Emulsion is required to increase the resiliency of the ARDEX K 523. Mix 1.75 quarts (1.65 L) of ARDEX E 25 with 3 quarts (2.8 L) of water for each bag of ARDEX K 523 following the mixing instructions above. Please note that, if ARDEX E 25 is used, the ARDEX K 523 must first cure 24 hours prior to receiving foot traffic and 48 hours prior to being polished.

Work Practice Control Methods
ARDEX recommends using the ARDEX DUSTFREE™ or a standard “gutter hook” vacuum attachment in combination with a HEPA dust extraction vacuum system when mixing ARDEX K 523. Handle the...
An empty bag of substrate movement while the topping cures. Hairline cracking also can occur when there is slight space is very low and/or air is moved rapidly over the surface of during cure, which tends to happen when ambient humidity in the cracking is overly rapid moisture evaporation from the topping performance of the topping. The most common cause of hairline also known as map cracking or crazing. Hairline cracking, while aesthetically unpleasant, typically does not affect the overall beauty that the topping is well bonded to the substrate. As long as the topping is well bonded, its overall performance will not be affected. If there is a desire to smooth or mask the appearance of the cracks, please contact the ARDEX Technical Service Department for a recommendation.

**Notes**

FOR PROFESSIONAL USE ONLY. Improper use voids warranty.

ARDEX K 523 wear surfaces are intended for foot traffic. Excessive service conditions, such as steel- or hard plastic-wheeled traffic or dragging heavy metal equipment or loaded pallets with protruding nails over the floor, will cause gouging and indentations. ARDEX K 523 is not a resurfacing topping for heavy-duty manufacturing areas or industrial floors or for chemical environments requiring customized industrial toppings. As with any floor covering (wood, soft natural stone, marble, etc.), allowances must be made for scratches or abrasion that occur due to moving or sliding furniture or fixtures over the surface. Keeping the floor surface clean and free of dirt or other contaminants also will help to minimize scratching and abrasion due to foot traffic.

ARDEX K 523 wear surfaces are not intended to be perfectly homogeneous in appearance. The physical act of spreading and smoothing will result in optical variations in the appearance of the floor even though it is very flat. The aesthetic appearance that is created is subject to possible technical and artistic tolerances. Variations in the overall finished appearance are an intended effect and should be expected.

Always install an adequate number of properly located test areas, to determine the suitability and aesthetic value of the products for the intended use. As coatings vary, always contact and rely upon the manufacturer for specific directives, such as maximum allowable moisture content, coating selection and intended end use of the product.

The finished floor does not achieve its published surface hardness until after 28 days.

While ARDEX K 523 can be installed over concrete that contains in-floor heating, ARDEX K 523 should not be used to encapsulate any heating system directly. If the concrete substrate has in-floor heating, ARDEX K 523 should not be used to encapsulate it should be turned off, and the concrete should be allowed to cool, before installing ARDEX K 523.

Never mix with cement or additives other than ARDEX-approved products. Observe the basic rules of concrete work. Do not install below 50°F (10°C) surface and air temperatures. Install quickly if the substrate is warm, and follow warm weather instructions available from the ARDEX Technical Service Department.

Dispose of packaging and residue in accordance with federal, state and local waste disposal regulations. Do not flush material down drains.

**Precautions**

Carefully read and follow all precautions and warnings on the product label. For complete safety information, please refer to the Safety Data Sheet (SDS) available at www.ardexamericas.com.
### Technical Data According To ARDEX

#### Quality Standards

Physical properties are typical values and not specifications. All data based on a partial, in-lab mix. Mixing and testing completed at 70°F / 21°C and, where applicable, in accordance with ASTM C1708.

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
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<tbody>
<tr>
<td><strong>Mixing Ratio:</strong></td>
<td>3.25 or 3.75 quarts (3.07 or 3.55 L) of water per 50 lb. (22.7 kg) bag</td>
</tr>
<tr>
<td><strong>Coverage:</strong></td>
<td>Up to 13 sq. ft. per bag at 3/8&quot; (1.2 sq. m at 9 mm)</td>
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<tr>
<td><strong>Flow time:</strong></td>
<td>10 minutes</td>
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<tr>
<td><strong>Thickness of Installation:</strong></td>
<td>3/8&quot; (9 mm) up to 2&quot; (5 cm)</td>
</tr>
<tr>
<td><strong>Compressive strength (ASTM C109/mod – air cure only):</strong></td>
<td>6,200 psi (436 kg/cm²) at 28 days</td>
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<tr>
<td><strong>Flexural strength (ASTM C348):</strong></td>
<td>1,100 psi (77 kg/cm²) at 28 days</td>
</tr>
<tr>
<td><strong>Walkable:</strong></td>
<td>2 - 3 hours (without E 25)</td>
</tr>
<tr>
<td></td>
<td>24 hours (with E 25)</td>
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<tr>
<td><strong>Polishable:</strong></td>
<td>24 hours (without E 25)</td>
</tr>
<tr>
<td></td>
<td>48 hours (with E 25)</td>
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<tr>
<td><strong>Available Colors:</strong></td>
<td>Gray</td>
</tr>
<tr>
<td><strong>VOC:</strong></td>
<td>0</td>
</tr>
<tr>
<td><strong>Packaging:</strong></td>
<td>50 lb. (22.7 kg) net weight bag</td>
</tr>
<tr>
<td><strong>Storage:</strong></td>
<td>Store in a cool, dry area. Do not leave bags exposed to sun.</td>
</tr>
<tr>
<td><strong>Shelf life:</strong></td>
<td>1 year, if unopened</td>
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For easy-to-use ARDEX Product Calculators and Product Information On the Go, download the ARDEX App at the iTunes Store or Google Play.

Visit www.youtube.com/ARDEX101 to watch ARDEX Americas product videos.

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