



**For the Builders  
of a Better World™**

# 328R Rapid Flexible Adhesive

DS14-328R-0325

328R Rapid Flexible Adhesive is a versatile polymer modified rapid set bagged cementitious thin-set powder to be mixed with water for installation of ceramic tiles, porcelain tiles, mosaics and natural stone. Designed for interior and exterior floor and wall installations of a variety of substrates.



## FEATURES/BENEFITS

- Fast setting.
- Flexible.
- Easy to apply, just mix with water.
- Heat resistant.
- Strong bond and durable.

## USES

- Recommended for wet areas such as bathrooms & kitchens.
- For interior and exterior applications.
- Excellent for installing glass mosaics, natural stone & tiles.

## MANUFACTURER/ DISTRIBUTED BY

LATICRETE South East Asia Pte Ltd  
No. 38 Sungei Kadut Street 2 (Level 2, A3) Singapore 729245  
Telephone: +65 6515 3028 Fax: +65 6515 3037  
Internet: [se.laticrete.com](http://se.laticrete.com)

## STANDARDS/CERTIFICATIONS

- BS EN 12004
- ANSI A118

### Suitable Substrates

- Concrete
- Cement plaster
- Brick masonry
- Drywall boards\*
- Cement mortar beds
- Cement backer board\*\*
- Concrete Masonry

\* Consult Laticrete Technical Services for more information.

\*\*Consult cement backer board manufacturer for specific installation recommendations and to verify acceptability for exterior use.

### Packaging

25kg bag, 80 bags per pallet.

### Colors

Default Grey and White

### Approximate Coverage

25kg of 328R Rapid Flexible Adhesive mixed with clean water will yield a coverage of 6.5 to 7.5 m<sup>2</sup> using 6 x 6mm notch trowel.

### Shelf Life

Factory sealed containers of this product are guaranteed to be of first quality for Six (6) months\* if stored off the ground in a dry area, at temperature  $\geq 0^{\circ}\text{C}$  to  $\leq 40^{\circ}\text{C}$ .

\* High humidity will reduce the shelf life of bagged product.

### Limitations

- Use LATAPOXY® 300 Adhesive for installing green marble or water sensitive natural stone and agglomerates.
- Adhesives/mastics, mortars and grouts for ceramic tile, pavers, brick and stone are not replacements for waterproofing membranes. When a waterproofing membrane is required, use a LATICRETE Waterproofing Membrane.
- Surfaces must be structurally sound, stable and rigid enough to support ceramic/stone tile, thin brick and similar finishes. Substrate deflection under all live, dead and impact loads, including concentrated loads, must not exceed L/360 for thin bed ceramic tile/brick installations or L/480 for thin bed stone installations where L=span length.

### Cautions

Consult MSDS for more safety information.

- During cold weather, protect finished work from traffic until fully cured.
- Contains Portland cement and silica sand. May irritate eyes and skin. Avoid contact with eyes or prolonged contact with skin. In case of contact, flush thoroughly with water.
- Do not take internally. Silica sand may cause cancer or serious lung problems. Avoid breathing dust. Wear a respirator in dusty areas.
- Keep out of reach of children.

### TECHNICAL DATA

#### Performance Properties

328R Rapid Flexible Adhesive when mixed with water

Test	Test Method	Results
Tensile Adhesion Bond Strength (6 hours)	BS EN 12004	$\geq 0.5 \text{ N/mm}^2$
Tensile Adhesion Bond Strength (28 days)	BS EN 12004	$\geq 2.0 \text{ N/mm}^2$
Tensile Adhesion Bond Strength after Heat Ageing (28 days)	BS EN 12004	$\geq 2.0 \text{ N/mm}^2$
Tensile Adhesion Bond Strength after Water Immersion (28 days)	BS EN 12004	$\geq 1.4 \text{ N/mm}^2$
Shear Bond Strength (28 days)	ANSI A118	$\geq 1.5 \text{ MPa}$
Open Time (30mins)	BS EN 12004	$\geq 1.0 \text{ N/mm}^2$
Slip Resistance	BS EN 12004	$\leq 0.5 \text{ mm}$
Transverse Deformation	BS EN 12004	$\geq 2.5 \text{ mm}$

#### Working Properties

328R Rapid Flexible Adhesive when mixed with water

Open Time (25°C)	20 minutes
Pot Life (25°C)	30 - 40 minutes
Time to Light Traffic	2 - 3 hours

Results shown are typical but reflect test procedures used. Actual field performance will depend on installation methods and site conditions.

### INSTALLATION

All surfaces should be between 5°C and 40°C and structurally sound, clean and free of all dirt, oil, grease, laitance, loose peeling paint, concrete sealers or curing compounds. Rough or uneven concrete surfaces should be made smooth with LATICRETE Latex Portland Cement underlayment to provide a wood float (or better) finish.

Dry, dusty concrete slabs or masonry should be dampened and excess water swept off. Installation may be made on a damp surface. New concrete slabs shall be damp cured and 28 days old before application.

\*Note: Latex Portland Cement Mortars do not require a minimum cure time for concrete slabs. All slabs must be plumb and true to within 6mm in 3m. Expansion joints shall be provided through the tile work from all construction or expansion joints in the substrate. Follow ANSI specification AN-3.8 "Requirements for Expansion Joints" or TCA Detail EJ171 "Expansion Joints". Do not cover expansion joints with mortar.

### Mixing

Place clean, potable water into a clean pail. Add 328R Rapid Flexible Adhesive powder Mortar. Use approximately 6.25ℓ - 6.75ℓ of water for 25 kg of powder. Mix by hand or with a slow speed mixer to a

smooth, trowellable consistency. Allow mortar to slake for 3-5 minutes. Adjust consistency if necessary. Remix and apply with the proper sized notched trowel. **Please do not mix other aggregates such as cement or sand etc to 328R Rapid Flexible Adhesive.**

**\*Actual mix ratio & field performance will depend on application methods, site condition and temperature.**

### Application

Apply mortar to the substrate with the flat side of the trowel, pressing firmly to work into surface. Comb on additional mortar with the notched side.

Note: Use the proper sized-notched trowel to insure full bedding of the tile. Spread as much mortar as can be covered with tile in 15-20 minutes. Back butter large tiles > 8"x8" (>300mm x 300mm) to provide full bedding and firm support. Place tiles into wet, sticky mortar and beat in using a beating block and rubber mallet to imbed tile and adjust level. Check mortar for complete coverage by periodically removing a tile and inspecting bedding mortar transfer onto back of tile. If mortar is skinned over (not sticky), remove and replace with fresh mortar.

### Cleaning

Clean tools and tile work with water while mortar is fresh.

## AVAILABILITY AND COST

### Availability

LATICRETE and LATAPOXY materials are available worldwide. For distributor information, call:

**Telephone:** (65) 6515-3028

**Fax:** (65) 6515-3037

For on-line distributor information, visit LATICRETE at [se.laticrete.com](http://se.laticrete.com)

### Cost

Contact a LATICRETE Distributor in your area.

## WARRANTY

LATICRETE South East Asia Pte Ltd warrants that 328R Rapid Flexible Adhesive is free from manufacturing defects and will not break down, deteriorate or disintegrate under normal usage for a period of one (1) year from date of purchase subject to terms and conditions stated.

## MAINTENANCE

LATICRETE and LATAPOXY grouts require routine cleaning with a neutral pH soap and water. All other LATICRETE and LATAPOXY materials require no maintenance but installation performance and durability may depend on properly maintaining products supplied by other manufacturers.

## TECHNICAL SERVICES/ CONTACT

### Technical Assistance

Information is available by calling:

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(Level 2, A3)

Singapore 729245

Telephone: (65) 6515-3028

Fax: (65) 6515-3037

Email: [enquiry@laticrete.com.sg](mailto:enquiry@laticrete.com.sg)

### Technical and safety literature

To acquire technical and safety literature, please visit our website at [se.laticrete.com](http://se.laticrete.com)

### Disclaimer

LATICRETE is not responsible for product use beyond its intended application. Liability is limited to replacing defective materials. We are not responsible for any loss or damage resulting from improper use. Product specifications are subject to change without notice. For the most up-to-date information, please visit our website at [se.laticrete.com](http://se.laticrete.com).